Amana Tool®

INDUSTRIAL

Solid Carbide Cutting Edge & Carbide Tipped 2 Flute Straight Plunge High Production Router Bits

CNC Operating Spindle Speed: 18,000 RPM / **Depth of Cut:** 1 x Tool Diameter †

Tool No.	Diameter	Shank	Softwood IPM* / Chip Load Per Tooth	Hardwood IPM* / Chip Load Per Tooth	MDF IPM* / Chip Load Per Tooth	Plywood IPM* / Chip Load Per Tooth
45200	1/8"	1/4"	60" / 0.0017"	60" / 0.0017"	120" / 0.0034"	60" / 0.0017"
45210	1/4"	1/4"	110" / 0.0031"	110" / 0.0031"	220" / 0.0062"	110" / 0.0031"

***IPM:** Inches Per Minute

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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