

**Solid Carbide Spektra™ Extreme Tool Life Coated
Compression Spiral 2 & 3 Flute Router Bits
Operating RPM: 18,000**

2 Flute

Tool No.	Diameter	MDF/HDF			Laminate			Melamine			Veneered Plywood			Wood			Oriented Strand Board (OSB)		
		* Feed Rate	Chip Load Per Tooth	* Ramp Down	* Feed Rate	Chip Load Per Tooth	* Ramp Down	* Feed Rate	Chip Load Per Tooth	* Ramp Down	* Feed Rate	Chip Load Per Tooth	* Ramp Down	* Feed Rate	Chip Load Per Tooth	* Ramp Down	* Feed Rate	Chip Load Per Tooth	* Ramp Down
46180-K	1/8"	40	.0011"	20	40	.0011"	20	40	.0011"	20	20	.0005"	10	20	.0005"	10	40	.0011"	20
46175-K	6mm	80	.0021"	40	80	.0021"	40	80	.0021"	40	40	.0010"	20	40	.0010"	20	80	.0021"	40
46170-K	1/4"	80	.0021"	40	80	.0021"	40	80	.0021"	40	40	.0010"	20	40	.0010"	20	80	.0021"	40
46171-K	3/8"	260	.0072"	130	260	.0072"	130	260	.0072"	130	130	.0036"	65	130	.0036"	65	260	.0072"	130
46174-K	3/8"	260	.0072"	130	260	.0072"	130	260	.0072"	130	130	.0036"	65	130	.0036"	65	260	.0072"	130
46172-K	3/8"	260	.0072"	130	260	.0072"	130	260	.0072"	130	130	.0036"	65	130	.0036"	65	260	.0072"	130
46182-K	1/2"	350	.0096"	175	350	.0096"	175	350	.0096"	175	170	.0048"	85	170	.0048"	85	350	.0096"	175
46185-K	12mm	350	.0096"	175	350	.0096"	175	350	.0096"	175	170	.0048"	85	170	.0048"	85	350	.0096"	175
46188-K	1/2"	350	.0096"	175	350	.0096"	175	350	.0096"	175	170	.0048"	85	170	.0048"	85	350	.0096"	175
46190-K	1/2"	350	.0096"	175	350	.0096"	175	350	.0096"	175	170	.0048"	85	170	.0048"	85	350	.0096"	175
46193-K	1/2"	350	.0096"	175	350	.0096"	175	350	.0096"	175	170	.0048"	85	170	.0048"	85	350	.0096"	175
46195-K	1/2"	350	.0096"	175	350	.0096"	175	350	.0096"	175	170	.0048"	85	170	.0048"	85	350	.0096"	175
46199-K	1/2"	350	.0096"	175	350	.0096"	175	350	.0096"	175	170	.0048"	85	170	.0048"	85	350	.0096"	175

3 Flute

46011-K	3/8"	400	.0075"	200	400	.0075"	200	400	.0075"	200	200	.0036"	100	200	.0036"	100	400	.0075"	200
46010-K	3/8"	400	.0075"	200	400	.0075"	200	400	.0075"	200	200	.0036"	100	200	.0036"	100	400	.0075"	200
46012-K	1/2"	520	.0096"	260	520	.0096"	260	520	.0096"	260	270	.0049"	135	270	.0049"	135	520	.0096"	260
46014-K	1/2"	520	.0096"	260	520	.0096"	260	520	.0096"	260	270	.0049"	135	270	.0049"	135	520	.0096"	260

*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 / 2