



2 Flute Carbide Tipped Amerock Hinge Router Bit

CNC Operating Spindle Speed: 18,000 RPM

| Diameter | Softwood | | | Hardwood | | | MDF | | | Plywood | | |
|----------|--------------------|------------------------|--------------|--------------------|------------------------|--------------|--------------------|------------------------|--------------|--------------------|------------------------|--------------|
| | Feed Rate IPM * | Chip Load Per Tooth | Ramp Down | Feed Rate IPM * | Chip Load Per Tooth | Ramp Down | Feed Rate IPM * | Chip Load Per Tooth | Ramp Down | Feed Rate IPM * | Chip Load Per Tooth | Ramp Down |
| 1-1/8" | 110" | .0031" | 55" | 50" | .0014" | 25" | 100" | .0029" | 50" | 60" | .0017" | 30" |

| | |
|--------------------|--------|
| Tool Reference #'s | |
| 48101 | 1-1/8" |

* **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 IPM / # of flutes

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

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