2 Flute Polycrystalline Diamond (PCD) CNC Straight Plunge Router Bit
Operating RPM: 12,000 / **Depth of Cut:** 1 x Tool Diameter

Tool No.	Diameter Inch/mm	No. Teeth	Chip Load Per Tooth Inch (mm)/min	RPM	Feed Rate Inch (mm)/min
DRB-420	1/4" (6.35mm)	2	.004" (0.10mm)	12,000	100" (2,500mm)
DRB-424	1/2" (12.7mm)	2	.004" (0.10mm)	12,000	100" (2,500mm)

Multipliers for different materials:
0.8% = MDF with or without Coating
1.1% = Chipboard with or without Coating
0.7% = Cross grain veneer

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)