



High Polish Surface Finish CNC Flattening Router Bit For Plastics

CNC Operating Spindle Speed: 18,000 RPM / Depth of Cut: 1 x Tool Diameter † / Step Down: 0.02" (0.5mm) / Stepcover: 50%

Tool No.	Diameter	Flute	Acrylic & Other Plastics	
			Feed Rate IPM*	Ramp Down IPM*
43625	1/2"	2	80"	40"

*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.

© Copyright Amana Tool® All Rights Reserved