



**Mini Insert Carbide 2+2 Spoilboard Surfacing, Rabbeting,
Flycutter, Slab Leveler & Surface Planer Router Bits**
(Max Cutting Depth Per Pass 1/4")

Tool No.	Plywood/Chipboard RPM* / IPM** / Chip Load Per Tooth	Hardwood RPM* / IPM** / Chip Load Per Tooth	MDF RPM* / IPM** / Chip Load Per Tooth	Softwood RPM* / IPM** / Chip Load Per Tooth	Plastic RPM* / IPM** / Chip Load Per Tooth
RC-2239	18,000 / 110" / 0.0032"	18,000 / 100" / 0.0026"	18,000 / 190" / 0.0053"	18,000 / 220" / 0.0063"	18,000 / 150" / 0.0042"
RC-2247	18,000 / 290" / 0.0081"	18,000 / 240" / 0.0067"	18,000 / 480" / 0.014"	18,000 / 600" / 0.016"	18,000 / 380" / 0.0011"
RC-2249	18,000 / 110" / 0.0032"	18,000 / 100" / 0.0026"	18,000 / 190" / 0.0053"	18,000 / 220" / 0.0063"	18,000 / 150" / 0.0042"
RC-2253	18,000 / 340" / 0.0097"	18,000 / 290" / 0.0081"	18,000 / 600" / 0.016"	18,000 / 350" / 0.0097"	18,000 / 460" / 0.013"
RC-2250	18,000 / 290" / 0.0081"	18,000 / 240" / 0.0067"	18,000 / 480" / 0.014"	18,000 / 600" / 0.016"	18,000 / 380" / 0.0011"

*RPM: Revolutions Per Minute

**IPM: Inches Per Minute

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 / # of flutes

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

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