Amana Tool®

INDUSTRIAL

High Speed Steel (HSS) Single & Double Flute Aluminum Cutting Router Bits

Up-Cut Tool No.	Down-Cut Tool No.	Max RPM	Flutes	Chip Load Per Tooth (1D Cutting Length) Soft Wood	Hard Wood	Aluminum
HSS1620	—	18,000	1	0.008" - 0.010"	0.006" - 0.008"	0.004" - 0.006"
HSS1621	—	18,000	1	0.008" - 0.010"	0.006" - 0.008"	0.004" - 0.006"
HSS1622	—	18,000	1	0.008" - 0.010"	0.006" - 0.008"	0.004" - 0.006"
—	HSS1628	18,000	1	0.008" - 0.010"	0.006" - 0.008"	0.004" - 0.006"
HSS1623	—	18,000	1	0.008" - 0.010"	0.006" - 0.008"	0.004" - 0.006"
—	HSS1629	18,000	1	0.008" - 0.010"	0.006" - 0.008"	0.004" - 0.006"
HSS1624	—	16,000	1	0.004" - 0.006"	0.008" - 0.010"	0.006" - 0.008"
HSS1625	—	16,000	1	0.004" - 0.006"	0.008" - 0.010"	0.006" - 0.008"
HSS1626	—	16,000	1	0.004" - 0.006"	0.008" - 0.010"	0.006" - 0.008"
HSS1627	—	16,000	1	0.005" - 0.007"	0.007" - 0.009"	0.007" - 0.009"
—	HSS1650	18,000	2	0.006" - 0.008"	0.005" - 0.007"	0.002" - 0.004"
HSS1630	—	18,000	2	0.006" - 0.008"	0.005" - 0.007"	0.002" - 0.004"
HSS1631	HSS1651	18,000	2	0.005" - 0.007"	0.005" - 0.007"	0.001" - 0.003"
HSS1632	—	18,000	2	0.006" - 0.008"	0.005" - 0.007"	0.001" - 0.003"
HSS1633	HSS1652	18,000	2	0.006" - 0.008"	0.005" - 0.007"	0.002" - 0.004"
HSS1634	HSS1653	18,000	2	0.006" - 0.008"	0.005" - 0.007"	0.002" - 0.004"
HSS1635	HSS1654	16,000	2	0.006" - 0.008"	0.005" - 0.007"	0.002" - 0.004"
HSS1636	HSS1655	18,000	2	0.006" - 0.008"	0.005" - 0.007"	0.002" - 0.004"
—	HSS1656	18,000	2	0.006" - 0.008"	0.005" - 0.007"	0.002" - 0.004"
HSS1637	HSS1657	16,000	2	0.006" - 0.008"	0.006" - 0.008"	0.002" - 0.004"
HSS1638	—	18,000	2	0.006" - 0.008"	0.006" - 0.008"	0.002" - 0.004"
HSS1639	HSS1658	18,000	2	0.006" - 0.008"	0.006" - 0.008"	0.002" - 0.004"
HSS1640	HSS1659	18,000	2	0.006" - 0.008"	0.006" - 0.008"	0.002" - 0.004"
HSS1641	—	18,000	2	0.007" - 0.009"	0.006" - 0.008"	0.003" - 0.005"
HSS1642	HSS1660	18,000	2	0.007" - 0.009"	0.006" - 0.008"	0.003" - 0.005"
HSS1643		18,000	2	0.007" - 0.009"	0.006" - 0.008"	0.003" - 0.005"
HSS1644	HSS1661	18,000	2	0.008" - 0.010"	0.007" - 0.009"	0.004" - 0.008"
HSS1645	HSS1662	18,000	2	0.008" - 0.010"	0.007" - 0.009"	0.004" - 0.006"
HSS1646	HSS1663	18,000	2	0.010" - 0.012"	0.009" - 0.011"	0.006" - 0.008"

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.