Amana Tool®

INDUSTRIAL

2 Flute Carbide Tipped Core Box Router Bits

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

Tool No.	Diameter	Shank	Softwood		Hardwood		MDF		Plywood	
2 Flute			Feed Rate IPM*	Chip Load Per Tooth	Feed Rate IPM*	Chip Load Per Tooth	Feed Rate IPM*	Chip Load Per Tooth	Feed Rate IPM*	Chip Load Per Tooth
45930	3/8"	1/2"	200"	0.0057"	100"	0.0028"	200"	0.0057"	120"	0.0032"
45932	1/2"	1/2"	250"	0.0069"	110"	0.0032"	230"	0.0064"	140"	0.0038"
45934	9/16"	1/2"	250"	0.0069"	110"	0.0032"	230"	0.0064"	140"	0.0038"
45936	5/8"	1/2"	200"	0.0057"	100"	0.0028"	200"	0.0057"	116"	0.0032"
45938	3/4"	1/2"	200"	0.0057"	100"	0.0028"	200"	0.0057"	116"	0.0032"
45942	1"	1/2"	100"	0.0026"	50"	0.0012"	80"	0.0023"	50"	0.0012"
45944	1-1/4"	1/2"	75"	0.0021"	35"	0.0009"	70"	0.0019"	40"	0.0011"
45946	1-1/2"	1/2"	75"	0.0021"	35"	0.0009"	70"	0.0019"	40"	0.0011"
45948	2"	1/2"	40"	0.0010"	20"	0.0005"	35"	0.0009"	40"	0.0011"
45949	2-1/2"	1/2"	40"	0.0010"	20"	0.0005"	35"	0.0009"	40"	0.0011"

***IPM** Inches per minute

† Depth of Cut: 1 x D Use recommended feed rate
2 x D Reduce feed rate by 25%
3 x D Reduce feed rate 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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