Amana Tool®

Polycrystalline Diamond (PCD) CNC Straight Plunge Router Bit
Operating RPM: 18,000

Tool No.	Diameter	No. Teeth	Chip Load Per Tooth (Inches Per Minute)			
			MDF	Chipboard	Wood	Aluminum
DRB-421	1/4" (6.35mm)	1	100"	110"	120"	120"
DRB-422	3/8" (9.5mm)	1	100"	110"	120"	120"
DRB-423	1/2" (12.7mm)	2	100"	110"	200"	200"

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%