Amana Tool®

INDUSTRIAL

High Speed Steel (HSS) Single & Double Flute Aluminum Cutting Router Bits

Tool No.	Max RPM	Flutes	Chip Load Per Tooth (1D Cutting Length) Soft Wood	Hard Wood	Aluminum
HSS1620	18,000	1	0.008" - 0.010"	0.006" - 0.008"	0.004" - 0.006"
HSS1621	18,000	1	0.008" - 0.010"	0.006" - 0.008"	0.004" - 0.006"
HSS1622	18,000	1	0.008" - 0.010"	0.006" - 0.008"	0.004" - 0.006"
HSS1623	18,000	1	0.008" - 0.010"	0.006" - 0.008"	0.004" - 0.006"
HSS1628	18,000	1	0.008" - 0.010"	0.006" - 0.008"	0.004" - 0.006"
HSS1629	18,000	1	0.008" - 0.010"	0.006" - 0.008"	0.004" - 0.006"
HSS1630	18,000	2	0.006" - 0.008"	0.005" - 0.007"	0.002" - 0.004"
HSS1633	18,000	2	0.006" - 0.008"	0.005" - 0.007"	0.002" - 0.004"
HSS1634	18,000	2	0.006" - 0.008"	0.005" - 0.007"	0.002" - 0.004"
HSS1635	16,000	2	0.006" - 0.008"	0.005" - 0.007"	0.002" - 0.004"
HSS1636	18,000	2	0.006" - 0.008"	0.005" - 0.007"	0.002" - 0.004"
HSS1637	16,000	2	0.006" - 0.008"	0.005" - 0.007"	0.002" - 0.004"
HSS1641	18,000	2	0.007" - 0.009"	0.006" - 0.008"	0.003" - 0.005"
HSS1644	18,000	2	0.008" - 0.010"	0.007" - 0.009"	0.004" - 0.008"
HSS1645	18,000	2	0.008" - 0.010"	0.007" - 0.009"	0.004" - 0.008"
HSS1650	18,000	2	0.006" - 0.008"	0.005" - 0.007"	0.002" - 0.004"
HSS1653	18,000	2	0.006" - 0.008"	0.005" - 0.007"	0.002" - 0.004"
HSS1654	16,000	2	0.006" - 0.008"	0.005" - 0.007"	0.002" - 0.004"
HSS1659	16,000	2	0.006" - 0.008"	0.005" - 0.007"	0.002" - 0.004"
HSS1656	18,000	2	0.006" - 0.008"	0.005" - 0.007"	0.002" - 0.004"
HSS1661	18,000	2	0.008" - 0.010"	0.007" - 0.009"	0.004" - 0.008"

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)

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%

Disclaimer: These values are based on test results. Your results may vary.
It is important to understand that these values are only recommendations.