

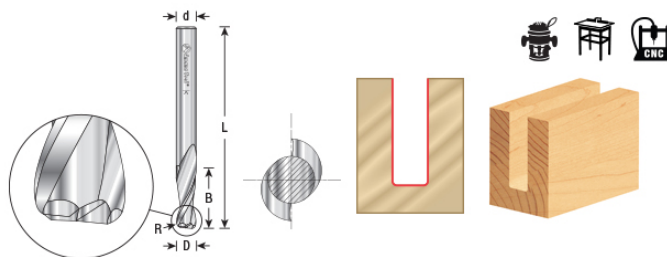
## Edge of Arlington Saw & Tool, Inc.

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### Item #46460, Amana Tool Solid Carbide Spiral Plunge with Corner Radius 1/16" Radius x 1/4" Dia x 3/4" x 1/4" Shank Upcut \$30.86

Thank you for shopping with us! For carving, lettering, decorative doors, and sign manufacturing. Leaves an excellent finish and expels chips quickly. Excellent for cutting: Aluminum MDF Soft/Hard Plastic Soft/Hard Wood



Solid Carbide Spiral Plunge with Corner Radius Router Bit  
 Operating RPM: 18,000

(Chip Load Per Tooth)

Diameter	Soft Wood	Hard Wood	MDF	Hard / Soft Plastics	Aluminum
1/4" (0.25)	0.007" - 0.008"	0.005" - 0.007"	0.006" - 0.008"	0.004" - 0.006"	0.004" - 0.006"

Tool Reference #'s	Dia.
2 Flute 46460	1/4"

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)

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%

Disclaimer: These values are based on test results using 18,000 RPM. Your results may vary. It is important to understand that these values are only recommendations.

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## SPECIFICATIONS

<b>Manufacturer</b>	Amana Tool
<b>Diameter</b>	1/4 in
<b>Cut Height, Length, or Width</b>	3/4 in
<b>Flute Geometry</b>	Upcut
<b>Flute</b>	2
<b>Overall Length</b>	2 1/2 in
<b>Radius</b>	1/16 in
<b>Shank</b>	1/4 in