

2 Flute Solid Carbide Spiral Plunge for Solid Wood with Diamond-Like Carbon (DLC) Coating

Depth of Cut: 1 x Tool Diameter †

Material	1/8"		1/4"		3/8"		1/2"	
	Max RPM	Chip Load Per Tooth	Max RPM	Chip Load Per Tooth	Max RPM	Chip Load Per Tooth	Max RPM	Chip Load Per Tooth
Softwood	24000	0.006" - 0.008"	24000	0.007" - 0.009"	24000	0.008" - 0.010"	24000	0.009" - 0.011"
Hardwood	24000	0.003" - 0.005"	24000	0.005" - 0.007"	24000	0.006" - 0.008"	24000	0.007" - 0.009"
MDF	24000	0.005" - 0.007"	24000	0.006" - 0.008"	18000	0.007" - 0.009"	15000	0.008" - 0.010"

Tool Reference #'s		
Up-Cut	Down-Cut	Dia.
46100-DLC	46200-DLC	1/8"
48122-DLC	48213-DLC	1/8"
46102-DLC	46202-DLC	1/4"
46320-DLC	46420-DLC	3/8"
46210-DLC	46447-DLC	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

* **IPM** Inches per minute