Amana Tool®

INDUSTRIAL

3 Flute Solid Carbide Spiral Flute Finishing With Chip Breaker Router Bits

CNC Operating Spindle Speed: 18,000 RPM / **Depth of Cut:** 1 x Tool Diameter †

Diameter	Wood	
	Feed Rate IPM*	Chip Load Per Tooth
1/2" (0.50)	1100" - 1200"	0.020" - 0.022"
5/8" (0.625)	1200" - 1300"	0.022" - 0.024"
3/4" (0.75)	1300" - 1400"	0.024" - 0.026"

***IPM:** Inches Per Minute

Tool Reference #'s		
Up-Cut	Down-Cut	Dia.
46132	46232	1/2"
46134	46234	1/2"
46136	46236	5/8"
46138	46238	3/4"

† Depth of Cut: 1 x D Use recommended chip load
2 x D Reduce chip load by 25%
3 x D Reduce chip load by 50%

Simple Machining Calculations:
To find **RPM:** (SFM x 3.82) / diameter of tool
To find **SFM:** 0.262 x diameter of tool x RPM
To find **Feed Rate IPM:** RPM x # of flutes x chip load
To find **Chip Load:** Feed Rate IPM / (RPM x # of flutes)
To find **Ramp Down:** Feed Rate IPM / # of flutes

Disclaimer: It is important to understand that these values are only recommendations.

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