Amana Tool®

INDUSTRIAL

Solid Carbide Spiral Flute Roughing
3 Flute Router Bits

Operating RPM: 18,000

Tool No. Up-Cut / Down-Cut	Diameter	(Chip Load Per Tooth) MDF	Veneered Plywood	Wood
46129 / 46223	**3/8" (0.375)**	0.012" - 0.014"	0.014" - 0.016"	0.013" - 0.015"
46124 / 46224	**1/2" (0.50)**	0.014" - 0.016"	0.016" - 0.018"	0.015" - 0.017"
46126 / 46226	**1/2" (0.50)**	0.016" - 0.018"	0.015" - 0.017"	0.014" - 0.016"
46130	**3/4" (0.75)**	0.018" - 0.020"	0.019" - 0.021"	0.019" - 0.021"

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: These values are based on test results using 18,000 RPM. Your results may vary. It is important to understand that these values are only recommendations.