3 Flute Up-Cut Solid Carbide Spektra™ Extreme Tool Life Coated Spiral Phenolic, Resin and Composite with Chipbreaker CNC Router Bits

Depth of Cut: 1 x Tool Diameter †

<table>
<thead>
<tr>
<th>Material</th>
<th>Diameter</th>
<th>Operating RPM</th>
<th>Chip Load Per Tooth</th>
</tr>
</thead>
<tbody>
<tr>
<td>Phenolic (Fiberglass, linen, wood, others)</td>
<td>1/4&quot;</td>
<td>8,000 - 16,000</td>
<td>0.002&quot; - 0.010&quot;</td>
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<tr>
<td></td>
<td>3/8&quot;</td>
<td>6,000 - 10,000</td>
<td>0.002&quot; - 0.010&quot;</td>
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<tr>
<td></td>
<td>1/2&quot;</td>
<td>4,000 - 8,000</td>
<td>0.002&quot; - 0.010&quot;</td>
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</tbody>
</table>

† 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 IPM / # of flutes

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