



1 Flute Solid Carbide 'O' Flute Plastic Edge Rounding Router Bits

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

	1/4" (0.1875") #46452 & #46466	
	Feed Rate IPM*	Chip Load Per Tooth (Based on 13,000 RPM)
Plastic, Acrylics, Acrylic Stone, Corian, Coroplast®, Poly (methyl methacrylate) (PMMA)	70" - 110"	0.004" - 0.008"

*IPM Inches per minute

- † **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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