



Solid Carbide Single Flute Carving Liner Router Bits
CNC Operating Spindle Speed: 18,000 RPM / Depth of Cut: 1 x Tool Diameter †

Tool No.	Diameter	Shank	IPM* / Chip Load
			Per Tooth
40782	1/4"	1/4"	70" - 100" / 0.004" - 0.006"
40784	1/4"	1/4"	70" - 100" / 0.004" - 0.006"
45783	1/4"	1/4"	70" - 100" / 0.004" - 0.006"

*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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