



**INDUSTRIAL**

**Insert Carbide 2 Flute Ball End Router Bits**  
CNC Operating Spindle Speed: 18,000 RPM / Depth of Cut: 1 x Tool Diameter †

Tool No.	Diameter	Shank	Softwood IPM* / Chip Load Per Tooth	Hardwood IPM* / Chip Load Per Tooth	MDF IPM* / Chip Load Per Tooth	Plywood IPM* / Chip Load Per Tooth
RC-1126	1"	1/2"	70" / 0.0020"	30" / 0.0008"	60" / 0.0017"	40" / 0.001"

\*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.

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