



**Insert Carbide 3 & 5 Wing Heavy Duty Spoilboard Surfacing,  
Planing & Chamfering Router Bits**

Tool No.	Wings	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-2255	3-Wing	18,000 / 50" / 0.0009"	18,000 / 40" / 0.0008"	18,000 / 90" / 0.0016"	18,000 / 90" / 0.0016"	15,000 / 50" / 0.0012"
RC-2259	5-Wing	12,000 / 60" / 0.0010"	12,000 / 50" / 0.0009"	12,000 / 100" / 0.0018"	12,000 / 110" / 0.0019"	9,000 / 60" / 0.0013"

**Max Cutting Depth Per Pass 1/4"**

\*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**: RPM x # of flutes x chip load

To find **Chip Load**: IPM / (RPM x # of Flutes)

**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%