

Foam Cutting Straight V Flute High Speed Steel (HSS) Router Bits

Tool No. Foam / Natural Wood RPM / Chip Load Per Tooth

HSS1610	18,000 / 0.003" - 0.005"
HSS1611	18,000 / 0.003" - 0.005"
HSS1612	18,000 / 0.003" - 0.005"
HSS1613	18,000 / 0.004" - 0.006"
HSS1614	18,000 / 0.005" - 0.007"

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**: RPM x # of flutes x chip load

To find **Chip Load**: 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: These values are based on test results using 18,000 RPM. Your results may vary.
It is important to understand that these values are only recommendations.