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Amana Tool CNC 2D/3D High Speed Steel (HSS) Upcut Spiral ZrN Coated Router Bit

Thank you for shopping with us! Specially designed for 2D and 3D CNC profiling and carving in plastic, aluminum & wood with CNC machines. The high-shear ball nose tips cut smooth 2D and 3D contours with reduced stepping while the proprietary ZrN coating (applied by the physical vapor deposition coating process) provides high resistance to wear, sharper cutting edges, extended tool life, and less friction and heat buildup. Some of Amana Tool carving tools, as you can appreciate, have a very small diameter therefore any material chip-loads need to reflect that small size. It can however withstand RPM's up to 60,000 RPMs. A directed air-blast to keep chips away along with cooling the tool and workpiece are always welcome. Tools are manufactured with high balance that allows them to run up to 60,000 RPMs. Adjust your chip load and feed rate accordingly. **Applications:**

- Precision 2D and 3D large scale carving
- Dimensional signage
- 3D millwork
- 2D and 3D contouring, profiling, modeling, and pattern-making for cabinetry, sign-making, furniture-making, and jewelry mold-making
- Compatible with CarveWright™ and CompuCarve woodworking systems
- Perfect for model-makers on large 3D milling profiles in abrasive EPS foam and other materials

Benefits of Zirconium Nitride (ZrN) Coating

- Creates a harder and tougher cutting edge, allows for a prolonged cutting edge life, and helps to prevent the build-up of material in the flutes while cutting
- Has the tendency to run/spin much faster than an uncoated tool
- Optimized flute geometry and low Total Indicated Runout (TIR) guarantees clean cuts, essentially eliminates sanding and reduces chatter (where the machine or work-piece vibrates) under high chip loads (when used with low TIR spindles)
- High flute volume supports high feed rates and chip loads
- High aspect ratio for single pass deep-reach cutting
- Flute geometry optimized for cutting sign foam, sign board, hardwoods, thermoplastics, and phenolic composites

Item #	Manufacturer	Diameter	Cut Height, Length, or Width	Flute	Overall Length	Radius	Shank Type	Angle	Price
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HSS1300	Amana Tool	1/32 in	1 in	3	3 in	1/64 in	1/4 in	Ball Nose, ZrN	6.2 deg	\$26.93
HSS1302	Amana Tool	1/16 in	1 in	4	3 in	1/32 in	1/4 in	Ball Nose, ZrN	5.4 deg	\$26.93
HSS1304	Amana Tool	1/8 in	1 in	3	3 in	1/16 in	1/4 in	Ball Nose, ZrN	3.6 deg	\$26.93
HSS1306	Amana Tool	1/8 in	1 1/2 in	3	3 in	1/16 in	1/4 in	Ball Nose, ZrN	1 deg	\$32.29
HSS1310	Amana Tool	1/16 in	5/16 in	3	2 in	--	1/4 in	Flat Bottom, ZrN	0.10 deg	\$19.61
HSS1312	Amana Tool	1/8 in	1 3/32 in	4	2 1/2 in	--	1/4 in	Flat Bottom, ZrN	0.10 deg	\$23.89