



**INDUSTRIAL**

**SPEKTRA**  
EXTREME TOOL LIFE COATING

*Mirror*  
**FINISH**

**Solid Carbide Spektra™ Extreme Tool Life Coated  
Solid Carbide Plastic Cutting Spiral Single 'O' Flute For Improved Surface Finish Router Bits  
Operating RPM: 18,000 / Depth of Cut: 1 x Tool Diameter †**

<b>Diameter</b>	<b>IPM at 18,000 RPM</b> (Inches Per Minute)	<b>Spindle Speed SFM</b> (Surface Feet Per Minute)	<b>Chip Load Per Tooth</b>
<b>1/16" (0.0625)</b>	35 - 70	500 - 1,200	0.002" - 0.004"
<b>1/8" (0.125)</b>	70 - 110	500 - 1,200	0.004" - 0.006"
<b>3/16" (0.1875)</b>	110 - 145	500 - 1,200	0.006" - 0.008"
<b>1/4" (0.250)</b>	145 - 220	500 - 1,200	0.008" - 0.012"
<b>3/8" (0.375)</b>	200 - 290	500 - 1,200	0.011" - 0.016"

Tool Reference #'s		
Up-Cut	Down-Cut	Dia.
57360-K	—	1/8"
57361-K	—	1/8"
57362-K	—	1/4"
57363-K	—	1/4"
57364-K	—	1/16"
57365-K	—	1/8"
57366-K	—	3/16"
57367-K	—	1/4"
57368-K	—	3/8"

† **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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