

### Double Edge 'V' Grooving AlTiN Coated Router Bits with Flat Bottom for SCM Materials

Material	Spindle Speed SFM**	Chip Load Per Tooth				
		Depth of Cut				
		< 1/8" (< 3mm)	1/8"-3/16" (3mm-5mm)	3/16"-5/16" (5mm-8mm)	5/16"-9/16" (8mm-14mm)	9/16"-23/32" (14mm-18mm)
Stainless Steel, Steel, DuraPlate®	164 - 295	0.0003" - 0.0005"	0.0004" - 0.001"	0.001" - 0.002"	0.002" - 0.003"	0.003" - 0.004"

**SFM\*\*** Surface feet per minute

Simple Machining Calculations:

To find **RPM**:  $SFM \times 3.82 / \text{diameter of tool (diameter of flat bottom of tool D1)}$

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

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

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

**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%