

2 Flute Carbide Tipped Plunge Beading Router Bits
CNC Operating Spindle Speed: 18,000 RPM / Depth of Cut: 1 x Tool Diameter †

Tool No.	Flutes	Diameter	Shank	Softwood		Hardwood		MDF		Plywood	
				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
56100	2	25/64"	1/4"	280"	0.0079"	120"	0.0033"	240"	0.0066"	140"	0.0040"
56170	2	1/2"	1/4"	280"	0.0079"	120"	0.0033"	240"	0.0066"	140"	0.0040"
56178	2	1-1/8"	1/2"	70"	0.0020"	30"	0.0008"	60"	0.0017"	40"	0.0010"

*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.