Amana Tool®

INDUSTRIAL

Solid Carbide Spiral Plunge For Solid Wood
2 Flute Router Bits

Operating RPM: 18,000

Diameter	(Chip Load Per Tooth) Softwood/Hardwood
2 Flute	
1/8" (0.125)	0.003" - 0.005"
3/16" (0.1875)	0.004" - 0.006"
7/32" (0.21875)	0.004" - 0.006"
1/4" (0.25)	0.005" - 0.007"
5/16" (0.3125)	0.005" - 0.007"
3/8" (0.375)	0.006" - 0.008"
1/2" (0.50)	0.007" - 0.009"

Tool Reference #'s		
Up-Cut	Down-Cut	Dia.
2 Flute		
46240	46340	1/8"
46241	46341	1/8"
46245	46345	3/16"
46247	—	7/32"
46248	46348	1/4"
46249	46349	1/4"
46250	—	1/4"
46253	46353	5/16"
46257	46357	3/8"
46259	46359	3/8"
46261	46361	1/2"
46263	46363	1/2"
—	46365	1/4"

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.