



Mini Insert Carbide 2+2 Spoilboard Surfacing Rabbeting, Flycutter & Leveler Router Bits

Tool No.	Plywood/Chipboard RPM / IPM* / Chip Load Per Tooth	Hardwood RPM / IPM* / Chip Load Per Tooth	MDF RPM / IPM* / Chip Load Per Tooth	Softwood RPM / IPM* / Chip Load Per Tooth	Plastic RPM / IPM* / Chip Load Per Tooth
RC-2247	18,000 / 100" / 0.003"	18,000 / 85" / 0.002"	18,000 / 171" / 0.005"	18,000 / 185" / 0.005"	18,000 / 129" / 0.004"
RC-2249	18,000 / 29" / 0.001"	18,000 / 25" / 0.001"	18,000 / 50" / 0.001"	18,000 / 51" / 0.001"	18,000 / 36" / 0.001"
RC-2250	18,000 / 100" / 0.003"	18,000 / 85" / 0.002"	18,000 / 171" / 0.005"	18,000 / 188" / 0.005"	18,000 / 129" / 0.004"
RC-2253	18,000 / 33" / 0.001"	18,000 / 28" / 0.001"	18,000 / 57" / 0.002"	18,000 / 33" / 0.001"	18,000 / 42" / 0.001"

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%