Amana Tool®

INDUSTRIAL

Solid Carbide Slow Spiral Single and Double 'O' Flute Acrylic Cutting Router Bits

Operating RPM: 18,000 / **Depth of Cut:** 1 x Tool Diameter †

Diameter	Feed Rate IPM*	Chip Load Per Tooth	Ramp Down
Single Flute			
1/4" (0.250)	145" - 180"	0.008" - 0.010"	145" - 180"
2 Flute			
1/4" (0.250)	290" - 360"	0.008" - 0.010"	145" - 180"
1/2" (0.500)	430" - 500"	0.012" - 0.014"	215" - 250"
3 Flute			
3/8" (0.375)	210" - 320"	0.004" - 0.006"	70" - 107"
1/2" (0.500)	320" - 430"	0.006" - 0.008"	107" - 143"

Tool Reference #'s			
Tool No.		Flutes	Dia.
Up-Cut	Down-Cut		
46327	46427	1	1/4"
46313	46413	2	1/4"
46311	46411	2	1/4"
51892	–	2	1/4"
46391	46492	2	1/2"
–	46430	3	3/8"
46330	46431	3	3/8"
46332	46432	3	1/2"
46334	46434	3	1/2"

***IPM:** Inches Per Minute

† Depth of Cut: 1 x D Use recommended feed rate
2 x D Reduce feed rate by 25%
3 x D Reduce feed rate by 50%

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.