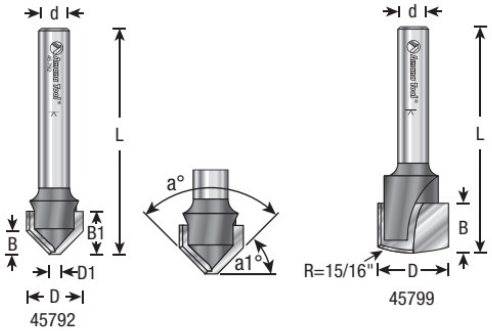
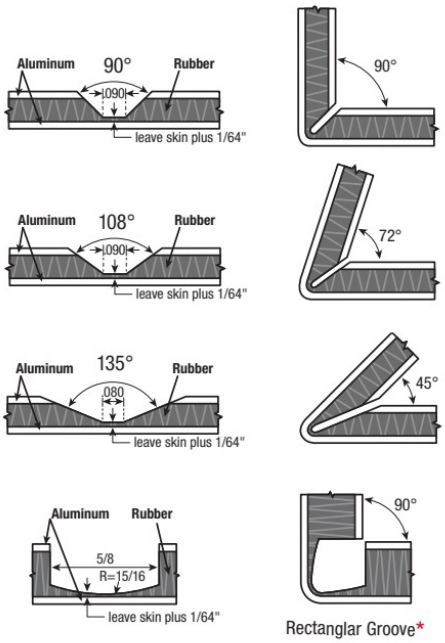
INDUSTRIAL

ACM

Aluminum Composite Material

Router Bits





* For rectangular grooves in thicker material like Alucore®

ACM DOUBLE EDGE FOLDING

Carbide Tipped • V-Groove

Designed for shaping Aluminum Composite (sandwich) Materials with 90°, 108°, 135°, and 155° angle V-grooves with flat bottom. Ideal for wall panel fabrication. Widely used for cladding many diverse exterior and interior applications. The long lasting durablility of the material makes it an excellent choice for buildings, signage, displays, etc. Routing V-shaped grooves, whereby the aluminum cover and a part of the polyethylene core is removed, allows for folding the remaining material.

For Scoring Aluminum Composite Materials Including:

- Aluminum, Clay, Zinc & Wood Composite Panels
- Aluminum Composite Material (ACM)
- Aluminum Composite Panel (ACP)
- ALPOLIC® Copper Composite Material (CCM)
- Alucobond®
- Alupanel®
- Dibond®
- Durabond
- e-panel™
- Etalbond®
- PE and FR Cores
- Phenolics
- Plastic/Acrylic
- Plexiglas®
- Titanium Composite Material (TCM)
- Wood

a°	a1°	ØD	ØD1	B	B1	Ød	L	Tool No.
90°	45°	1/2	0.090 (2.3mm)	13/64	3/8	1/4	2	45792
90°	45°	1/2	0.090 (2.3mm)	13/64	3/8	6mm	2	45792-M
90°	45°	1/2	0.090 (2.3mm)	13/64	3/8	1/2	2	45794
90°	45°	3/4	0.118 (3.0mm)	5/16	17/32	1/4	2-1/8	45793
108°	36°	1/2	0.090 (2.3mm)	5/32	3/8	1/4	2	45795
108°	36°	1/2	0.090 (2.3mm)	5/32	3/8	1/2	2-3/64	45797
108°	36°	1/2	0.090 (2.3mm)	5/32	3/8	1/2	3	45736
108°	36°	3/4	0.090 (2.3mm)	15/64	3/8	1/2	2-3/8	45735 New
135°	22.5°	3/4	0.078 (2.0mm)	9/64	1/2	1/4	2-1/4	45798
135°	22.5°	3/4	0.078 (2.0mm)	1/8	1/2	1/2	2-1/2	45791
155°	12.5°	3/4	0.118 (3.0mm)	1/8	1/2	1/2	2-1/2	45737 New
—	—	5/8	—	7/16	—	1/4	2	45799 *

Packs

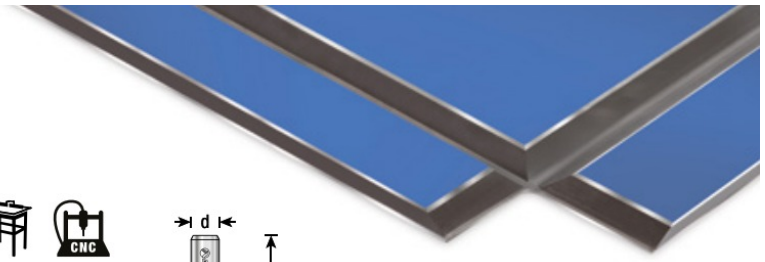
Includes 45792, 45795 & 45798 (1/4 shank)	AMS-140
Includes 45794, 45797 & 45791 (1/2 shank)	AMS-147

PCD Polycrystalline Diamond

Excellent cutting surfaces and extremely long life. Good for scoring above materials. Also optimal for panels with mineral core which may meet fire regulations.

a°	a1°	ØD	ØD1	B	B1	Ød	L	Tool No.
90°	45°	1/2	0.090 (2.3mm)	13/64	3/8	1/4	2	DRB-450

CNC feed and speed available online



ZrN COATED

ACM DOUBLE EDGE FOLDING

Carbide (Brazed to Steel Shank) V-Groove

Designed For Scoring Aluminum Composite Materials

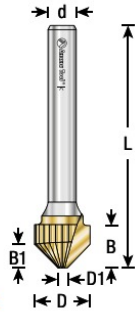
For material cut list visit www.amanatool.com.

a°	a1°	ØD	ØD1	B	B1	Ød	L	Tool No.
90°	45°	1/2	0.090 (2.3mm)	3/8	13/64	1/4	2-1/8	45745
90°	45°	1/2	0.090 (2.3mm)	3/8	13/64	1/2	2-3/8	45747
108°	36°	1/2	0.090 (2.3mm)	3/8	5/32	1/4	2-1/8	45781
108°	36°	1/2	0.090 (2.3mm)	3/8	5/32	1/2	2-3/8	45785
135°	22.5°	3/4	0.078 (2.0mm)	1/2	1/8	1/4	2-1/4	45741
135°	22.5°	3/4	0.078 (2.0mm)	1/2	1/8	1/2	2-1/2	45743

Sets

3-Pc Set includes 45745 (90°), 45781 (108°) & 45741 (135°) (1/4 Shank)	AMS-218 New
3-Pc Set includes 45745 (90°), 45795 (108°) & 51402-Z (1/4 Shank)	AMS-213 New
3-Pc Set includes 45747 (90°), 45785 (108°) & 45743 (135°) (1/2 Shank)	AMS-219 New

Tools are manufactured with high balance, that allows them to run up to 60,000 RPM. Adjust your chip load and feed rate accordingly. See page 8 for cut illustrations.



Benefits of ZrN Coating:

- Creates a harder and tougher cutting edge
- Allows for a prolonged cutting edge life
- Helps to prevent the build-up of material in the flutes while cutting

AlTiN COATED BITS

SCM DOUBLE EDGE FOLDING

Carbide (Brazed to Steel Shank) V-Groove

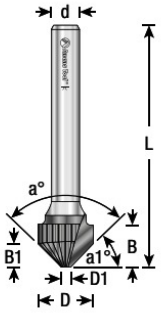
Special Amana-grade carbide provides much longer tool life especially compared to carbide tipped tooling.

For Scoring Steel and Titanium Composite Materials:

- Metal Composite Material (MCM)
- Steel Composite Material (SCM)
- Titanium Composite Material (TCM)

a°	a1°	ØD	ØD1	B	B1	Ød	L	Tool No.
90°	45°	1/2	0.090 (2.3mm)	3/8	13/64	1/4	2-1/8	45762
90°	45°	1/2	0.090 (2.3mm)	3/8	13/64	1/2	2-3/8	45778
108°	36°	1/2	0.090 (2.3mm)	3/8	5/32	1/4	2-1/8	45749

See previous page for cut illustrations.



Benefits of AlTiN Coating:

- Extra wear resistance
- Allows for faster feed & speed rates
- Cutting edge protected from wear
- Better chip evacuation
- Superior cut quality & extended tool life

Set AMS-151
See page 72

ACM Saw Blades
See page 338-339

CNC ACM DOUBLE EDGE FOLDING

Insert Carbide • V-Groove for Shaping Composite Material Panels

Special Amana-grade insert carbide provides much longer tool life especially compared to carbide tipped tooling.

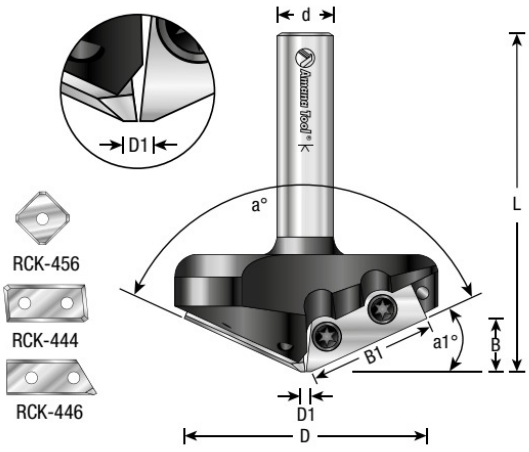
For Scoring Aluminum Composite Materials Including:

- Aluminum, Clay, Zinc & Wood Composite Panels
- ACM
- ACP
- CCM
- Alucobond®
- Alupanel®
- Dibond®
- Durabond
- e-panel™
- Etalbond®
- PE and FR Cores
- Phenolics
- Plastic/Acrylic
- Plexiglas®
- SCM
- TCM
- Wood

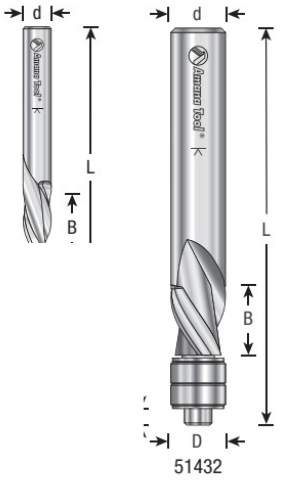
ØD	ØD1	a°	a1°	B	B1	Flute	Ød	L	Repl. Knives	Tool No.
43/64	0.090	90°	45°	19/64	—	2	1/4	2-9/32	RCK-456	RC-45716
43/64	0.090	90°	45°	19/64	—	2	1/2	2-9/32	RCK-456	RC-45714
1-1/2	0.090	90°	45°	45/64	1	1	1/2	3	RCK-442	RC-1172
1-47/64	2mm	110°	35°	37/64	1	1	1/2	3-5/32	RCK-444	RC-1175
2-1/8	3mm	130°	25°	15/32	1-7/64	2	1/2	3	RCK-446	RC-1177

Optional knives for RC-1175: General Purpose #RCK-119; MDF #RCK-352.
Optional knives for RC-1177: General Purpose #RCK-136; MDF #RCK-353.
Visit www.amanatool.com for technical details and a complete list of replacement parts.

See page 8 for cut illustrations.



CNC feed and speed available online



51432

INVECTRA™

ALUMINUM LAMINATE TRIM

Solid Carbide Spiral • 2 Flute with Ball Bearing Guide

Designed and tested for trimming all decorative aluminum laminates manufactured by Formica®, Advanced Technology Inc. (ATI™), DecoMetal® and many others. Engineered from our exclusive carbide grade designed specifically for cutting both aluminum laminates and wood-based substrate materials. Each bit is fitted with a steel bearing guide that enables users to trim laminate materials flush, allowing you to perform any metal trim job to perfection! Not for use on stainless steel.

ØD	B	Ød	L	L1	Tool No.
1/4	5/8	1/4	2-1/2	—	51430* ⚠28
1/2	5/8	1/2	3-1/2	5/32	51432* ⚠14

#51430 Replacement bearing #47723 (2), lock ring #47779.
#51432 Replacement bearing #47701 (2), lock ring #47752, replacement washer #67053.

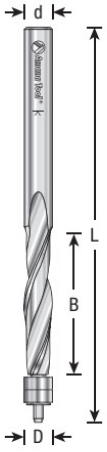
* Except material: Formica® #2178

⚠ **Warning:** Maximum RPM ⚠14 =14,000; ⚠28 =28,000

5-Packs Includes	Tool No. New
51430 (5 Pcs. each)	51430-5

With Invectra™ router bits, kitchen fabricators, remodelers and construction workers can perform any kind of cut and trim job in aluminum laminates.


51520 51522 51422 51420
Down-Cut Up-Cut



ALUMINUM CUTTING FLUSH TRIM SPIRAL

Solid Carbide • 2 Flute with Ball Bearing Guide • Up & Down-Cut

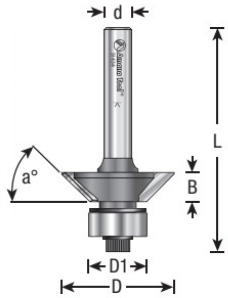
This flush trim router bit was designed to eject chips up for clean cuts in aluminum and ACM materials. Perfect for routing aluminum using a template. Features a special carbide grade to perform high-quality cuts in aluminum.

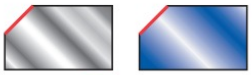
Excellent For Cutting:
- Aluminum
- Aluminum Composite Materials (ACM)
- MDF

ØD	B	Ød	L	'Up-Cut' Tool No.	'Down-Cut' Tool No.
1/4	1/2	1/4	3	51422	51522
1/4	1-1/4	1/4	3-1/2	51420	51520

Replacement parts: Bearing #47723 (2); Snap Ring #47779.


51434-DLC





45° ALUMINUM & PLASTIC CUTTING BEVEL TRIM

Carbide Tipped • 2 Flute

For bevel trimming in aluminum and plastic with a standard router. The solid construction reduces vibration for the smoothest cut possible with a two flute bit.

ØD	D1	a°	B	Ød	L	Tool No.
31/32	1/2	45°	1/4	1/4	1-15/16	51434
31/32	1/2	45°	1/4	1/4	1-15/16	51434-DLC*

* Diamond-Like Carbon (DLC) is a low-friction coating for aluminum and aluminum alloys with a longer tool edge life.

Replacement bearing #47706.

Note: Start at 12,000 RPM, inspect result, and increase the speed for a better surface, if necessary.