

2 Flute Carbide Tipped Mortising Router Bits

CNC Operating Spindle Speed: 18,000 RPM / Depth of Cut: 1 x Tool Diameter

Tool No.	Diameter	Softwood			Hardwood			MDF			Plywood		
		* 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
45576	3/4"	290	.0079"	145	120	.0033"	60	240	.0066"	120	140	.0040"	70
45580	1-1/4"	150	.0043"	75	60	.0018"	30	130	.0036"	65	80	.0022"	40

* **IPM:** Inches Per Minute

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%

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

Disclaimer: It is important to understand that these values are only recommendations.