

**Solid Carbide Compression Spiral For Solid Wood Router Bits**  
 CNC Operating Spindle Speed: 18,000 RPM / Depth of Cut: 1 x Tool Diameter †

**1 Flute**

Diameter	Wood		
	Feed Rate IPM *	Chip Load Per Tooth	Ramp Down
1/4"	60"	.0031"	60"
3/8"	200"	.0056"	100"
1/2"	140"	.0077"	140"

**2 Flute**

Diameter	Wood		
	Feed Rate IPM *	Chip Load Per Tooth	Ramp Down
1/2"	280"	.0077"	140"

Tool Reference #'s	
1 Flute	Dia.
46322	1/4"
46324	3/8"
46326	1/2"
46328	1/2"
46390	1/4"
46392	3/8"
2 Flute	Dia.
46344	1/2"

**\*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.