



Point Cutting Round Over Router Bits
 Operating RPM: 18,000

| Hardwood | Softwood | Plastic | Plywood | MDF |
|-----------------------------------|-----------------------------------|-----------------------------------|-----------------------------------|-----------------------------------|
| IPM* / Chip Load Per Tooth | IPM* / Chip Load Per Tooth | IPM* / Chip Load Per Tooth | IPM* / Chip Load Per Tooth | IPM* / Chip Load Per Tooth |
| 90" / 0.0024" | 90" / 0.0024" | 90" / 0.0024" | 90" / 0.0024" | 180" / 0.0048" |

*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 IPM**: RPM x # of flutes x chip load

To find **Chip Load**: Feed Rate 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%

Disclaimer: These values are based on test results using 18,000 RPM. Your results may vary. It is important to understand that these values are only recommendations.