

2 Flute Foam Cutting Straight V Flute High Speed Steel (HSS) Router Bits

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

Tool No.	Foam / Natural Wood	
	Feed Rate IPM*	Chip Load Per Tooth
HSS1610	110" - 180"	0.003" - 0.005"
HSS1611	110" - 180"	0.003" - 0.005"
HSS1611-M	110" - 180"	0.003" - 0.005"
HSS1612	110" - 180"	0.003" - 0.005"
HSS1613	150" - 220"	0.004" - 0.006"
HSS1614	180" - 250"	0.005" - 0.007"

* 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