



**Solid Carbide Spektra™ Extreme Tool Life Coated Compression Spiral Router Bits
For Baltic Plywood**

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

2 Flute

Axial Depth Of Cut	(1/8" Dia.)		(1/4" Dia.)		(3/8" Dia.)		(1/2" Dia.)	
	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
1 x Diameter	145"	.0040"	150" - 180"	.004" - .005"	180" - 200"	.005" - .006"	200" - 220"	.006" - .0065"

*IPM: Inches Per Minute

3 Flute

Axial Depth Of Cut	(1/4" Dia.)		(3/8" Dia.)		(1/2" Dia.)	
	Feed Rate IPM *	Chip Load Per Tooth	Feed Rate IPM *	Chip Load Per Tooth	Feed Rate IPM*	Chip Load Per Tooth
1 x Diameter	270"	.0050"	330"	.009"	350"	.0065"

*IPM: Inches Per Minute

Item #	Dia.
46701-K	1/8
46700-K	1/4
46702-K	3/8
46704-K	
46706-K	1/2
46708-K	1/2
46709-K	3/8
46710-K	1/2

† **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.

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