

Solid Carbide Mortise Compression Spirals Single, 2, 3 & 4 Flute Router Bits

Operating RPM: 18,000

1 Flute

Tool No.	Diameter	MDF/HDF			Laminate			Melamine			Veneered Plywood			Wood			Oriented Strand Board (OSB)		
		* Feed Rate	Chip Load Per Tooth	* Ramp Down	* Feed Rate	Chip Load Per Tooth	* Ramp Down	* Feed Rate	Chip Load Per Tooth	* Ramp Down	* Feed Rate	Chip Load Per Tooth	* Ramp Down	* Feed Rate	Chip Load Per Tooth	* Ramp Down	* Feed Rate	Chip Load Per Tooth	* Ramp Down
46393	1/4"	40	.0021"	20	40	.0021"	20	40	.0021"	20	20	.0011"	10	20	.0011"	10	40	.0021"	20
46397	1/2"	180	.0096"	90	180	.0096"	90	180	.0096"	90	90	.0048"	45	90	.0048"	45	180	.0096"	90

2 Flute

46350	1/4"	80	.0021"	40	80	.0021"	40	80	.0021"	40	40	.0010"	20	40	.0010"	20	80	.0021"	40
46367	3/8"	260	.0072"	130	260	.0072"	130	260	.0072"	130	130	.0036"	65	130	.0036"	65	260	.0072"	130
46352	3/8"	260	.0072"	130	260	.0072"	130	260	.0072"	130	130	.0036"	65	130	.0036"	65	260	.0072"	130
46354	1/2"	350	.0096"	175	350	.0096"	175	350	.0096"	175	170	.0048"	85	170	.0048"	85	350	.0096"	175
46356	1/2"	350	.0096"	175	350	.0096"	175	350	.0096"	175	170	.0048"	85	170	.0048"	85	350	.0096"	175
46360	1/2"	350	.0096"	175	350	.0096"	175	350	.0096"	175	170	.0048"	85	170	.0048"	85	350	.0096"	175

3 Flute

46020	3/8"	400	.0075"	200	400	.0075"	200	400	.0075"	200	200	.0036"	100	200	.0036"	100	400	.0075"	200
46022	1/2"	520	.0096"	260	520	.0096"	260	520	.0096"	260	270	.0049"	135	270	.0049"	135	520	.0096"	260
46024	1/2"	520	.0096"	260	520	.0096"	260	520	.0096"	260	270	.0049"	135	270	.0049"	135	520	.0096"	260

4 Flute

46026	1/2"	600	.0082"	300	600	.0082"	300	600	.0082"	300	350	.0049"	175	350	.0049"	175	600	.0082"	300
46028	1/2"	600	.0082"	300	600	.0082"	300	600	.0082"	300	350	.0049"	175	350	.0049"	175	600	.0082"	300

* **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 / 2