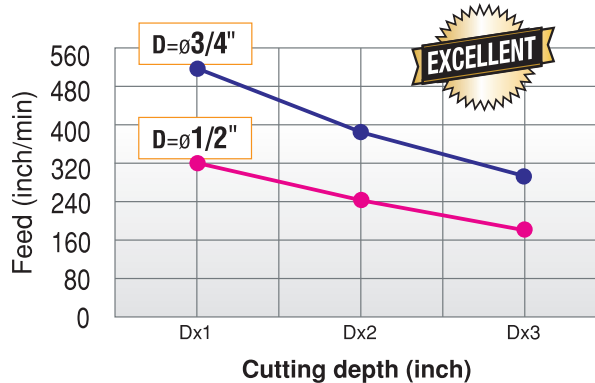
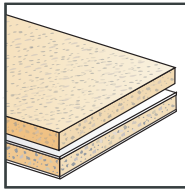


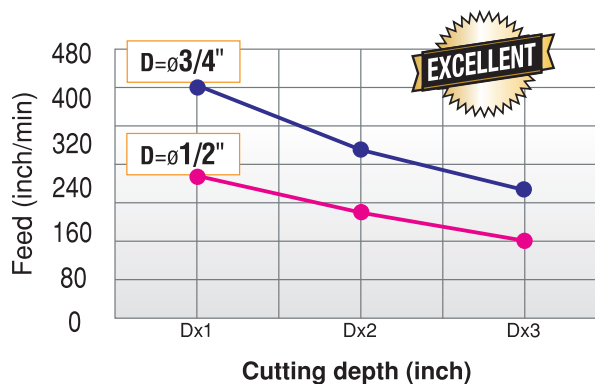
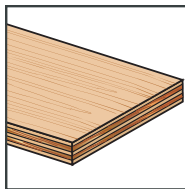
Feed Rates - Solid Carbide Spiral 2-Flute Plunge for MDF/Laminate

INDUSTRIAL

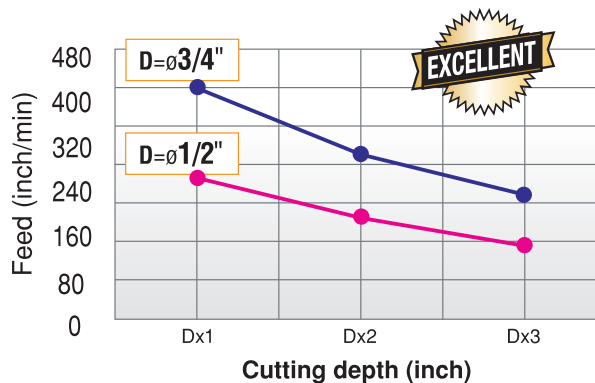
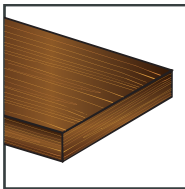
Particle Board
Laminate



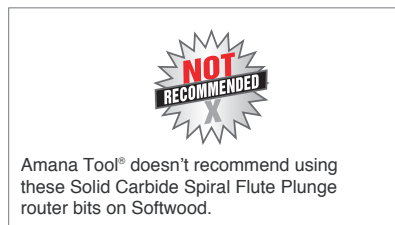
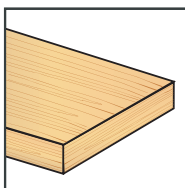
Plywood
Veneered Plywood



Hardwood



Softwood



Tool Reference #'s		
Up-Cut	Down-Cut	Dia.
46100	46200	1/8"
46101	46201	3/16"
46102	46202	1/4"
46103	46203	3/8"
46104	46204	3/8"
46106	46206	1/2"
46107	46207	1/2"
46108	46208	5/8"
46117	46217	9/32"
46119	46219	5/16"
46121	—	5/8"
46125	46225	1/8"
46127	46227	1/8"
—	46229	1/32"
—	46231	3/64"
—	46237	1/16"
—	46239	3/32"
46310	46410	5/32"
46314	46414	7/32"
46315	46415	1/4"
46316	46416	1/4"
46317	46417	9/32"
46318	—	5/16"
46320	46420	3/8"
46321	46421	1/4"
46323	46423	3/8"
46329	—	3/8"

Math For Routers:

To find **Chip Load** = Feed Rate / RPM of spindle x # of cutting edges

To find **Feed Rate** = RPM x # of cutting edges x Chip Load

To find **RPM** = Feed Rate / (Chip Load x # of cutting edges)

Recommended Feed Rate

Because of the dependency which we have between the cutting conditions and the non-uniformity of the wood pieces, it is important to understand that these values are only recommendations. Wood fiber direction, wood type, wood humidity, clamping stiffness, machine stiffness, etc., all these variables together or one by one can change the cutting condition. It is recommended that in any new application, you reach the recommended feed rate gradually and if the cutting quality is OK, you can continue to increase the feed rate values. Please remember, the larger your chip per tip (high feed rate), the lifetime of the tool is increased.