



Solid Carbide Spiral Flute Finishing With Chip Breaker
3 Flute Router Bits
Operating RPM: 18,000

(Chip Load Per Tooth)

Diameter	Wood
1/2" (0.50)	0.020" - 0.022"
5/8" (0.625)	0.022" - 0.024"
3/4" (0.75)	0.024" - 0.026"

Tool Reference #'s		
Up-Cut	Down-Cut	Dia.
46132	46232	1/2"
46134	46234	1/2"
46136	46236	5/8"
46138	46238	3/4"

Simple Machining Calculations:

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

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%

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.