



**3 Flute Up-Cut Solid Carbide Spektra™ Extreme Tool Life Coated Spiral Phenolic, Resin and Composite with Chipbreaker
CNC Router Bits
Depth of Cut: 1 x Tool Diameter †**

Material	Diameter	Operating RPM	Chip Load Per Tooth
Phenolic (Fiberglass, linen, wood, others)	1/4"	8,000 - 16,000	0.002" - 0.010"
	3/8"	6,000 - 10,000	0.002" - 0.010"
	1/2"	4,000 - 8,000	0.002" - 0.010"

Tool Reference #'s	
46150-K	1/4" Dia.
46151-K	3/8" Dia.
46153-K	1/2" Dia.

† **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.