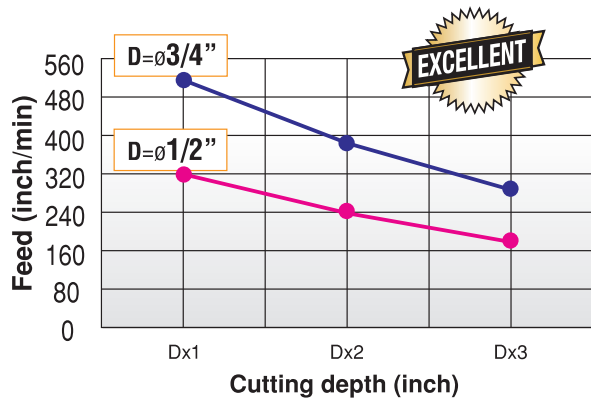
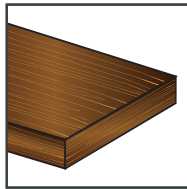


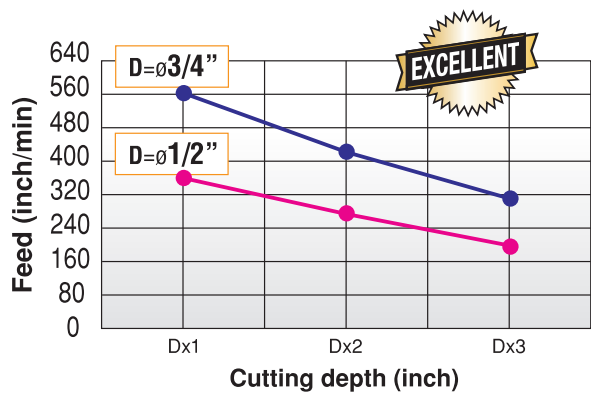
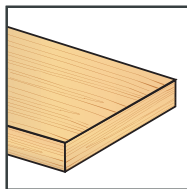
Feed Rates - Solid Carbide Spiral Roughing w/Chipbreaker

Hardwood

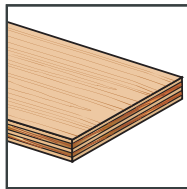


Tool Reference #'s	
Up-Cut	Down-Cut
46124	46223
46126	46224
46129	46226
46130	

Softwood



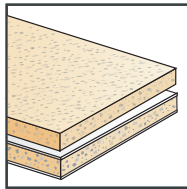
**Plywood
Veneered Plywood**



NOT RECOMMENDED

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

**Particle Board
Laminate**



NOT RECOMMENDED

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

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.