Amana Tool®

INDUSTRIAL

Foam Cutting Spiral Router Bits

Operating RPM: 18,000

Material: Foam

Square End

Tool No.	ØD	Chip Load Per Tooth
46269	1/8	0.002" – 0.004"
46270	1/8	0.002" – 0.004"
46562	1/8	0.002" – 0.004"
46564	1/8	0.002" – 0.004"
46271	3/16	0.002" – 0.004"
46273	3/16	0.002" – 0.004"
46274	1/4	0.004" – 0.006"
46272	1/4	0.004" – 0.006"
46275	1/4	0.004" – 0.006"
46566	1/4	0.004" – 0.006"
46276	5/16	0.004" – 0.006"
46278	3/8	0.004" – 0.006"
46277	3/8	0.004" – 0.006"
46279	3/8	0.004" – 0.006"

Ball End

46030	1/8	0.002" – 0.004"
46032	1/4	0.004" – 0.006"

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:** RPM x # of flutes x chip load
To find **Chip Load:** IPM / (RPM x # of Flutes)

Depth of Cut: 1 x D Use recommended chip load
2 x D Reduce chip load by 25%
3 x D Reduce chip load by 50%

Disclaimer: These values are based on test results using 18,000 RPM. Your results may vary. It is important to understand that these values are only recommendations.