



INDUSTRIAL

Carbide Tipped V-Groove Router Bits
Operating RPM: 18,000

Hardwood	Softwood	Plastic	Plywood	MDF
IPM* / Chip Load Per Tooth	IPM* / Chip Load Per Tooth	IPM* / Chip Load Per Tooth	IPM* / Chip Load Per Tooth	IPM* / Chip Load Per Tooth
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**: (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)

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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