



**Solid Carbide Spektra™ Extreme Tool Life Coated  
Plastic Cutting Spiral Double & Triple 'V' Flute Router Bits**

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

<b>Diameter</b>	<b>Feed Rate IPM*</b>	<b>Chip Load Per Tooth</b>	<b>Ramp Down</b>
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**2 Flute**

<b>1/8" (0.125)</b>	110"	0.003"	55"
<b>1/4" (0.250)</b>	130"	0.004"	65"

**3 Flute**

<b>1/4" (0.250)</b>	180	0.004"	60"
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Tool Reference #'s		
Tool No.	Flutes	Dia.
43507-K	2	1/8"
43506-K	2	1/4"
43600-K	2	1/8"
43607-K	2	1/4"
43608-K	2	1/4"
46483-K	3	1/4"

\* **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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