



2 Flute Carbide Tipped Plunging Round Over Router Bits

Operating RPM: 18,000 / Depth of Cut: 1 x Tool Diameter †

(Max Cutting Depth Per Pass 1/4)

Diameter	Hardwood			Softwood			MDF		
	Feed Rate IPM *	Chip Load Per Tooth	Plunge Rate	Feed Rate IPM *	Chip Load Per Tooth	Plunge Rate	Feed Rate IPM *	Chip Load Per Tooth	Plunge Rate
1-3/8"	100"	.002"	50"	125"	.003"	60"	150"	.004"	75"

Tool Reference #'s	
49706	1-3/8" Dia.

*IPM: Inches Per Minute

† **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%

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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