



### 1 & 2 Flute Polycrystalline Diamond (PCD) CNC Straight Plunge Router Bit

Operating RPM: 18,000 / Depth of Cut: 1 x Tool Diameter

Tool No.	Diameter	No. Teeth	MDF		Chipboard		Wood		Aluminum	
			Feed Rate IPM*	Chip Load Per Tooth	Feed Rate IPM*	Chip Load Per Tooth	Feed Rate IPM*	Chip Load Per Tooth	Feed Rate IPM*	Chip Load Per Tooth
DRB-421	1/4" (6.35mm)	1	100"	.005"	110"	.006"	120"	.003"	120"	.007"
DRB-422	3/8" (9.5mm)	1	100"	.005"	110"	.006"	120"	.003"	120"	.007"
DRB-423	1/2" (12.7mm)	2	100"	.003"	110"	.003"	200"	.006"	200"	.006"

\* 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)