



Solid Carbide Single Flute Spektra™ Extreme Tool Life Coated 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
45783-K	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.

© Copyright Amana Tool® All Rights Reserved