



2 Flute Double Edge V-Grooving AlTiN Coated Router Bits with Flat Bottom for SCM Materials

CNC Operating Spindle Speed: 18,000 RPM

Material	Spindle Speed SFM*	< 1/8" (< 3mm)		1/8" - 3/16" (3mm - 5mm)		3/16" - 5/16" (5mm - 8mm)		5/16" - 9/16" (8mm - 14mm)		9/16" - 23/32" (14mm - 18mm)	
		Feed Rate IPM**	Chip Load Per Tooth Based on Depth of Cut	Feed Rate IPM**	Chip Load Per Tooth Based on Depth of Cut	Feed Rate IPM**	Chip Load Per Tooth Based on Depth of Cut	Feed Rate IPM**	Chip Load Per Tooth Based on Depth of Cut	Feed Rate IPM**	Chip Load Per Tooth Based on Depth of Cut
Stainless Steel, Steel, DuraPlate®, Steel Composite Material (SCM) Titanium Composite Material (TCM)	164 - 295	10" - 20"	0.0003" - 0.0005"	15" - 35"	0.0004" - 0.001"	35" - 70"	0.001" - 0.002"	70" - 110"	0.002" - 0.003"	110" - 150"	0.003" - 0.004"

* SFM Surface feet per minute

** IPM Inches per minute

Tool Reference #'s	Angle
45762	90°
45778	90°
45749	108°

- † **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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