



Carbide Tipped 3 & 4 Wing Spoilboard Surfacing, Planing & Chamfering Router Bits

CNC Operating Spindle Speed: 18,000 RPM

Feed and Speed based on 1/4" Cutting Depth Per Pass

Tool No.	Diameter	Wings	Plywood/Chipboard IPM* / Chip Load Per Tooth	Hardwood IPM* / Chip Load Per Tooth	MDF IPM* / Chip Load Per Tooth	Softwood IPM* / Chip Load Per Tooth	Plastic IPM* / Chip Load Per Tooth
45522	1"	3-Wing	130" / 0.002"	120" / 0.002"	200" / 0.004"	130" / 0.002"	120" / 0.002"
45523	28.5mm	3-Wing	130" / 0.002"	120" / 0.002"	200" / 0.004"	130" / 0.002"	120" / 0.002"
45525	1-1/8"	3-Wing	130" / 0.002"	120" / 0.002"	200" / 0.004"	130" / 0.002"	120" / 0.002"
45526	1-1/2"	4-Wing	160" / 0.002"	150" / 0.002"	250" / 0.004"	160" / 0.002"	150" / 0.002"
45527	2"	4-Wing	160" / 0.002"	150" / 0.002"	250" / 0.004"	160" / 0.002"	150" / 0.002"

*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

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

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