



Solid Carbide 60° Degree Single & 3 Flute V-Groove, Signmaking & Lettering Router Bits
 CNC Operating Spindle Speed: 18,000 RPM / Cutting Depth: 1/4" Per Pass

Material	Single Flute 60°		3 Flute 60°	
	Feed Rate IPM*	Chip Load Per Tooth IPR**	Feed Rate IPM*	Chip Load Per Tooth IPR**
Soft Wood	50" - 125"	0.003" - 0.007"	50" - 125"	0.001" - 0.002"
Hard Wood	50" - 125"	0.003" - 0.007"	50" - 125"	0.001" - 0.002"
Soft Plastic	50" - 125"	0.003" - 0.007"	50" - 125"	0.001" - 0.002"
Hard Plastic	50" - 125"	0.003" - 0.007"	50" - 125"	0.001" - 0.002"
Aluminum	50" - 125"	0.003" - 0.007"	50" - 125"	0.001" - 0.002"
Solid Surface	50" - 125"	0.003" - 0.007"	50" - 125"	0.001" - 0.002"

Tool Reference #'s	
Single Flute	3 Flute
45731	45730
—	45733

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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