

## Solid Carbide Compression Spiral Router Bits For Nesting

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

### 3 Flute

Diameter	Wood			MDF			Plywood			Plastic		
	Feed Rate IPM *	Chip Load Per Tooth	Ramp Down	Feed Rate IPM *	Chip Load Per Tooth	Ramp Down	Feed Rate IPM *	Chip Load Per Tooth	Ramp Down	Feed Rate IPM *	Chip Load Per Tooth	Ramp Down
1/4"	200"	.0037"	67"	400"	.0074"	133"	200"	.0037"	67"	200"	.0037"	67"
3/8"	300"	.0056"	100"	400"	.0074"	133"	300"	.0056"	100"	300"	.0056"	100"
1/2"	350"	.0065"	117"	450"	.0080"	150"	350"	.0065"	117"	350"	.0065"	117"

Tool Reference #'s	
3 Flute	Dia.
46370	1/4"
46371	3/8"
46372	1/2"

\***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.