

Carbide Tipped Bowl, Tray, Core Box Router Bits

CNC Operating Spindle Speed: 18,000 RPM / Depth of Cut: 1 x Tool Diameter †

Tool No.	Diameter	Shank	Flute	Softwood	Hardwood	MDF	Plywood
				IPM* / Chip Load Per Tooth	IPM* / Chip Load Per Tooth	IPM* / Chip Load Per Tooth	IPM* / Chip Load Per Tooth
45982	3/4"	1/4"	2	180" / 0.0050"	80" / 0.0023"	160" / 0.0046"	100" / 0.0027"
45924	1"	1/4"	2	60" / 0.0017"	30" / 0.0008"	60" / 0.0016"	30" / 0.0009"

*IPM: Inches Per Minute

Depth of Cut: 1 x D Use recommended chip load
 2 x D Reduce chip load by 25%
 3 x D Reduce chip load 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

Disclaimer: It is important to understand that these values are only recommendations.