Amana Tool®

INDUSTRIAL

6 Flute Solid Carbide ZrN Coated CNC Honeycomb Hogger Router Bits

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

	Tool Reference #'s	40304		46306 / 40305		46305		46309	
	Diameter	Ø1/8" (0.125)		Ø1/4" (0.250)		Ø3/8" (0.375)		Ø1/2" (0.500)	
Material	**Spindle Speed SFM***	**Feed Rate IPM****	**Chip Load Per Tooth**	**Feed Rate IPM****	**Chip Load Per Tooth**	**Feed Rate IPM****	**Chip Load Per Tooth**	**Feed Rate IPM****	**Chip Load Per Tooth**
Aluminum Honeycomb	800 - 1,200	320" - 540"	0.003" - 0.005"	650" - 1000"	0.006" - 0.009"	750" - 1100"	0.007" - 0.010"	650" - 1000"	0.006" - 0.009"
Aramid Honeycomb	1,200 - 1,600	210" - 430"	0.002" - 0.004"	320" - 650"	0.003" - 0.006"	550" - 900"	0.005" - 0.008"	1000" - 1400"	0.009" - 0.013"
Carbon Laminates (Nomex, Kevlar)	1,100 - 1,400	210" - 430"	0.002" - 0.004"	320" - 650"	0.003" - 0.006"	550" - 900"	0.005" - 0.008"	320" - 650"	0.003" - 0.006"
Tedlar	1,400 - 1,600	110" - 320"	0.001" - 0.003"	110" - 430"	0.001" - 0.004"	210" - 540"	0.002" - 0.005"	110" - 430"	0.001" - 0.004"

***SFM** Surface feet per minute
****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.

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