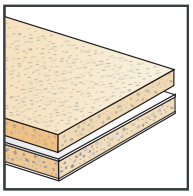
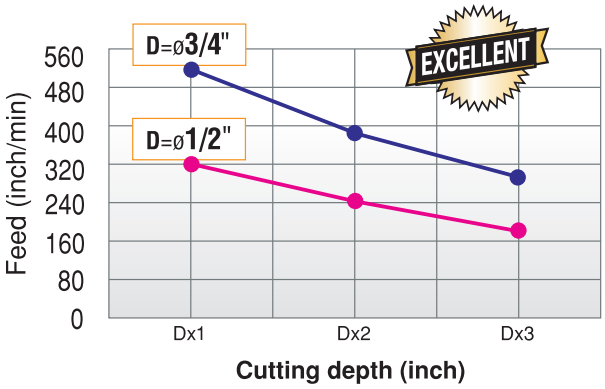
Feed Rates - Solid Carbide Spiral 2-Flute Plunge for MDF/Laminate

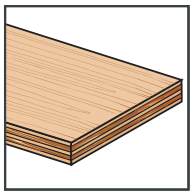
INDUSTRIAL

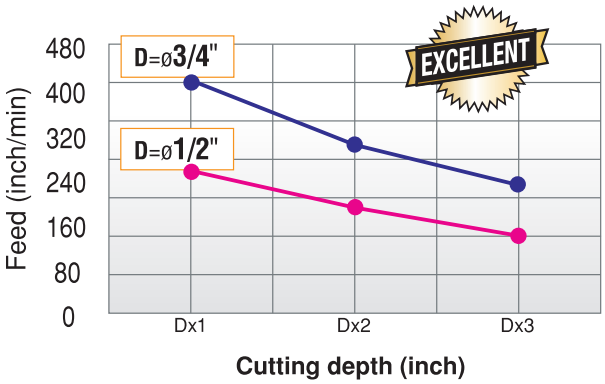
Particle Board
Laminate



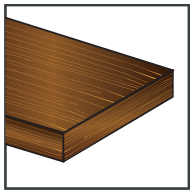


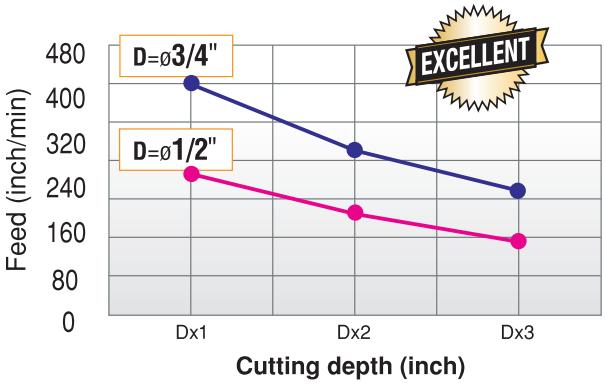
Plywood
Veneered Plywood



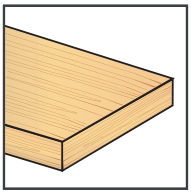


Hardwood





Softwood



NOT RECOMMENDED

Amana Tool® doesn't recommend using these Solid Carbide Spiral Flute Plunge router bits on Softwood.

Tool Reference #'s	
Up-Cut	Down-Cut
46127	46229
46100	46231
46125	46237
46310	46239
46101	46227
46314	46200
46102	46225
46315	46410
46316	46201
46119	46414
46317	46202
46117	46415
46318	46416
46103	46219
46320	46417
46104	46217
46106	46203
46107	46420
46108	46204
46121	46206
	46207
	46208

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)

Recommended Feed Rate
Because of the dependency which we have between the cutting conditions and the non-uniformity of the wood pieces, it is important to understand that these values are only recommendations. Wood fiber direction, wood type, wood humidity, clamping stiffness, machine stiffness, etc., all these variables together or one by one can change the cutting condition. It is recommended that in any new application, you reach the recommended feed rate gradually and if the cutting quality is OK, you can continue to increase the feed rate values. Please remember, the larger your chip per tip (high feed rate), the lifetime of the tool is increased.

Amana Tool®
REDEFINING WOODWORKING®