



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

Operating RPM: 18,000

Material	Spindle Speed SFM*	Chip Load Per Tooth Based On 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® Steel Composite Material (SCM) Titanium Composite Material (TCM)	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 x 3.82) / diameter of tool (diameter of flat bottom of tool D1)

To find **SFM**: 0.262 x diameter of tool x RPM

To find **Feed Rate**: RPM x # of flutes x chip load

To find **Chip Load**: IPM / (RPM x # 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%

Tool Reference #'s	Angle
45762	90°
45778	90°
45749	108°

Disclaimer: These values are based on test results using 18,000 RPM. Your results may vary. It is important to understand that these values are only recommendations.