**Andy’caster Feeds and Speeds**

**Body Front and Back**

**Index Holes**

0.25" Down Cut

Pass Depth .02"

Step Over 0.0625 (8%)

Spindle Speed 18000

Feed Rate 50

Plunge Rate 50

**Roughing pass**

.25" Ball Nose

Pass Depth .15"

Step Over .125" (50%)

Spindle Speed 19000

Feed Rate 120

Plunge Rate 75

**Finishing pass:**

.125" Ball Nose

Step Over .01" (8%)

Spindle Speed 18000

Feed Rate 100

Plunge Rate 50

**Body Back**

**Profile Cutout**

.25" Down Cut

Pass Depth 0.125"

Step Over .02" (8%)

Spindle Speed 18000

Feed Rate 80

Plunge Rate 40

**Ferrule Holes**

.125" Down Cut

Pass Depth .045"

Step Over .05" (40%)

Spindle Speed 18000

Feed Rate 60

Plunge Rate 15

**Neck Plate/Holes**

.125" Down Cut

Pass Depth .045"

Step Over .05" (40%)

Spindle Speed 18000

Feed Rate 60

Plunge Rate 15

**Neck Front and Back**

**Index Holes**

0.25" Down Cut

Pass Depth .02"

Step Over 0.0625 (8%)

Spindle Speed 18000

Feed Rate 50

Plunge Rate 50

**Roughing pass**

.25" Ball Nose

Pass Depth .15"

Step Over .125" (50%)

Spindle Speed 19000

Feed Rate 120

Plunge Rate 75

**Finishing Pass**

.125" Ball Nose

Step Over .01" (8%)

Spindle Speed 18000

Feed Rate 100

Plunge Rate 50

**Neck Back**

**Tuner Key Holes/Neck Profile Cutout Paths**

0.125" Down Cut

Pass Depth .0625"

Step Over 0.05 (40%)

Spindle Speed 18000

Feed Rate 100

Plunge Rate 50

**Fretboard**

**Marker Dots**

0.0625" Down Cut

Pass Depth .02"

Step Over 0.0625 (100%)

Spindle Speed 18000

Feed Rate 50

Plunge Rate 20

**Finish Pass**

0.25" Ball Nose

Step Over 0.015 (6%)

Spindle Speed 18000

Feed Rate 80

Plunge Rate 40

**Fret Slots**

0.024" Down Cut

Pass Depth .01”

Step Over 0.0096 (40%)

Spindle Speed 18000

Feed Rate 20

Plunge Rate 15

**Profile Cutout**

0.25" Down Cut

Pass Depth 0.125”

Step Over 0.1 (40%)

Spindle Speed 18000

Feed Rate 100

Plunge Rate 50

**Pickguard**

**90vbit Toolpath - Profile not V-carve**

90 degree Vbit

Pass Depth .0625”

Step Over - doesn’t matter

Spindle Speed 18000

Feed Rate 50

Plunge Rate 15

**Screw Holes - V-Carve Toolpath**

90 degree Vbit

Pass Depth .0625”

Step Over - doesn’t matter

Spindle Speed 18000

Feed Rate 50

Plunge Rate 15

**Profile Toolpaths**

0.25” Down Cut

Pass Depth .0625”

Step Over - doesn’t matter

Spindle Speed 18000

Feed Rate 50

Plunge Rate 15