



**Composite, Fiberglass & Phenolic Cutting Spektra™ Extreme Tool Life Coated Router Bits**  
 Operating RPM: 18,000

**Chip Load**  
**Per Tooth**  
**#46094-K**  
**1/4" (0.250)**

**Spindle Speed**  
**SFM\***

**Material**

Material	SFM*	Chip Load Per Tooth
Composites	600 - 800	0.003" - 0.005"
Fiberglass	800 - 1,200	0.003" - 0.005"
Phenolic	800 - 1,200	0.003" - 0.005"
Aluminum	600 - 300	0.003" - 0.005"

\* **SFM** Surface feet per minute

Simple Machining Calculations:

To find **RPM**:  $SFM \times 3.82 / \text{diameter of tool}$

To find **SFM**:  $0.262 \times \text{diameter of tool} \times \text{RPM}$

To find **Feed Rate IPM**:  $\text{RPM} \times \# \text{ of flutes} \times \text{chip load}$

To find **Chip Load**:  $\text{Feed Rate IPM} / (\text{RPM} \times \# \text{ of Flutes})$

**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:** It is important to understand that these values are only recommendations.

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