

6 Pc CNC Electric Guitar Making Router Bit Set

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

2 Flute

Tool No.	Diameter	Wood/Plywood			MDF/Laminate		
		Feed Rate IPM *	Chip Load Per Tooth	Ramp Down	Feed Rate IPM *	Chip Load Per Tooth	Ramp Down
46403-K	1/16"	70 "	.0020"	35"	105"	.0030"	52.5"
45924	1"	120"	.0029"	60"	200"	.0058"	100"
46202-K	1/4"	180"	.0050"	90"	215"	.0060"	107.5"
46421-K	1/4"	180"	.0050"	90"	215"	.0060"	107.5"
56126	3/8"	90 "	.0024"	45"	180"	.0048"	110"

* IPM: Inches Per Minute

† Depth of Cut:

1 x D Use recommended feed rate

2 x D Reduce feed rate by 25%

3 x D Reduce feed rate 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.