

Tool No.	Angle a°	Flutes	RPM	Hardwood			Softwood			Plywood/Chipboard			MDF			Plastic			Foam		
				*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
RC-1040	40°	1	18,000	40	.0024"	20	40	.0024"	20	40	.0024"	20	90	.0047"	45	40	.0024"	20	90	.0047"	45
RC-1045	45°	1	18,000	40	.0024"	20	40	.0024"	20	40	.0024"	20	90	.0047"	45	40	.0024"	20	90	.0047"	45
RC-1145	45°	1	18,000	40	.0024"	20	40	.0024"	20	40	.0024"	20	90	.0047"	45	40	.0024"	20	90	.0047"	45
RC-1049	45°	1	18,000	40	.0024"	20	40	.0024"	20	40	.0024"	20	90	.0047"	45	40	.0024"	20	90	.0047"	45
RC-1031	45°	1	18,000	40	.0024"	20	40	.0024"	20	40	.0024"	20	80	.0047"	40	40	.0024"	20	80	.0047"	40
RC-1047	46°	1	18,000	40	.0024"	20	40	.0024"	20	40	.0024"	20	90	.0047"	45	40	.0024"	20	90	.0047"	45
RC-1046	50°	1	18,000	40	.0024"	20	40	.0024"	20	40	.0024"	20	90	.0047"	45	40	.0024"	20	90	.0047"	45
RC-1108	60°	1	18,000	40	.0024"	20	40	.0024"	20	40	.0024"	20	90	.0047"	45	40	.0024"	20	90	.0047"	45
RC-1148	60°	1	18,000	40	.0024"	20	40	.0024"	20	40	.0024"	20	90	.0047"	45	40	.0024"	20	90	.0047"	45
RC-1048	70°	1	18,000	40	.0024"	20	40	.0024"	20	40	.0024"	20	90	.0047"	45	40	.0024"	20	90	.0047"	45
RC-1072	72°	1	18,000	40	.0024"	20	40	.0024"	20	40	.0024"	20	90	.0047"	45	40	.0024"	20	90	.0047"	45
RC-1102	90°	1	18,000	40	.0024"	20	40	.0024"	20	40	.0024"	20	90	.0047"	45	40	.0024"	20	90	.0047"	45
RC-1142	90°	1	18,000	40	.0024"	20	40	.0024"	20	40	.0024"	20	90	.0047"	45	40	.0024"	20	90	.0047"	45
RC-1030	90°	1	18,000	40	.0024"	20	40	.0024"	20	40	.0024"	20	80	.0047"	40	40	.0024"	20	80	.0047"	40
RC-1034	90°	1	18,000	40	.0024"	20	40	.0024"	20	40	.0024"	20	80	.0047"	40	40	.0024"	20	80	.0047"	40
RC-1100	91°	1	18,000	40	.0024"	20	40	.0024"	20	40	.0024"	20	90	.0047"	45	40	.0024"	20	90	.0047"	45
RC-1140	91°	1	18,000	40	.0024"	20	40	.0024"	20	40	.0024"	20	90	.0047"	45	40	.0024"	20	90	.0047"	45
RC-1028	91°	1	18,000	40	.0024"	20	40	.0024"	20	40	.0024"	20	80	.0047"	40	40	.0024"	20	80	.0047"	40
RC-1103	100°	1	18,000	40	.0024"	20	40	.0024"	20	40	.0024"	20	90	.0047"	45	40	.0024"	20	90	.0047"	45
RC-1105	110°	1	18,000	40	.0024"	20	40	.0024"	20	40	.0024"	20	90	.0047"	45	40	.0024"	20	90	.0047"	45
RC-1104	120°	2	18,000	90	.0024"	45	90	.0024"	45	90	.0024"	45	180	.0048"	90	90	.0024"	45	180	.0048"	90
RC-1029	120°	2	15,000	70	.0024"	35	70	.0024"	35	70	.0024"	35	150	.0047"	75	70	.0024"	35	140	.0047"	70
RC-1107	130°	2	18,000	90	.0024"	45	90	.0024"	45	90	.0024"	45	180	.0048"	90	90	.0024"	45	180	.0048"	90
RC-1110	140°	2	18,000	90	.0024"	45	90	.0024"	45	90	.0024"	45	180	.0048"	90	90	.0024"	45	180	.0048"	90
RC-1111	140°	2	16,000	80	.0024"	40	80	.0024"	40	80	.0024"	40	160	.0048"	80	80	.0024"	40	160	.0048"	80
RC-1106	150°	2	18,000	90	.0024"	45	90	.0024"	45	90	.0024"	45	180	.0048"	90	90	.0024"	45	180	.0048"	90
RC-1027	150°	2	13,000	60	.0024"	30	60	.0024"	30	60	.0024"	30	120	.0047"	60	60	.0024"	30	120	.0047"	60
RC-1109	160°	2	18,000	90	.0024"	45	90	.0024"	45	90	.0024"	45	180	.0048"	90	90	.0024"	45	180	.0048"	90

*IPM: Inches Per Minute

Ramp Down is half the Feed Rate.

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)