



2 Flute Carbide Tipped T-Slot Router Bit

Operating RPM: 18,000

Diameter	Feed Rate IPM*	Chip Load Per Tooth
1-3/8"	72"	0.0020"

* IPM: Inches Per Minute

Tool Reference #'s	
Tool No.	Dia.
45671	1-3/8"

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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