



**Solid Carbide 15° Degree 2 Flute V Groove Engraving Router Bits**  
**CNC Operating Spindle Speed: 18,000 RPM / Depth of Cut: 1 x Tool Diameter**

Material	(Tip Width) 0.020" 15°	
	Feed Rate IPM*	Chip Load Per Tooth IPR**
	Soft Wood	50" - 125"
Hard Wood	50" - 125"	0.003" - 0.007"
Soft Plastic	50" - 125"	0.003" - 0.007"
Hard Plastic	50" - 125"	0.003" - 0.007"
Aluminum	50" - 125"	0.003" - 0.007"
Solid Surface	50" - 125"	0.003" - 0.007"

Tool Reference #'s	
	Degree
45628	15°

**IPM\*** Inches per minute  
**IPR\*\*** Inches per revolution

**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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