



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

Diameter	Softwood/Hardwood	
	Feed Rate IPM*	Chip Load Per Tooth
2 Flute		
1/8" (0.125)	100" - 180"	0.003" - 0.005"
1/4" (0.25)	145" - 200"	0.004" - 0.006"

Tool Reference #'s		
Up-Cut	Down-Cut	Dia.
2 Flute		
46241-K	46341-K	1/8"
46248-K	46348-K	1/4"

* 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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