



**2 Flute Solid Carbide Spektra™ Extreme Tool Life Coated
Foam Cutting Spiral Router Bits**
CNC Operating Spindle Speed: 18,000 RPM / Depth of Cut: 1 x Tool Diameter †



Material	Diameter			
	Ø1/8" (0.125) / 3mm		Ø1/4" (0.250) / 6mm	
	Feed Rate IPM**	Chip Load Per Tooth	Feed Rate IPM**	Chip Load Per Tooth
Foam	100" - 140"	0.002" - 0.004"	140" - 210"	0.004" - 0.006"

Tool Reference #'s		
Up-Cut	Down-Cut	Dia.
46269-K	—	1/8"
46270-K	46564-K	1/8"
46272-K	46566-K	1/4"
48442-K	—	3mm
48444-K	—	6mm

*SFM Surface feet per minute

**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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