



Solid Carbide Spektra™ Extreme Tool Life Coated Straight Flute Finishing with Chip Breaker Router Bit
CNC Operating Spindle Speed: 18,000 RPM / Depth of Cut: 1 x Tool Diameter †

3 Flute

Diameter	Wood/Plywood			MDF/Laminate		
	Feed Rate IPM *	Chip Load Per Tooth	Ramp Down	Feed Rate IPM *	Chip Load Per Tooth	Ramp Down
1/4"	180"	.0050"	90"	215"	.0060"	107.5"

Tool Reference #'s	
3 Flute	Dia.
59432-K	1/4"

* **IPM:** Inches Per Minute

† **Depth of Cut:** 1 x D Use recommended feed rate
2 x D Reduce feed rate by 25%
3 x D Reduce feed rate by 50%

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)

To find **Ramp Down:** Feed Rate IPM / # of flutes

Disclaimer: It is important to understand that these values are only recommendations.

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