



THE EXTREMELY FAST CNC NESTING BIT

## In-Presta™ 3 Flute Solid Carbide Cutting Edge Straight Plunge High Production Router Bit

CNC Operating Spindle Speed: 18,000 RPM / Depth of Cut: 1/4" Depth Per Pass † / Ramp Down: 50%

Tool No.	Diameter	Shank	Particle Board, MDF & Melamine	Plywood
			IPM* / Chip Load Per Tooth	IPM* / Chip Load Per Tooth
45508-3	1/4"	1/2"	800" / 0.014"	500" / 0.009"

\*IPM: Inches Per Minute

- † Depth of Cut: 1 x D Use recommended feed rate  
2 x D Reduce feed rate by 25%  
3 x D Reduce feed rate by 50%

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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