Amana Tool®

INDUSTRIAL

Solid Carbide Plastic Cutting Spiral Single & Double 'O' Flute 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			
1/8" (0.125)	50"	0.003"	50"
3/16" (0.1875)	60"	0.003"	60"
1/4" (0.250)	70"	0.004"	70"
3/8" (0.375)	80"	0.004"	80"
2 Flute			
1/8" (0.125)	110	0.003"	55"
3/16" (0.1875)	120	0.003"	60"
1/4" (0.250)	130	0.004"	65"
1/2" (0.500)	220	0.006"	110"

Tool Reference #'s		
Tool No.	Flutes	Dia.
43500	1	1/8"
43501	1	1/8"
43502	1	1/8"
43503	1	1/8"
43504	1	3/16"
43508	1	1/4"
43512	1	1/4"
43518	1	3/8"
43507	2	1/8"
43600	2	1/8"
43604	2	3/16"
43607	2	1/4"
43608	2	1/4"
43616	2	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.