



Carbide Tipped Bowl & Tray Router Bit
CNC Operating Spindle Speed: 18,000 RPM / Depth of Cut: .15"

Tool No.	Diameter	Flute	Wood/Plywood	
			Feed Rate IPM*	Plunge Rate IPM*
45982	3/4"	2	50"	25"

*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.