



**Insert Carbide 3 & 5 Wing Heavy Duty Spoilboard Surfacing,
Planing & Chamfering Router Bits
(Max Cutting Depth Per Pass 1/4")**

Feed and Speed based on 1/8" Cutting Depth Per Pass

Tool No.	Shank	Wings	Plywood/Chipboard	Hardwood	MDF	Softwood	Plastic
			RPM* / IPM** / Chip Load Per Tooth	RPM* / IPM** / Chip Load Per Tooth	RPM* / IPM** / Chip Load Per Tooth	RPM* / IPM** / Chip Load Per Tooth	RPM* / IPM** / Chip Load Per Tooth
RC-2255	1/2"	3-Wing	18,000 / 350" / 0.007"	18,000 / 300" / 0.006"	14,000 / 500" / 0.012"	12,000 / 500" / 0.014"	14,000 / 400" / 0.009"
RC-2261	1/2"	3-Wing	18,000 / 350" / 0.007"	18,000 / 300" / 0.006"	14,000 / 500" / 0.012"	12,000 / 500" / 0.014"	14,000 / 400" / 0.009"
RC-2263	1/2"	3-Wing	18,000 / 350" / 0.007"	18,000 / 300" / 0.006"	14,000 / 500" / 0.012"	12,000 / 500" / 0.014"	14,000 / 400" / 0.009"
RC-2265	1/4"	3-Wing	18,000 / 350" / 0.007"	18,000 / 300" / 0.006"	14,000 / 500" / 0.012"	12,000 / 500" / 0.014"	14,000 / 400" / 0.009"
RC-2259	3/4"	5-Wing	12,000 / 450" / 0.008"	12,000 / 400" / 0.006"	12,000 / 600" / 0.010"	12,000 / 600" / 0.010"	9,000 / 500" / 0.010"

*RPM: Revolutions Per Minute

**IPM: Inches Per Minute

Feed and Speed based on 1/4" Cutting Depth Per Pass

Tool No.	Shank	Wings	Plywood/Chipboard	Hardwood	MDF	Softwood	Plastic
			RPM* / IPM** / Chip Load Per Tooth	RPM* / IPM** / Chip Load Per Tooth	RPM* / IPM** / Chip Load Per Tooth	RPM* / IPM** / Chip Load Per Tooth	RPM* / IPM** / Chip Load Per Tooth
RC-2255	1/2"	3-Wing	18,000 / 190" / 0.004"	18,000 / 150" / 0.003"	18,000 / 300" / 0.006"	18,000 / 350" / 0.007"	18,000 / 200" / 0.005"
RC-2261	1/2"	3-Wing	18,000 / 190" / 0.004"	18,000 / 150" / 0.003"	18,000 / 300" / 0.006"	18,000 / 350" / 0.007"	18,000 / 200" / 0.005"
RC-2263	1/2"	3-Wing	18,000 / 190" / 0.004"	18,000 / 150" / 0.003"	18,000 / 300" / 0.006"	18,000 / 350" / 0.007"	18,000 / 200" / 0.005"
RC-2265	1/4"	3-Wing	18,000 / 190" / 0.004"	18,000 / 150" / 0.003"	18,000 / 300" / 0.006"	18,000 / 350" / 0.007"	18,000 / 200" / 0.005"
RC-2259	3/4"	5-Wing	12,000 / 250" / 0.004"	12,000 / 200" / 0.003"	12,000 / 400" / 0.006"	12,000 / 500" / 0.008"	9,000 / 200" / 0.005"

*RPM: Revolutions Per Minute

**IPM: Inches Per Minute

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