



**Solid Carbide Spektra™ Extreme Tool Life Coated V-Groove Router Bits**  
 CNC Operating Spindle Speed: 18,000 RPM

<b>Hardwood</b>	<b>Softwood</b>	<b>Plastic</b>	<b>Plywood</b>	<b>MDF</b>
<b>IPM* / Chip Load Per Tooth</b>	<b>IPM* / Chip Load Per Tooth</b>	<b>IPM* / Chip Load Per Tooth</b>	<b>IPM* / Chip Load Per Tooth</b>	<b>IPM* / Chip Load Per Tooth</b>
90" / 0.0024"	90" / 0.0024"	90" / 0.0024"	90" / 0.0024"	180" / 0.0048"

\*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 / 2

**Disclaimer:** It is important to understand that these values are only recommendations.

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