

2 Flute CNC Compression Spiral Flute for Solid Wood with Diamond-Like Carbon (DLC) Coating

Depth of Cut: 1 x Tool Diameter †

| Material | 1/4" | | 3/8" | | 1/2" | |
|----------|---------|---------------------|---------|---------------------|---------|---------------------|
| | Max RPM | Chip Load Per Tooth | Max RPM | Chip Load Per Tooth | Max RPM | Chip Load Per Tooth |
| Softwood | 24000 | 0.015" - 0.017" | 24000 | 0.017" - 0.019" | 24000 | 0.019" - 0.021" |
| Hardwood | 24000 | 0.014" - 0.016" | 24000 | 0.016" - 0.018" | 24000 | 0.018" - 0.021" |
| MDF | 24000 | 0.013" - 0.015" | 18000 | 0.014" - 0.016" | 15000 | 0.016" - 0.018" |

| Tool Reference #s | Dia. |
|-------------------|------|
| 46170-DLC | 1/4" |
| 46172-DLC | 3/8" |
| 46188-DLC | 1/2" |

† **Depth of Cut:** 1 x D Use recommended feed rate
 2 x D Reduce feed rate by 25%
 3 x D Reduce feed rate by 50%

Simple Machining Calculations:

To find **RPM:** (SFM x 3.82) / diameter of tool

To find **SFM:** 0.262 x diameter of tool x RPM

To find **Feed Rate IPM:** RPM x # of flutes x chip load

To find **Chip Load:** Feed Rate IPM* / (RPM x # of flutes)

To find **Ramp Down:** Feed Rate IPM* / # of flutes

* **IPM** Inches per minute