



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

Diameter	(Chip Load Per Tooth) Softwood/Hardwood
2 Flute	
1/8" (0.125)	0.003" - 0.005"
1/4" (0.25)	0.014" - 0.016"

Tool Reference #'s		
Up-Cut	Down-Cut	Dia.
2 Flute		
46241-K	46341-K	1/8"
46248-K	46348-K	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 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: It is important to understand that these values are only recommendations.

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