



Carbide Tipped V-Groove Router Bits
CNC Operating Spindle Speed: 18,000 RPM

Hardwood	Softwood	Plastic	Plywood	MDF
IPM* / Chip Load Per Tooth				
90" / 0.0024"	90" / 0.0024"	90" / 0.0024"	90" / 0.0024"	180" / 0.0048"

*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 / 2

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

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