2 Flute Solid Carbide Spiral Plunge with Corner Radius Router Bit
CNC Operating Spindle Speed: 18,000 RPM / **Depth of Cut:** 1 x Tool Diameter †

Diameter 2 Flute	Soft Wood		Hard Wood		MDF		Hard / Soft Plastics		Aluminum	
	Feed Rate IPM*	Chip Load Per Tooth	Feed Rate IPM*	Chip Load Per Tooth	Feed Rate IPM*	Chip Load Per Tooth	Feed Rate IPM*	Chip Load Per Tooth	Feed Rate IPM*	Chip Load Per Tooth
1/4" (0.25)	250" - 320"	0.007" - 0.009"	180" - 250"	0.005" - 0.007"	210" - 290"	0.006" - 0.008"	150" - 210"	0.004" - 0.006"	150" - 210"	0.004" - 0.006"
1/2" (0.50)	330" - 425"	0.009" - 0.011"	240" - 330"	0.007" - 0.009"	280" - 390"	0.008" - 0.010"	200" - 280"	0.006" - 0.008"	200" - 280"	0.006" - 0.008"

Tool Reference #'s	Dia.
2 Flute	
46460	1/4"
46462	1/2"

*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.