

**From:** Andy Almonte (Support) <ttsupport@toolstoday.com>  
**Sent:** Tuesday, March 19, 2019 6:14 AM  
**To:** gmackelburg  
**Subject:** [Toolstoday] Re: RE: [Toolstoday] Re: Fr Amana

##- Please type your reply above this line -##

Your request (558800) has been updated. To add additional comments, reply to this email.



**Andy Almonte (Toolstoday)**

Mar 19, 10:14 ADT

I agree with the 46102 reference you made.

The max RPM on these tools 28,000



**gmackelburg**

Mar 19, 02:44 ADT

Andy,

I'm thinking that the coated [46102-K](#), since it has 1/3 the recommended Chip Load of the uncoated [46102](#), would be the better choice for me with wood because it would allow me to reduce my cutting power and force by a factor of 3. Do you agree? Can I operate either/both of those products safely at 30,000 RPM - assuming that I maintain the same recommended Chip Loads? How low can I safely go with Chip Loads on these products?

Gerald



**Andy Almonte (Toolstoday)**

Mar 18, 13:36 ADT

The revised feed and speed have changed because now they are based on full depth of cut.

If you provide me with the tool number in questions I can give you some safe starting parameters for you.



**gmackelburg**

Mar 18, 13:19 ADT

Andy,

As I attempted to convey in my email, I'm confused about changes and inconsistencies in Amana's recommended speeds and feeds for their CNC and router bits, not their meaning. I was also hoping to find the maximum safe speed (RPM) for the 1/4 inch and smaller bits as well as their minimum practical Chip Loads so I can utilize Amana bits most effectively and safely with our CNCs routers and router tables.

Gerald



**Andy Almonte (Toolstoday)**

Mar 18, 09:11 ADT

If you are a bit confused with the feed and speed provided then we suggest that you use the following formula:



With the use of this formula you can use your own feed rate and calculate the chip load and rpm



**gmackelburg**

Mar 15, 14:26 ADT

This is a follow-up to your previous request #555982 "Fr Amana"

Eric,

I noticed that depths of cut have now been added to the online 46102-K speeds and feeds chart (<https://www.amanatool.com/pub/media/productattachments/Solid-Carbide-Spektra-Spiral-Plunge-2-3-Flute-v13.pdf>) . But that chart now differs significantly from that for the new uncoated versions' chart (<https://www.amanatool.com/pub/media/productattachments/Solid-Carbide-Spiral-Plunge-2-3-Flute-v19.pdf>) , whereas before it was virtually identical (see attachment). Why?

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The old version seems a lot more reasonable for folks like us using “hobbyist” CNC routers which are primarily limited by force/rigidity. Also, running the bits at the maximum router speed helps to mitigate that shortcoming somewhat. It seems to me that if it’s safe to run a 5/8” bit at 24000 RPM, running a 1/4” bit at 30000 RPM (our maximum router speed and collet capacity). Is that correct? Reducing chip loads to 0.0005” – 0.001” also helps, are the bits sharp enough to permit that?

One of our shop’s router tables uses Porter Cable 6902 router motors (<https://www.portercable.com/products/accessories/woodworking-accessories/specialty-accessories/motors/134-hp-maximum-motor-hp-singlespeed-replacement-motor-for-690-series-routers/6902>), which has a (single) no load speed of 27500 RPM. Is that too fast for “standard” Amana router bits?

Gerald

Attachment(s)

[Amana Speeds and Feeds.pdf](#)