



## 2 Flute Carbide Tipped Mortising Router Bit

CNC Operating Spindle Speed: 18,000 RPM

Diameter	Softwood			Hardwood			MDF			Plywood		
	Feed Rate IPM *	Chip Load Per Tooth	Ramp Down	Feed Rate IPM *	Chip Load Per Tooth	Ramp Down	Feed Rate IPM *	Chip Load Per Tooth	Ramp Down	Feed Rate IPM *	Chip Load Per Tooth	Ramp Down
3/4"	180"	.0050"	90"	80"	.0023"	40"	160"	.0046"	80"	100"	.0027"	50"

Tool Reference #'s	
45504	3/4"

\* **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 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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