



**INDUSTRIAL**

**Solid Carbide Cutting Edge & Carbide Tipped 2 Flute Straight Plunge High Production Router Bits**  
CNC Operating Spindle Speed: 18,000 RPM / Depth of Cut: 1 x Tool Diameter †

Tool No.	Diameter	Shank	Softwood	Hardwood	MDF	Plywood
			IPM* / Chip Load Per Tooth	IPM* / Chip Load Per Tooth	IPM* / Chip Load Per Tooth	IPM* / Chip Load Per Tooth
45200	1/8"	1/4"	60" / 0.0017"	60" / 0.0017"	120" / 0.0034"	60" / 0.0017"
45210	1/4"	1/4"	110" / 0.0031"	110" / 0.0031"	220" / 0.0062"	110" / 0.0031"

\*IPM: Inches Per Minute

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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