Amana Tool®

INDUSTRIAL

Double Flute HSS 'O' Flute Straight Router Bits

Material	Feed Rate (Inch/Min)		Speed Rate (RPM)	
	#HSS1601 1/4"	#HSS1602 1/4"	#HSS1601 1/4"	#HSS1602 1/4"
Soft & Hard Plastics	120"	100"	15,000	12,500

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:** RPM x # of flutes x chip load
To find **Chip Load:** IPM / (RPM x # of Flutes)

SFM* Surface feet 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%

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