



## 2 Flute Solid Carbide Spektra™ Extreme Tool Life Coated Compression Spiral Router Bits For Baltic Plywood

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

| Axial Depth<br>Of Cut | 46700-K (1/4" Dia.) |                        | 46704-K (3/8" Dia.) |                        | 46706-K (1/2" Dia.) |                        |
|-----------------------|---------------------|------------------------|---------------------|------------------------|---------------------|------------------------|
|                       | Feed Rate<br>IPM *  | Chip Load<br>Per Tooth | Feed Rate<br>IPM *  | Chip Load<br>Per Tooth | Feed Rate<br>IPM *  | Chip Load<br>Per Tooth |
| 1 x Diameter          | 150" - 180"         | .004" - .005"          | 180" - 200"         | .005" - .006"          | 200" - 220"         | .006" - .0065"         |

\*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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