Amana Tool®

INDUSTRIAL DIAMOND TECHNOLOGY

PCD* CNC Straight Plunge Router Bit Speed and Feed Chart

Tool No.	Diameter Inch/mm	No. Teeth	Chip Load Per Tooth Inch (mm)/min	RPM	Feed Rate Inch (mm)/min
DRB-420	1/4" (6.35mm)	2	.004" (0.10mm)	12,000	130" (3,200mm)
DRB-424	1/2" (12.7mm)	2	.004" (0.10mm)	12,000	130" (3,200mm)

Multipliers for different materials:
0.8% = MDF with or without Coating
1.1% = Chipboard with or without Coating
0.7% = Cross grain veneer

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:** RPM x # of flutes x chip load
To find **Chip Load =** $\frac{\text{Feed Rate}}{\text{RPM x \# of Flutes}}$

* Polycrystalline Diamond