

**Insert Carbide 2+2 Spoilboard Surfacing, Rabbeting,  
Flycutter, Leveler & Surface Planer Router Bits**

<b>Tool No.</b>	<b>Plywood/Chipboard RPM / IPM* / Chip Load Per Tooth</b>	<b>Hardwood RPM / IPM* / Chip Load Per Tooth</b>	<b>MDF RPM / IPM* / Chip Load Per Tooth</b>	<b>Softwood RPM / IPM* / Chip Load Per Tooth</b>	<b>Plastic RPM / IPM* / Chip Load Per Tooth</b>
<b>RC-2251</b>	18,000 / 130" / 0.0038"	18,000 / 110" / 0.0031"	18,000 / 220" / 0.0062"	18,000 / 270" / 0.0075"	18,000 / 120" / 0.0031"
<b>RC-2252</b>	14,300 / 100" / 0.0037"	14,300 / 100" / 0.0037"	14,300 / 180" / 0.0062"	14,300 / 210" / 0.0075"	14,300 / 100" / 0.0050"

**⚠ Warning: Max Cutting Depth Per Pass 1/4"**

\*IPM: Inches Per Minute

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**: RPM x # of flutes x chip load

To find **Chip Load**: IPM / (RPM x # of Flutes)

**Depth of Cut:** 1 x D Use recommended chip load

2 x D Reduce chip load by 25%

3 x D Reduce chip load by 50%