



Single and 2 Flute Solid Carbide 'O' Flute Plastic Edge Rounding Router Bits

CNC Operating Spindle Speed: 13,000 RPM / Depth of Cut: 1 x Tool Diameter †

Material	1/4" (0.1875") Single Flute	
	Feed Rate IPM*	Chip Load Per Tooth (Based on 13,000 RPM)
Plastic, Acrylics, Acrylic Stone, Corian, Coroplast®, Poly (methyl methacrylate) (PMMA)	70" - 110"	0.004" - 0.008"

Material	1/4" (0.1875") 2 Flute	
	Feed Rate IPM*	Chip Load Per Tooth (Based on 13,000 RPM)
Plastic, Acrylics, Acrylic Stone, Corian, Coroplast®, Poly (methyl methacrylate) (PMMA)	70" - 110"	0.003" - 0.004"

*IPM Inches per minute

Tool Reference #'s	
Single Flute	
46441	1/4" Dia.
46443	1/4" Dia.
46452	1/4" Dia.
46464	1/4" Dia.
46465	1/4" Dia.
46466	1/4" Dia.
2 Flute	
46481	1/4" Dia.
46484	1/4" Dia.
46485	1/4" Dia.

† 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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