Amana Tool®

Solid Carbide Compression Spiral Single, 2 & 3 Flute Router Bits

Operating RPM: 18,000

INDUSTRIAL

1 Flute

Tool No.	Diameter	Cutting Height	MDF/HDF			Laminate			Melamine			Veneered Plywood			Wood			Oriented Strand Board (OSB)		
			*Feed Rate	Chip Load Per Tooth	*Ramp Down	*Feed Rate	Chip Load Per Tooth	*Ramp Down	*Feed Rate	Chip Load Per Tooth	*Ramp Down	*Feed Rate	Chip Load Per Tooth	*Ramp Down	*Feed Rate	Chip Load Per Tooth	*Ramp Down	*Feed Rate	Chip Load Per Tooth	*Ramp Down
46137	1/8"	3/8"	40	.0021"	20	40	.0021"	20	40	.0021"	20	20	.0011"	10	20	.0011"	10	40	.0021"	20
46139	1/8"	3/8"	40	.0021"	20	40	.0021"	20	40	.0021"	20	20	.0011"	10	20	.0011"	10	40	.0021"	20
46140	1/4"	7/8"	30	.0018"	15	30	.0018"	15	30	.0018"	15	20	.0011"	10	20	.0011"	10	30	.0018"	15
46159	1/2"	1-1/4"	90	.0051"	45	90	.0051"	45	90	.0051"	45	50	.0029"	25	50	.0029"	25	90	.0051"	45
46160	1/2"	1-5/8"	50	.0029"	25	50	.0029"	25	50	.0029"	25	30	.0018"	15	30	.0018"	15	50	.0029"	25

2 Flute

46180	1/8"	13/16"	30	.0009"	15	30	.0009"	15	30	.0009"	15	20	.0005"	10	20	.0005"	10	30	.0009"	15
46183	5/32"	7/8"	40	.0011"	20	40	.0011"	20	40	.0011"	20	20	.0006"	10	20	.0006"	10	40	.0011"	20
46181	3/16"	1"	50	.0015"	25	50	.0015"	25	50	.0015"	25	30	.0008"	15	30	.0008"	15	50	.0015"	25
46170	1/4"	7/8"	60	.0018"	30	60	.0018"	30	60	.0018"	30	30	.0008"	15	30	.0008"	15	60	.0018"	30
46171	3/8"	7/8"	200	.0054"	100	200	.0054"	100	200	.0054"	100	110	.0032"	55	110	.0032"	110	200	.0054"	100
46173	3/8"	1-1/8"	150	.0042"	75	150	.0042"	75	150	.0042"	75	90	.0024"	45	90	.0024"	45	150	.0042"	75
46172	3/8"	1-1/4"	100	.0029"	50	100	.0029"	50	100	.0029"	50	60	.0018"	30	60	.0018"	30	100	.0029"	50
46174	3/8"	1"	170	.0047"	85	170	.0047"	85	170	.0047"	85	100	.0029"	50	100	.0029"	50	170	.0047"	85
46178	3/8"	1-1/8"	150	.0042"	75	150	.0042"	75	150	.0042"	75	90	.0024"	45	90	.0024"	45	150	.0042"	75
46182	1/2"	1"	260	.0072"	130	260	.0072"	130	260	.0072"	130	150	.0042"	75	150	.0042"	75	260	.0072"	130
46186	1/2"	1-1/8"	200	.0056"	100	200	.0056"	100	200	.0056"	100	120	.0033"	60	120	.0033"	60	200	.0056"	100
46188	1/2"	1-1/4"	180	.0050"	90	180	.0050"	90	180	.0050"	90	100	.0029"	50	100	.0029"	50	180	.0050"	90
46189	1/2"	1-1/2"	150	.0042"	75	150	.0042"	75	150	.0042"	75	90	.0024"	45	90	.0024"	45	150	.0042"	75
46191	1/2"	1-1/2"	150	.0042"	75	150	.0042"	75	150	.0042"	75	90	.0024"	45	90	.0024"	45	150	.0042"	75
46190	1/2"	1-5/8"	100	.0029"	50	100	.0029"	50	100	.0029"	50	60	.0018"	30	60	.0018"	30	100	.0029"	50

3 Flute

46011	3/8"	7/8"	300	.0054"	150	300	.0054"	150	300	.0054"	150	170	.0032"	85	170	.0032"	85	300	.0054"	150
46010	3/8"	1-1/8"	230	.0042"	115	230	.0042"	115	230	.0042"	115	130	.0025"	65	130	.0025"	65	230	.0042"	115
46013	1/2"	7/8"	450	.0082"	225	450	.0082"	225	450	.0082"	225	270	.0049"	135	270	.0049"	135	450	.0082"	225
46012	1/2"	1-1/4"	280	.0050"	140	280	.0050"	140	280	.0050"	140	150	.0042"	75	150	.0042"	75	280	.0050"	140
46014	1/2"	1-5/8"	160	.0030"	80	160	.0030"	80	160	.0030"	80	100	.0017"	50	100	.0017"	50	160	.0030"	80

***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 / 2

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