Amana Tool®

Polycrystalline Diamond (PCD) CNC Double Edge Folding 'V' Groove Router Bit
Speed and Feed Chart (Maximum Depth of Cut 1/4")

Tool No. DRB-450			Surface Cutting Speed		Chip Load Per Tooth		RPM		Feed Rate	
Material	**Diameter** Inch/mm	**No. Teeth**	**From** Inch (mm)/min	**To** Inch (mm)/min	**From** Inch (mm)/min	**To** Inch (mm)/min	**From**	**To**	**From** Inch (mm)/min	**To** Inch (mm)/min
Aluminum, Bronze, Copper	1/2" (12.7mm)	2	24" (600mm)	32" (8000mm)	.006" (0.15mm)	.01" (0.25mm)	15,000	20,000	178" (4,514mm)	250" (10,031mm)

Maximum RPM: 20,000

Correction factor for chip load:
0.8 = MDF with or without Coating
1.1 = Chipboard with or without Coating
0.7 = Veneer across grain

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:** RPM x # of flutes x chip load
To find **Maximum Depth of Cut:** .5 x diameter