

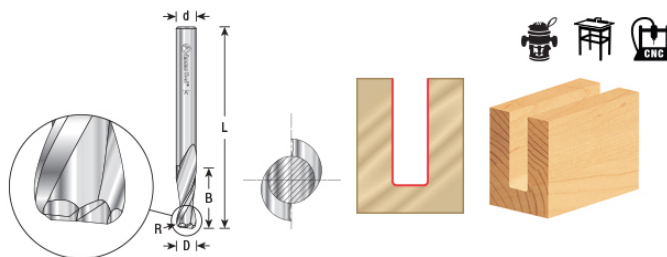
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Item #46460, Amana Tool Solid Carbide Spiral Plunge with Corner Radius 1/16" Radius x 1/4" Dia x 3/4" x 1/4" Shank Upcut \$30.86

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

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