



Single & 2 Flute Insert Carbide Straight Plunge Router Bit

CNC Operating Spindle Speed: 18,000 RPM / Depth of Cut: 1 x Tool Diameter †

Tool No.	Diameter	Flute	Softwood		Hardwood		MDF		Plywood	
			Feed Rate IPM*	Chip Load Per Tooth	Feed Rate IPM*	Chip Load Per Tooth	Feed Rate IPM*	Chip Load Per Tooth	Feed Rate IPM*	Chip Load Per Tooth
RC-3100	3/8"	1	100"	0.0056"	50"	0.0028"	100"	0.0056"	60"	0.0032"
RC-3100	1/2"	1	120"	0.0069"	60"	0.0032"	110"	0.0064"	70"	0.0038"
RC-3100	1/2"	2	200"	0.0056"	110"	0.0032"	200"	0.0056"	130"	0.0038"

*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.

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