



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

Tool No.	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-2251	17,000 / 35" / 0.001"	17,000 / 30" / 0.001"	17,000 / 60" / 0.002"	17,000 / 65" / 0.002"	12,000 / 21" / 0.001"
RC-2252	14,300 / 29" / 0.001"	14,300 / 25" / 0.001"	14,300 / 51" / 0.002"	14,300 / 29" / 0.001"	9,530 / 25" / 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%