



2 Flute Solid Carbide Spektra™ Extreme Tool Life Coated V-Groove Engraving 15
CNC Operating Spindle Speed: 18,000 RPM / Depth of Cut: 1 x Tool Diameter

° Degree Router Bits

Material	15°	
	Feed Rate IPM*	Chip Load Per Tooth IPR**
Soft Wood	50" - 125"	0.003" - 0.007"
Hard Wood	50" - 125"	0.003" - 0.007"
Soft Plastic	50" - 125"	0.003" - 0.007"
Hard Plastic	50" - 125"	0.003" - 0.007"
Solid Surface	50" - 125"	0.003" - 0.007"

Tool Reference #'s
15°
45780-K
45628-K

IPM* Inches per minute
IPR** Inches per revolution

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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