



2 Flute Solid Carbide Spiral Flute Plunge Inlay Router Bits

Operating RPM: 18,000 / Depth of Cut: 1 x Tool Diameter †

Diameter	Softwood / Hardwood / Plywood		Laminate / MDF	
	Feed Rate IPM*	Chip Load Per Tooth	Feed Rate IPM*	Chip Load Per Tooth
2 Flute				
1/32" (0.031)	40" - 110"	0.001" - 0.003"	70" - 140"	0.002" - 0.004"
3/64" (0.046875)	40" - 110"	0.001" - 0.003"	70" - 140"	0.002" - 0.004"
1/16" (0.0625)	70" - 140"	0.002" - 0.004"	140" - 210"	0.004" - 0.006"
3/32" (0.09375)	70" - 140"	0.002" - 0.004"	140" - 210"	0.004" - 0.006"
1/8" (0.125)	110" - 180"	0.003" - 0.005"	180" - 250"	0.005" - 0.007"

Tool Reference #'s	
Down-Cut	Dia.
46227	1/8"
46229	1/32"
46231	3/64"
46237	1/16"
46239	3/32"

*IPM Inches per minute

† **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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