



**Carbide Tipped Core Box Router Bit**  
CNC Operating Spindle Speed: 18,000 RPM / Depth of Cut: .25"

Tool No.	Diameter	Flute	Plywood		Softwood		Hardwood	
			Feed Rate IPM*	Plunge Rate IPM*	Feed Rate IPM*	Plunge Rate IPM*	Feed Rate IPM*	Plunge Rate IPM*
1/4" Shank 45924	1"	2	40"	20"	60"	30"	30"	15"

\*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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