Amana Tool®

Insert Carbide V-Groove Router Bits

INDUSTRIAL

Tool No.	Angle a°	Flutes	RPM	Hardwood			Softwood			Plywood/Chipboard			MDF			Plastic			Foam		
				Feed Rate * IPM	Chip Load Per Tooth	Ramp Down	Feed Rate * IPM	Chip Load Per Tooth	Ramp Down	Feed Rate * IPM	Chip Load Per Tooth	Ramp Down	Feed Rate * IPM	Chip Load Per Tooth	Ramp Down	Feed Rate * IPM	Chip Load Per Tooth	Ramp Down	Feed Rate * IPM	Chip Load Per Tooth	Ramp Down
RC-1040	40°	1	18,000	40"	.0024"	20"	40"	.0024"	20"	40"	.0024"	20"	90"	.0047"	45"	40"	.0024"	20"	90"	.0047"	45"
RC-1041	40°	1	18,000	40"	.0024"	20"	40"	.0024"	20"	40"	.0024"	20"	90"	.0047"	45"	40"	.0024"	20"	90"	.0047"	45"
RC-1045	45°	1	18,000	40"	.0024"	20"	40"	.0024"	20"	40"	.0024"	20"	90"	.0047"	45"	40"	.0024"	20"	90"	.0047"	45"
RC-1145	45°	1	18,000	40"	.0024"	20"	40"	.0024"	20"	40"	.0024"	20"	90"	.0047"	45"	40"	.0024"	20"	90"	.0047"	45"
RC-1049	45°	1	18,000	40"	.0024"	20"	40"	.0024"	20"	40"	.0024"	20"	90"	.0047"	45"	40"	.0024"	20"	90"	.0047"	45"
RC-1031	45°	1	18,000	40"	.0024"	20"	40"	.0024"	20"	40"	.0024"	20"	80"	.0047"	40"	40"	.0024"	20"	80"	.0047"	40"
NOT AVAILABLE ~~RC-1047~~	46°	1	18,000	40"	.0024"	20"	40"	.0024"	20"	40"	.0024"	20"	90"	.0047"	45"	40"	.0024"	20"	90"	.0047"	45"
RC-1046	50°	1	18,000	40"	.0024"	20"	40"	.0024"	20"	40"	.0024"	20"	90"	.0047"	45"	40"	.0024"	20"	90"	.0047"	45"
RC-1147	60°	1	18,000	40"	.0024"	20"	40"	.0024"	20"	40"	.0024"	20"	90"	.0047"	45"	40"	.0024"	20"	90"	.0047"	45"
RC-1108	60°	1	18,000	40"	.0024"	20"	40"	.0024"	20"	40"	.0024"	20"	90"	.0047"	45"	40"	.0024"	20"	90"	.0047"	45"
NOT AVAILABLE ~~RC-1149~~	60°	1	18,000	40"	.0024"	20"	40"	.0024"	20"	40"	.0024"	20"	90"	.0047"	45"	40"	.0024"	20"	90"	.0047"	45"
RC-1148/-M	60°	1	18,000	40"	.0024"	20"	40"	.0024"	20"	40"	.0024"	20"	90"	.0047"	45"	40"	.0024"	20"	90"	.0047"	45"
RC-1048	70°	1	18,000	40"	.0024"	20"	40"	.0024"	20"	40"	.0024"	20"	90"	.0047"	45"	40"	.0024"	20"	90"	.0047"	45"
RC-1072	72°	1	18,000	40"	.0024"	20"	40"	.0024"	20"	40"	.0024"	20"	90"	.0047"	45"	40"	.0024"	20"	90"	.0047"	45"
NOT AVAILABLE ~~RC-1141~~	90°	1	18,000	40"	.0024"	20"	40"	.0024"	20"	40"	.0024"	20"	90"	.0047"	45"	40"	.0024"	20"	90"	.0047"	45"
RC-1102	90°	1	18,000	40"	.0024"	20"	40"	.0024"	20"	40"	.0024"	20"	90"	.0047"	45"	40"	.0024"	20"	90"	.0047"	45"
RC-1142 ⚠	90°	1	18,000	40"	.0024"	20"	40"	.0024"	20"	40"	.0024"	20"	90"	.0047"	45"	40"	.0024"	20"	90"	.0047"	45"
RC-1030	90°	1	18,000	40"	.0024"	20"	40"	.0024"	20"	40"	.0024"	20"	80"	.0047"	40"	40"	.0024"	20"	80"	.0047"	40"
RC-1034	90°	1	18,000	40"	.0024"	20"	40"	.0024"	20"	40"	.0024"	20"	80"	.0047"	40"	40"	.0024"	20"	80"	.0047"	40"
RC-1100	91°	1	18,000	40"	.0024"	20"	40"	.0024"	20"	40"	.0024"	20"	90"	.0047"	45"	40"	.0024"	20"	90"	.0047"	45"
NOT AVAILABLE ~~RC-1140~~	91°	1	18,000	40"	.0024"	20"	40"	.0024"	20"	40"	.0024"	20"	90"	.0047"	45"	40"	.0024"	20"	90"	.0047"	45"
RC-1028	91°	1	18,000	40"	.0024"	20"	40"	.0024"	20"	40"	.0024"	20"	80"	.0047"	40"	40"	.0024"	20"	80"	.0047"	40"
RC-1103	100°	1	18,000	40"	.0024"	20"	40"	.0024"	20"	40"	.0024"	20"	90"	.0047"	45"	40"	.0024"	20"	90"	.0047"	45"
RC-1105	110°	1	18,000	40"	.0024"	20"	40"	.0024"	20"	40"	.0024"	20"	90"	.0047"	45"	40"	.0024"	20"	90"	.0047"	45"
RC-1146	120°	1	14,000	90"	.0024"	90"	90"	.0024"	90"	90"	.0024"	90"	180"	.0048"	180"	90"	.0024"	90"	180"	.0048"	180"
RC-1104	120°	2	18,000	90"	.0024"	45"	90"	.0024"	45"	90"	.0024"	45"	180"	.0048"	90"	90"	.0024"	45"	180"	.0048"	90"
RC-1029	120°	2	15,000	70"	.0024"	35"	70"	.0024"	35"	70"	.0024"	35"	150"	.0047"	75"	70"	.0024"	35"	140"	.0047"	70"
RC-1107	130°	2	18,000	90"	.0024"	45"	90"	.0024"	45"	90"	.0024"	45"	180"	.0048"	90"	90"	.0024"	45"	180"	.0048"	90"
RC-1135	135°	2	18,000	90"	.0024"	45"	90"	.0024"	45"	90"	.0024"	45"	180"	.0048"	90"	90"	.0024"	45"	180"	.0048"	90"
RC-1110	140°	2	18,000	90"	.0024"	45"	90"	.0024"	45"	90"	.0024"	45"	180"	.0048"	90"	90"	.0024"	45"	180"	.0048"	90"
RC-1111	140°	2	16,000	80"	.0024"	40"	80"	.0024"	40"	80"	.0024"	40"	160"	.0048"	80"	80"	.0024"	40"	160"	.0048"	80"
NOT AVAILABLE ~~RC-1101~~	150°	1	14,000	90"	.0024"	90"	90"	.0024"	90"	90"	.0024"	90"	180"	.0048"	180"	90"	.0024"	90"	180"	.0048"	180"
RC-1106	150°	2	18,000	90"	.0024"	45"	90"	.0024"	45"	90"	.0024"	45"	180"	.0048"	90"	90"	.0024"	45"	180"	.0048"	90"
RC-1109	160°	2	18,000	90"	.0024"	45"	90"	.0024"	45"	90"	.0024"	45"	180"	.0048"	90"	90"	.0024"	45"	180"	.0048"	90"

* **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)

⚠ **Attention:** Item #RC-1142, when using on small, hobby type CNC machines, set RPM to 12,000 RPM with 30% slower feed rate.

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