Amana Tool®

Carbide Tipped 2, 3 & 4 Wing Spoilboard Surfacing, Planing & Chamfering Router Bits

CNC Operating Spindle Speed: 18,000 RPM

Feed and Speed based on 1/4" Cutting Depth Per Pass

Tool No.	Diameter	Wings	Plywood/Chipboard IPM* / Chip Load Per Tooth	Hardwood IPM* / Chip Load Per Tooth	MDF IPM* / Chip Load Per Tooth	Softwood IPM* / Chip Load Per Tooth	Plastic IPM* / Chip Load Per Tooth
45522	1"	3-Wing	130" / 0.002"	120" / 0.002"	200" / 0.004"	130" / 0.002"	120" / 0.002"
45528/45529	1-1/4"	2-Wing	130" / 0.002"	120" / 0.002"	200" / 0.004"	130" / 0.002"	120" / 0.002"
45523	28.5mm	3-Wing	130" / 0.002"	120" / 0.002"	200" / 0.004"	130" / 0.002"	120" / 0.002"
45525	1-1/8"	3-Wing	130" / 0.002"	120" / 0.002"	200" / 0.004"	130" / 0.002"	120" / 0.002"
45526	1-1/2"	4-Wing	160" / 0.002"	150" / 0.002"	250" / 0.004"	160" / 0.002"	150" / 0.002"
45527	2"	4-Wing	160" / 0.002"	150" / 0.002"	250" / 0.004"	160" / 0.002"	150" / 0.002"

*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 IPM / # of flutes

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