



## Single Flute Solid Carbide Soft Aluminum Cutting ZrN Coated Router Bits

Depth of Cut: 1 x Tool Diameter †

	3/16" (0.1875")		1/4" (0.250")	
	IPM*	Chip Load Per Tooth (Based on 13,000 RPM)	IPM*	Chip Load Per Tooth (Based on 10,000 RPM)
Acrylonitrile-Butadiene-Styrene (ABS), Aluminum Sheet (3003 grade)	90"	0.007"	80"	0.008"
Brass, Bronze, Copper, Gold, Silver, Polycarbonate (Lexan™)				

\* IPM Inches per minute

Tool Reference #'s	
Tool No.	Dia.
51450	3/16"
51452	1/4"

† **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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