



Solid Carbide Compression Spiral Router Bits For Nesting
CNC Operating Spindle Speed: 18,000 RPM / Depth of Cut: 1 x Tool Diameter †

3 Flute

| Diameter | Wood | | | MDF | | | Plywood | | | Plastic | | |
|----------|--------------------|------------------------|--------------|--------------------|------------------------|--------------|--------------------|------------------------|--------------|--------------------|------------------------|--------------|
| | Feed Rate IPM * | Chip Load Per Tooth | Ramp Down | Feed Rate IPM * | Chip Load Per Tooth | Ramp Down | Feed Rate IPM * | Chip Load Per Tooth | Ramp Down | Feed Rate IPM * | Chip Load Per Tooth | Ramp Down |
| 1/4" | 200" | .0037" | 67" | 400" | .0074" | 133" | 200" | .0037" | 67" | 200" | .0037" | 67" |
| 3/8" | 300" | .0056" | 100" | 400" | .0074" | 133" | 300" | .0056" | 100" | 300" | .0056" | 100" |
| 1/2" | 350" | .0065" | 117" | 450" | .0080" | 150" | 350" | .0065" | 117" | 350" | .0065" | 117" |

| Tool Reference #'s | |
|--------------------|------|
| 3 Flute | Dia. |
| 46370 | 1/4" |
| 46371 | 3/8" |
| 46372 | 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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