



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

(Chip Load Per Tooth)

Diameter	Softwood/Hardwood/ Plywood	Laminate/MDF
2 Flute		

1/8" (0.125)	0.003" - 0.005"	0.005" - 0.007"
1/4" (0.25)	0.005" - 0.007"	0.006" - 0.008"
1/2" (0.50)	0.007" - 0.009"	0.008" - 0.010"

Tool Reference #'s		
Up-Cut	Down-Cut	Dia.
2 Flute	2 Flute	
46100	46200	1/8"
46102	46202	1/4"
46106	46206	1/2"
46315	46415	1/4"

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%

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.