



## High Speed Steel (HSS) TiN Coated Steel Door Bit

Material	Spindle Speed	Feed Rate IPM
	RPM	HSS1702TIN / HSS1705TIN 1/2" (0.500)

Metal Door Foam Core, Fiberglass Door	2,000 - 2,500	100" - 200"
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Tool #'s	Door Machine
HSS1702TIN	RUVO
HSS1705TIN	NORFIELD

### Simple Machining Calculations:

To find **RPM**:  $(\text{SFM} \times 3.82) / \text{diameter of tool}$

To find **SFM**:  $0.262 \times \text{diameter of tool} \times \text{RPM}$

To find **Feed Rate IPM**:  $\text{RPM} \times \# \text{ of flutes} \times \text{chip load}$

To find **Chip Load**:  $\text{Feed Rate IPM} / (\text{RPM} \times \# \text{ of Flutes})$

**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%