



**Insert Carbide 2+2 Spoilboard Surfacing, Rabbeting,
Flycutter, Leveler & Surface Planer Router Bits**

Tool No.	Plywood/Chipboard RPM / IPM* / Chip Load Per Tooth	Hardwood RPM / IPM* / Chip Load Per Tooth	MDF RPM / IPM* / Chip Load Per Tooth	Softwood RPM / IPM* / Chip Load Per Tooth	Plastic RPM / IPM* / Chip Load Per Tooth
RC-2251	18,000 / 130" / 0.0038"	18,000 / 110" / 0.0031"	18,000 / 220" / 0.0062"	18,000 / 270" / 0.0075"	18,000 / 120" / 0.0031"
RC-2252	14,300 / 100" / 0.0037"	14,300 / 100" / 0.0037"	14,300 / 180" / 0.0062"	14,300 / 210" / 0.0075"	14,300 / 100" / 0.0050"

⚠ Warning: Max Cutting Depth Per Pass 1/4"

***IPM:** Inches Per Minute

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:** RPM x # of flutes x chip load

To find **Chip Load:** IPM / (RPM x # of Flutes)

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%