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Subject: Re: Another question on router gear  
Posted by [Bill Martinelli](#) on Tue, 06 Jan 2004 15:35:48 GMT  
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An upcutting tool bit refers to the angle of the grind on the side flute. The up cutting bit pulls the chip load out of the cut as it turns. This is particularly good when making deeper cuts as the chips are pulled out of the cut instead of being packed in like a straight flute cutter. This may not be the best choice of cutter if you are routing delicate veneer though. This bit will want to pull the top layer away from the substrate and cause chips and splinters. For this a straight cutter or down cut may work better. On the other side of the coin. If you use a router table. Choosing an upcutting tool bit now pulls the work down against the table. You can then work with the delicate veneer on the top side and the cutter will then have less tearout. It can get confusing but you just have to think in terms of what is the best direction for the cutter to be forcing the tearout. You can use standard 1/2" shank, two flute end mills as an upcutting router bit. available in high speed steel or solid carbide.Bill

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