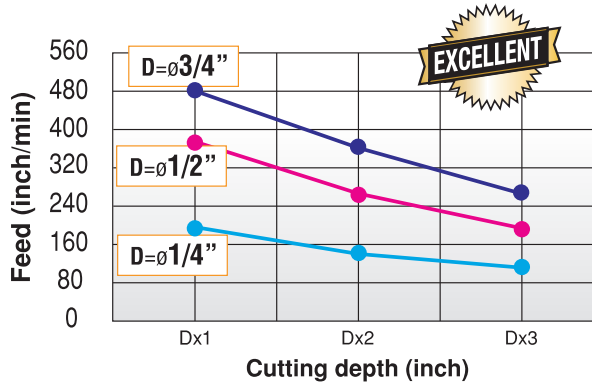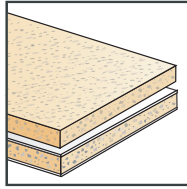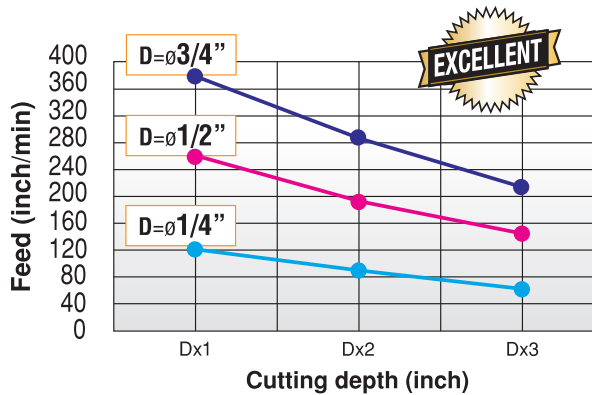# Feed Rates - Solid Carbide Compression Spiral for MDF/Laminate

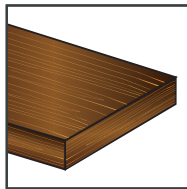**Partical Board Laminate**

Feed (inch/min) vs Cutting depth (inch)

- D=ø3/4"
- D=ø1/2"
- D=ø1/4"

EXCELLENT

Tool Reference #'s
46170
46170-LH
46172
46174
46178
46180
46181
46182
46183
46186
46188
46188-LH
46189
46190
46190-LH
46191

Plywood Veneered Plywood

Feed (inch/min) vs Cutting depth (inch)
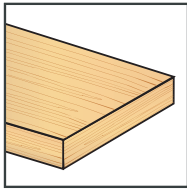
- D=ø3/4"
- D=ø1/2"
- D=ø1/4"

EXCELLENT
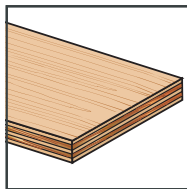
Hardwood

NOT RECOMMENDED X

Amana Tool® doesn't recommend using these Solid Carbide Spiral Flute Plunge router bits on Hardwood.

Softwood

NOT RECOMMENDED X

Amana Tool® doesn't recommend using these Solid Carbide Spiral Flute Plunge router bits on Softwood.

Math For Routers:
To find **Chip Load** = Feed Rate / RPM of spindle x # of cutting edges
To find **Feed Rate** = RPM x # of cutting edges x Chip Load
To find **RPM** = Feed Rate / (Chip Load x # of cutting edges)

Recommended Feed Rate
Because of the dependency which we have between the cutting conditions and the non-uniformity of the wood pieces, it is important to understand that these values are only recommendations. Wood fiber direction, wood type, wood humidity, clamping stiffness, machine stiffness, etc., all these variables together or one by one can change the cutting condition. It is recommended that in any new application, you reach the recommended feed rate gradually and if the cutting quality is OK, you can continue to increase the feed rate values. Please remember, the larger your chip per tip (high feed rate), the lifetime of the tool is increased.

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