

## 2 Flute Carbide Tipped Mortising Router Bits

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

Tool No.	Diameter	Softwood			Hardwood			MDF			Plywood		
		Feed Rate IPM *	Chip Load Per Tooth	Ramp Down	Feed Rate IPM *	Chip Load Per Tooth	Ramp Down	Feed Rate IPM *	Chip Load Per Tooth	Ramp Down	Feed Rate IPM *	Chip Load Per Tooth	Ramp Down
45576	3/4"	290"	.0079"	145"	120"	.0033"	60"	240"	.0066"	120"	140"	.0040"	70"
45580	1-1/4"	150"	.0043"	75"	60"	.0018"	30"	130"	.0036"	65"	80"	.0022"	40"

\* **IPM:** Inches Per Minute

† **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

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

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