

1 Flute

Tool No.	Diameter	MDF/HDF			Laminate			Melamine			Veneered Plywood			Wood			Oriented Strand Board (OSB)		
		* Feed Rate	Chip Load Per Tooth	* Ramp Down	* Feed Rate	Chip Load Per Tooth	* Ramp Down	* Feed Rate	Chip Load Per Tooth	* Ramp Down	* Feed Rate	Chip Load Per Tooth	* Ramp Down	* Feed Rate	Chip Load Per Tooth	* Ramp Down	* Feed Rate	Chip Load Per Tooth	* Ramp Down
46137	1/8"	40	.0021"	20	40	.0021"	20	40	.0021"	20	20	.0011"	10	20	.0011"	10	40	.0021"	20
46139	1/8"	40	.0021"	20	40	.0021"	20	40	.0021"	20	20	.0011"	10	20	.0011"	10	40	.0021"	20
46140	1/4"	40	.0021"	20	40	.0021"	20	40	.0021"	20	20	.0011"	10	20	.0011"	10	40	.0021"	20
46159	1/2"	180	.0096"	90	180	.0096"	90	180	.0096"	90	90	.0048"	45	90	.0048"	45	180	.0096"	90
46160	1/2"	180	.0096"	90	180	.0096"	90	180	.0096"	90	90	.0048"	45	90	.0048"	45	180	.0096"	90

2 Flute

46180	1/8"	40	.0011"	20	40	.0011"	20	40	.0011"	20	20	.0005"	10	20	.0005"	10	40	.0011"	20
46183	5/32"	40	.0011"	20	40	.0011"	20	40	.0011"	20	20	.0006"	10	20	.0006"	10	40	.0011"	20
46181	3/16"	60	.0016"	30	60	.0016"	30	60	.0016"	30	30	.0008"	15	30	.0008"	15	60	.0016"	30
46170	1/4"	80	.0021"	40	80	.0021"	40	80	.0021"	40	40	.0010"	20	40	.0010"	20	80	.0021"	40
46171	3/8"	260	.0072"	130	260	.0072"	130	260	.0072"	130	130	.0036"	65	130	.0036"	65	260	.0072"	130
46173	3/8"	260	.0072"	130	260	.0072"	130	260	.0072"	130	130	.0036"	65	130	.0036"	65	260	.0072"	130
46172	3/8"	260	.0072"	130	260	.0072"	130	260	.0072"	130	130	.0036"	65	130	.0036"	65	260	.0072"	130
46174	3/8"	260	.0072"	130	260	.0072"	130	260	.0072"	130	130	.0036"	65	130	.0036"	65	260	.0072"	130
46178	3/8"	260	.0072"	130	260	.0072"	130	260	.0072"	130	130	.0036"	65	130	.0036"	65	260	.0072"	130
46182	1/2"	350	.0096"	175	350	.0096"	175	350	.0096"	175	170	.0048"	85	170	.0048"	85	350	.0096"	175
46186	1/2"	350	.0096"	175	350	.0096"	175	350	.0096"	175	170	.0048"	85	170	.0048"	85	350	.0096"	175
46188	1/2"	350	.0096"	175	350	.0096"	175	350	.0096"	175	170	.0048"	85	170	.0048"	85	350	.0096"	175
46189	1/2"	350	.0096"	175	350	.0096"	175	350	.0096"	175	170	.0048"	85	170	.0048"	85	350	.0096"	175
46191	1/2"	350	.0096"	175	350	.0096"	175	350	.0096"	175	170	.0048"	85	170	.0048"	85	350	.0096"	175
46190	1/2"	350	.0096"	175	350	.0096"	175	350	.0096"	175	170	.0048"	85	170	.0048"	85	350	.0096"	175

3 Flute

46011	3/8"	400	.0075"	200	400	.0075"	200	400	.0075"	200	200	.0036"	100	200	.0036"	100	400	.0075"	200
46010	3/8"	400	.0075"	200	400	.0075"	200	400	.0075"	200	200	.0036"	100	200	.0036"	100	400	.0075"	200
46013	1/2"	520	.0096"	260	520	.0096"	260	520	.0096"	260	270	.0049"	135	270	.0049"	135	520	.0096"	260
46012	1/2"	520	.0096"	260	520	.0096"	260	520	.0096"	260	270	.0049"	135	270	.0049"	135	520	.0096"	260
46014	1/2"	520	.0096"	260	520	.0096"	260	520	.0096"	260	270	.0049"	135	270	.0049"	135	520	.0096"	260

*IPM: Inches Per Minute

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 / 2