2 Flute Foam Cutting Straight V Flute High Speed Steel (HSS) Router Bits
CNC Operating Spindle Speed: 18,000 RPM / **Depth of Cut:** 1 x Tool Diameter †

Tool No.	Foam / Natural Wood	
	Feed Rate IPM*	**Chip Load Per Tooth**
HSS1610	110" - 180"	0.003" - 0.005"
HSS1611	110" - 180"	0.003" - 0.005"
HSS1612	110" - 180"	0.003" - 0.005"
HSS1613	150" - 220"	0.004" - 0.006"
HSS1614	180" - 250"	0.005" - 0.007"

* 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