



**Solid Carbide Spektra™ Extreme Tool Life Coated Plastic Cutting Spiral  
Single ‘O’ Flute Router Bits**  
Operating RPM: 18,000 / Depth of Cut: 1 x Tool Diameter †

<b>Diameter</b>	<b>Feed Rate IPM*</b>	<b>Chip Load Per Tooth</b>	<b>Ramp Down</b>
Single Flute			

<b>1/8" (0.125)</b>	50"	0.003"	50"
<b>3/16" (0.1875)</b>	60"	0.003"	60"

Tool Reference #'s		
Tool No.	Flutes	Dia.
43500-K	1	1/8"
43504-K	1	3/16"
43505-K	1	3/16"

\*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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