



**Solid Carbide Spektra™ Extreme Tool Life Coated V-Groove Router Bits**  
Operating RPM: 18,000

<b>Hardwood</b>	<b>Softwood</b>	<b>Plastic</b>	<b>Plywood</b>	<b>MDF</b>
<b>IPM* / Chip Load Per Tooth</b>	<b>IPM* / Chip Load Per Tooth</b>	<b>IPM* / Chip Load Per Tooth</b>	<b>IPM* / Chip Load Per Tooth</b>	<b>IPM* / Chip Load Per Tooth</b>
90" / 0.0024"	90" / 0.0024"	90" / 0.0024"	90" / 0.0024"	180" / 0.0048"

\*IPM: Inches Per Minute

Simple Machining Calculations:

To find **RPM**:  $(\text{SFM} \times 3.82) / \text{diameter of tool}$

To find **SFM**:  $0.262 \times \text{diameter of tool} \times \text{RPM}$

To find **Feed Rate IPM**:  $\text{RPM} \times \# \text{ of flutes} \times \text{chip load}$

To find **Chip Load**:  $\text{Feed Rate IPM} / (\text{RPM} \times \# \text{ of Flutes})$

**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:** It is important to understand that these values are only recommendations.

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