



**Carbide Tipped "Zero-Point" V-Groove Router Bits**  
Operating RPM: 18,000

<b>Hardwood</b>	<b>Softwood</b>	<b>Plastic</b>	<b>Plywood</b>	<b>MDF</b>
<b>IPM* / Chip Load Per Tooth</b>	<b>IPM* / Chip Load Per Tooth</b>	<b>IPM* / Chip Load Per Tooth</b>	<b>IPM* / Chip Load Per Tooth</b>	<b>IPM* / Chip Load Per Tooth</b>
90" / 0.0024"	90" / 0.0024"	90" / 0.0024"	90" / 0.0024"	180" / 0.0048"

\*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)

**Depth of Cut:** 1 x D Use recommended chip load  
2 x D Reduce chip load by 25%  
3 x D Reduce chip load by 50%

**Disclaimer:** These values are based on test results using 18,000 RPM. Your results may vary. It is important to understand that these values are only recommendations.

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