

2 Flute Solid Carbide Spektra™ Extreme Tool Life Coated Spiral Ball Nose for Plastics

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

	3/16"		1/4"	
	Feed Rate IPM*	Chip Load Per Tooth	Feed Rate IPM*	Chip Load Per Tooth
2 Flute	75" - 100"	0.003" - 0.004"	75" - 100"	0.003" - 0.005"

	Tool Reference #'s	
	Dia.	Flutes
46424-K	3/16"	2
46426-K	1/4"	2

* 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