

**Insert Carbide 2-Wing Spoilboard Surfacing, Rabbeting,
Flycutter, Slab Leveler & Surface Planer Router Bits**
(Max Cutting Depth Per Pass 1/4")

Tool No.	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-2243	18,000 / 80" / 0.0023"	18,000 / 70" / 0.0019"	18,000 / 140" / 0.0038"	18,000 / 170" / 0.0046"	18,000 / 110" / 0.0031"
RC-2245	18,000 / 110" / 0.0032"	18,000 / 100" / 0.0026"	18,000 / 190" / 0.0053"	18,000 / 220" / 0.0063"	17,200 / 150" / 0.0042"
RC-2254	18,000 / 150" / 0.0043"	18,000 / 130" / 0.0036"	18,000 / 260" / 0.0071"	18,000 / 300" / 0.0086"	18,000 / 200" / 0.0057"
RC-2256	18,000 / 110" / 0.0032"	18,000 / 100" / 0.0026"	18,000 / 190" / 0.0053"	18,000 / 220" / 0.0063"	18,000 / 150" / 0.0042"
RC-2248	18,000 / 110" / 0.0032"	18,000 / 100" / 0.0026"	18,000 / 190" / 0.0053"	18,000 / 220" / 0.0063"	18,000 / 150" / 0.0042"
RC-2241	18,000 / 340" / 0.0097"	18,000 / 290" / 0.0081"	18,000 / 560" / 0.016"	18,000 / 350" / 0.0097"	18,000 / 450" / 0.013"
RC-2242	18,000 / 130" / 0.0034"	18,000 / 100" / 0.0029"	18,000 / 100" / 0.0058"	18,000 / 250" / 0.0069"	18,000 / 160" / 0.0046"
RC-2257	12,000 / 140" / 0.0038"	12,000 / 110" / 0.0031"	12,000 / 220" / 0.0063"	12,000 / 180" / 0.0075"	12,000 / 120" / 0.0050"
RC-2258	7,520 / 70" / 0.0032"	7,520 / 70" / 0.0027"	7,520 / 120" / 0.0053"	7,520 / 140" / 0.0063"	7,520 / 60" / 0.0043"

*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