



**Solid Carbide Spektra™ Extreme Tool Life Coated  
Compression Spiral 2 & 3 Flute Router Bits  
Operating RPM: 18,000**

**(Chip Load Per Tooth)**

<b>Diameter</b> 2 Flute	<b>MDF/HDF</b>	<b>Laminate</b>	<b>Melamine</b>	<b>Veneered Plywood</b>	<b>Wood</b>	<b>Oriented Strand Board (OSB)</b>
<b>1/8" (0.125)</b>	0.006" - 0.010"	0.012" - 0.014"	0.012" - 0.014"	0.012" - 0.014"	0.008" - 0.010"	0.012" - 0.014"
<b>1/4" (0.25)</b>	0.013" - 0.015"	0.017" - 0.019"	0.017" - 0.019"	0.017" - 0.019"	0.014" - 0.016"	0.017" - 0.019"
<b>3/8" (0.375)</b>	0.014" - 0.016"	0.019" - 0.021"	0.019" - 0.021"	0.019" - 0.021"	0.016" - 0.018"	0.019" - 0.021"
<b>1/2" (0.50)</b>	0.016" - 0.018"	0.021" - 0.023"	0.021" - 0.023"	0.021" - 0.023"	0.018" - 0.020"	0.021" - 0.023"
<b>3 Flute</b>						
<b>3/8" (0.375)</b>	0.014" - 0.016"	0.019" - 0.021"	0.019" - 0.021"	0.019" - 0.021"	0.014" - 0.016"	0.019" - 0.021"
<b>1/2" (0.50)</b>	0.016" - 0.018"	0.022" - 0.024"	0.022" - 0.024"	0.022" - 0.024"	0.016" - 0.018"	0.022" - 0.024"

Tool Reference #'s	Dia.
2 Flute	
46161	3/8"
46162	3/8"
46180-K	1/8"
*46188-K	1/2"
*46190-K	1/2"
*46170-K	1/4"
*46171-K	3/8"
3 Flute	
*46010-K	3/8"
*46012-K	1/2"
46014-K	1/2"

**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)

**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%

**Disclaimer:** These values are based on test results using 18,000 RPM. Your results may vary. It is important to understand that these values are only recommendations.

\*46010-K is replacing 46166  
\*46012-K is replacing 46168  
\*46170-K is replacing 46169  
\*46171-K is replacing 46167  
\*46188-K is replacing 46163  
\*46190-K is replacing 46165