

## Solid Carbide Plastic Cutting Spiral Single & Double 'O' Flute Router Bits

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

**Diameter**                      **Feed Rate**                      **Chip Load**                      **Ramp**  
**Single Flute**                      **IPM\***                      **Per Tooth**                      **Down**

Diameter	Feed Rate IPM*	Chip Load Per Tooth	Ramp Down
1/8" (0.125)	50"	0.003"	50"
3/16" (0.1875)	60"	0.003"	60"
1/4" (0.250)	70"	0.004"	70"

### 2 Flute

Diameter	Feed Rate IPM*	Chip Load Per Tooth	Ramp Down
1/8" (0.125)	110	0.003"	55"
3/16" (0.1875)	120	0.003"	60"
1/4" (0.250)	130	0.004"	65"
1/2" (0.500)	220	0.006"	110"

Tool Reference #'s		
Tool No.	Flutes	Dia.
43500	1	1/8"
43504	1	3/16"
43508	1	1/4"
43512	1	1/4"
43514	1	1/4"
43600	2	1/8"
43604	2	3/16"
43607	2	1/4"
43608	2	1/4"
43616	2	1/2"

\* **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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