



Carbide Tipped 2 Flute Bottom Cleaning / Spoilboard 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
45560	3/4"	1/4"	250" / 0.0069"	100" / 0.0029"	200" / 0.0058"	120" / 0.0035"
45562	3/4"	1/2"	290" / 0.0079"	120" / 0.0033"	240" / 0.0066"	140" / 0.0040"
45568	1"	1/4"	70" / 0.0020"	30" / 0.0008"	60" / 0.0017"	40" / 0.0010"
45564	1"	1/2"	100" / 0.0029"	40" / 0.0012"	90" / 0.0024"	50" / 0.0014"
45571	1-1/4"	1/4"	70" / 0.0020"	30" / 0.0008"	60" / 0.0017"	40" / 0.0010"
45569	1-1/2"	1/4"	70" / 0.0020"	30" / 0.0008"	60" / 0.0017"	40" / 0.0010"
45566	1-1/2"	1/2"	70" / 0.0020"	30" / 0.0008"	60" / 0.0017"	40" / 0.0010"

*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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