

MLCS Spiral Upcut and Downcut Bits provide a smooth shearing action, keeping steady contact with the workpiece and leaving work almost fray and splinter-free.

While most MLCS bits are carbide-tipped, spiral bits are **SOLID CARBIDE**. Though harder than steel, carbide is also more brittle. Thus, extra care must be taken with these bits. Never force your work. Don't make sudden plunges or starts.

Important: When the diameter of the bit is less than the depth of your groove, **take the cut in multiple passes, going deeper each time**. For smaller diameter bits (1/4" or less), we recommend cutting depths of half the bit diameter per pass. **Do NOT try to take the full depth in one pass.**

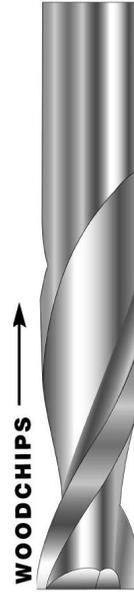
CHOOSING AND USING THE RIGHT BIT

UPCUT Bits remove sawdust and wood chips from a plunge cut with upward shearing. They work well for making deep mortises. In this application, any tearout caused by the upcut will be hidden by the tenoned workpiece. Upcut bits can also be used for any edge treatment performed with the work facing upward. Upcut bits are also useful when cutting dadoes in a router table.

DOWNCUT Bits (naturally) cut downward (away from the router base). This motion gives grooves, dadoes, rabbets, shallow mortises and plunge cuts a smooth clean edge. **REMEMBER:** Downcut bits push sawdust into the cut. Making multiple passes reduces the buildup of sawdust in the groove.

COMPRESSION UP/DOWN SPIRAL Bits (MLCS #7425) cut upward and downward simultaneously. This unusual design makes them perfect for smoothing and tidying the edges of hardwood plywood or melamine-coated particleboard (MCP). **NOTE:** When working with easily chipped materials, you may want to precut your pieces oversized using a tablesaw.

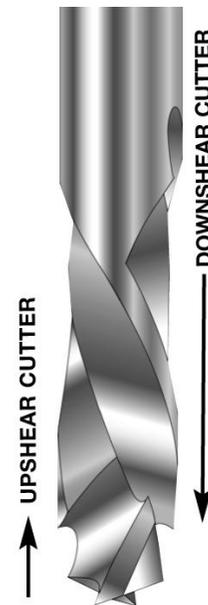
Spiral Up/Downcut Bits



Spiral Upcut Bit



Spiral Downcut Bit



Compression Up-Down Spiral Bit
 (#7425)