

In-Presta™ 3 Flute Solid Carbide Cutting Edge Straight Plunge High Production Router Bits
CNC Operating Spindle Speed: 18,000 RPM / Ramp Down: 50%

Tool No.	Diameter	Shank	Particle Board, MDF & Melamine IPM* / Chip Load Per Tooth	Plywood IPM* / Chip Load Per Tooth
45408-3	1/4"	1/2"	800" / 0.014"	500" / 0.009"
45185-M	6mm	12mm	800" / 0.014"	500" / 0.009"
45186-3	5/16"	1/2"	600" / 0.0108"	340" / 0.0064"

*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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