



2 Flute Solid Carbide Spektra™ Extreme Tool Life Coated Spiral Plunge with Corner Radius Router Bit
 CNC Operating Spindle Speed: 18,000 RPM / Depth of Cut: 1 x Tool Diameter †

Diameter	Soft Wood		Hard Wood		MDF		Hard / Soft Plastics	
	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
2 Flute								
1/4" (0.25)	250" - 320"	0.007" - 0.009"	180" - 250"	0.005" - 0.007"	210" - 290"	0.006" - 0.008"	150" - 210"	0.004" - 0.006"
5/16" (0.3125)	260" - 300"	0.007" - 0.008"	190" - 260"	0.005" - 0.007"	260" - 300"	0.007" - 0.008"	180" - 220"	0.005" - 0.006"

Tool Reference #'s		
Up-Cut	Down-Cut	Dia.
2 Flute	2 Flute	
43742-K	43752-K	5/16"
46460-K	—	1/4"

*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.