



2 Flute Solid Carbide Spektra™ Extreme Tool Life Coated Mortise Compression Spiral Router Bits For Baltic Birch Plywood

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

Axial Depth Of Cut	46712-K (1/4" Dia.)		46711-K (3/8" Dia.)		46714-K (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	150" - 180"	.004" - .005"	200"	.0056"	280"	.0077"

*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.

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