Amana Tool 'O' Flute Router Bits, Speed & Feed Chart

Material	Chip Load			
	1/8" (.125")	3/16" (.1875")	1/4" (.250")	1/2" (.50")
Plastics	.004"-.006"	.006"- .008"	.008"-.012"	.010" - .014"
Composites	.003" - .005"	.003" - .005"	.003" - .005"	.006" - .008"

Adjustments for "Depth of Cut"

1 Xs Diameter: Recommended chip load

2 Xs Diameter: Reduce chip load by 25%

3 Xs Diameter: Reduce chip load by 50%

Math For Routers:

To find **Chip Load** = Feed Rate / RPM of spindle X # of cutting edges

To find **Feed Rate** = RPM X # of cutting edges X chip load

To find **RPM** = Feed Rate / (Chip Load X # of cutting edges)