

Solid Carbide ZrN Coated Radius and Chamfer Edge Aluminum Cutting End Mill Router Bits
 Operating RPM: 18,000 / Depth of Cut: 1 x Tool Diameter †

Material	Feed Rate Inch/Min	Chip Load Per Tooth
Aluminum	9" - 36"	0.0005" - 0.002"
Brass	9" - 36"	0.0005" - 0.002"
Copper	9" - 36"	0.0005" - 0.002"
Plastic	36" - 90"	0.002" - 0.005"

Tool Reference #'s		
Radius	Chamfer	Dia.
51620	51625	3/16"
51622	51627	3/16"

† **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.