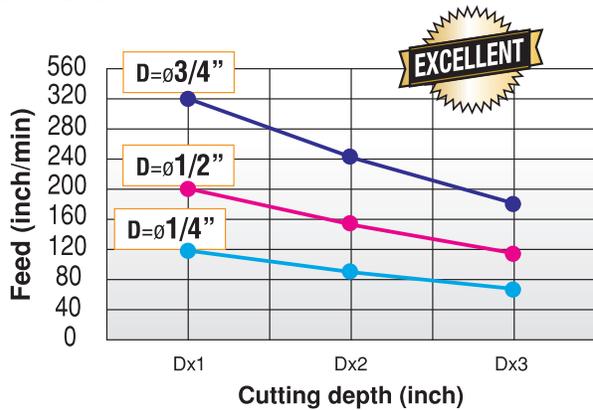


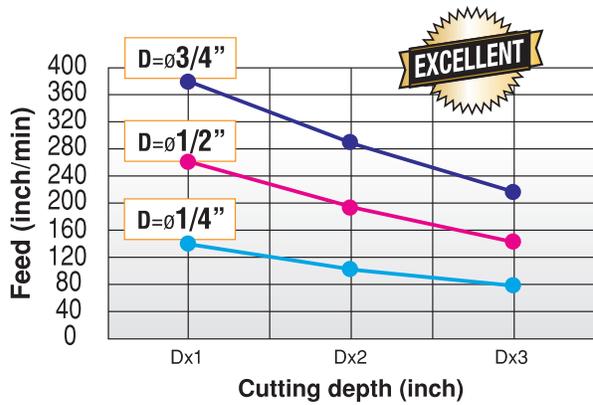
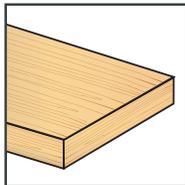
Feed Rates - Solid Carbide Compression Spiral for Solid Wood

Hardwood

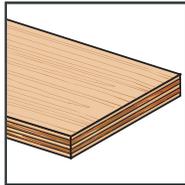


Tool Reference #'s
46322
46324
46326
46328
46342
46344
46390
46392

Softwood



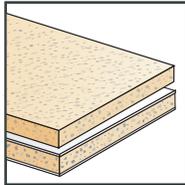
Plywood
Veneered Plywood



NOT RECOMMENDED

Amana Tool® doesn't recommend using these Solid Carbide Spiral Flute Plunge router bits on Plywood.

Particle Board
Laminate



NOT RECOMMENDED

Amana Tool® doesn't recommend using these Solid Carbide Spiral Flute Plunge router bits on Particle Boards.

Math For Routers:

To find **Chip Load** = Feed Rate / RPM of spindle x # of cutting edges

To find **Feed Rate** = RPM x # of cutting edges x Chip Load

To find **RPM** = Feed Rate / (Chip Load x # of cutting edges)

Recommended Feed Rate

Because of the dependency which we have between the cutting conditions and the non-uniformity of the wood pieces, it is important to understand that these values are only recommendations. Wood fiber direction, wood type, wood humidity, clamping stiffness, machine stiffness, etc., all these variables together or one by one can change the cutting condition. It is recommended that in any new application, you reach the recommended feed rate gradually and if the cutting quality is OK, you can continue to increase the feed rate values. Please remember, the larger your chip per tip (high feed rate), the lifetime of the tool is increased.