

CNC Router Bits



Spiral & Compression



STRAIGHT PLUNGE



Miter Fold & Signmaking



Chamfering & Profiling



Rabbeting



Door Making



Jointing



Grooving

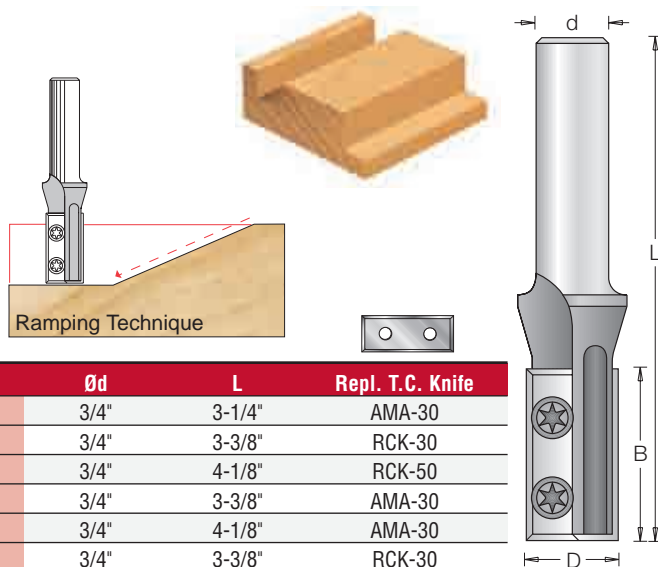


Planing & Hogging

CNC ROUTER BITS

INSERT STRAIGHT ROUTER BIT SINGLE & DOUBLE FLUTE

This group of router bits are not designed to plunge. Using the "ramping technique" the router is eased in and routes. Available in three different grades of carbide for various applications.



ØD	B	Flutes	Tool No.	Ød	L	Repl. T.C. Knife
1/2"	30(1-3/16")	1	RC-2154	3/4"	3-1/4"	AMA-30
5/8"	30(1-3/16")	1	RC-2156	3/4"	3-3/8"	RCK-30
5/8"	50(2")	1	RC-2158	3/4"	4-1/8"	RCK-50
5/8"	30(1-3/16")	2	RC-2080	3/4"	3-3/8"	AMA-30
5/8"	50(2")	2	*RC-2082	3/4"	4-1/8"	AMA-30
3/4"	30(1-3/16")	1	RC-2160	3/4"	3-3/8"	RCK-30
3/4"	50(2")	1	RC-2162	3/4"	4-1/8"	RCK-50
3/4"	30(1-3/16")	2	RC-2084	3/4"	3-3/8"	RCK-30
3/4"	50(2")	2	*RC-2086	3/4"	4-1/8"	RCK-30
7/8"	30(1-3/16")	1	RC-2164	3/4"	3-3/8"	RCK-30
7/8"	50(2")	1	RC-2166	3/4"	4-1/8"	RCK-50
7/8"	30(1-3/16")	2	RC-2088	3/4"	3-3/8"	RCK-30
7/8"	50(2")	2	*RC-2090	3/4"	4-1/8"	RCK-30

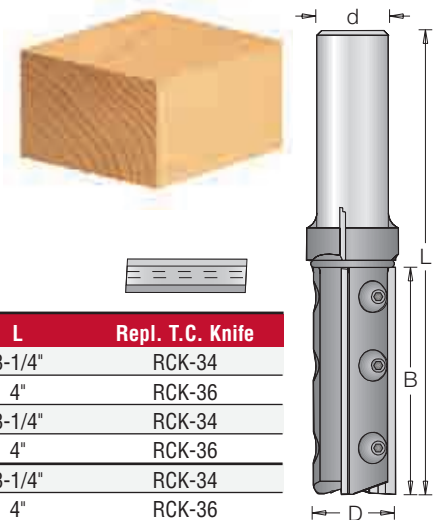
NOTE: All above two flute router bits have two cutting edges per knife.

*50mm cutting edge is achieved using two 30mm staggered knives.

WARNING: Recommended RPM 14,000-18,000

INSERT STRAIGHT ROUTER BIT 2 FLUTE & 3 FLUTE

Tested by many of the world's largest furniture manufacturers, these new CNC router bits yield cuts which are cleaner than typical insert bits. Unlike the other style of straight insert bits this category has a channel whereby the carbide is inserted and tightened. This tool is specifically suited for peripheral work. Available with double and triple flutes.



ØD	B	Flutes	Tool No.	Ød	L	Repl. T.C. Knife
5/8"	30(1-3/16")	2	RC-3204	3/4"	3-1/4"	RCK-34
5/8"	50(2")	2	RC-3208	3/4"	4"	RCK-36
3/4"	30(1-3/16")	2	RC-3260	3/4"	3-1/4"	RCK-34
3/4"	50(2")	2	RC-3264	3/4"	4"	RCK-36
3/4"	30(1-3/16")	3	RC-3300	3/4"	3-1/4"	RCK-34
3/4"	50(2")	3	RC-3304	3/4"	4"	RCK-36
3/4"	30(1-3/16")	3	RC-3305	5/8"	3-1/4"	RCK-34
3/4"	50(2")	3	RC-3307	5/8"	4"	RCK-36

WARNING: Maximum RPM 18,000



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Hogging

CNC Router Bits

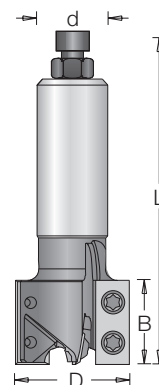


INSERT SUPER PLUNGE ROUTER BIT

This router bit is designed for fast and direct penetration into the material and quick removal of wood, MDF, melamine and man-made material.



ØD	B	Ød	L	Teeth	Tool No.	Repl. T.C. Knife	Repl. T.C. Knife	Max. RPM
40(1-1/2")	29.5(1-5/32")	3/4"	100(4")	2+2	RC-2180	RCK-30	AMA-12	18,000
60(2-3/8")	29.5(1-5/32")	3/4"	100(4")	2+2	RC-2182	RCK-30	ICK-30	18,000



CNC ROUTER BITS

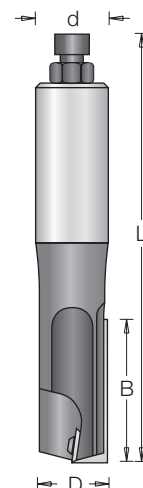
INSERT STRAIGHT ROUTER BIT WITH PLUNGE CENTER TIP

This router bit is designed for fast and direct penetration into the material and quick removal of wood, MDF, melamine and man-made material.



New

ØD	B	Ød	L	Tool No.	Repl. T.C. Knife	Repl. T.C. Knife	Max. RPM
5/8"	30(1-3/16")	1/2"	81(3-3/16")	RC-2063	RCK-35	AMA-12	24,000
18(23/32")	30(1-3/16")	3/4"	105(4-1/8")	RC-2060	RCK-160	RCK-30	18,000
18(23/32")	50(2")	3/4"	125(5")	RC-2062	RCK-162	RCK-50	18,000
<i>New</i> 20(25/32")	30(1-3/16")	3/4"	105(4-1/8")	RC-2061	RCK-160	RCK-30	18,000

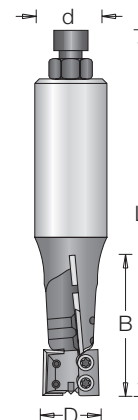


INSERT UP & DOWN SHEAR ROUTER BIT

Insert straight router bit complete with two up/down-shear flutes and center tip. Shear flutes squeeze the material into the middle to give an extra fine finish on both surfaces of laminated and veneered board. Replaceable inserts ensure a constant cutting diameter and finish quality. Center tip for improved boring. For use on routers with CNC control.



ØD	B	Ød	Tool No.	L	Repl. T.C. Knife	Max. RPM
20(25/32")	30(1-3/16")	3/4"	RC-2300	110(4-11/32")	RCK-16	18,000
20(25/32")	50(2")	3/4"	RC-2304	130(5-1/8")	RCK-28	18,000



Wood profiles shown at actual size. 3D renderings & tool illustrations not shown at actual size.

For a complete replacement parts listing for the above cutters please refer to our website: www.amanatool.com



CNC Router Bits



Spiral & Compression



Straight Plunge



Miter Fold & Signmaking



Chamfering & Profiling



Rabbeting



Door Making



Jointing



Grooving

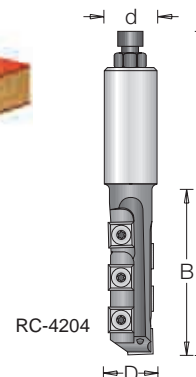


PLANING & HOGGING

CNC ROUTER BITS

INSERT STAGGER-TOOTH ROUTER BIT

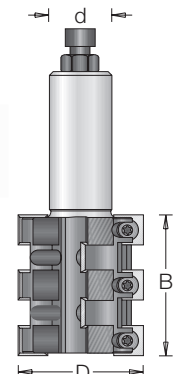
Insert straight router bit complete with two flutes and multiple cutting blades. Blades are sheared up and down to ensure a good finish on both top and bottom surfaces of laminated and veneered boards. For use on routers and machining centers with CNC control.



ØD	B	Ød	Tool No.	L	Max. RPM	# of knives	Repl. T.C. Knife
22(7/8")	42(1-11/16")	3/4"	RC-4200	115(4-9/16")	18,000	4	AMA-12
22(7/8")	62(2-7/16")	3/4"	RC-4204	135(5-5/16")	18,000	6	AMA-12

INSERT ROUGH RABBETING & SIZING ROUTER BIT

Insert straight router bit with multiple cutting flutes. Suitable for rough rabbeting and sizing in softwood, hardwood and man-made boards (with or without coating). Multiple cutting flutes ensure fine chips are produced for improved waste extraction. Replaceable inserts ensure a constant cutting diameter. For use on routers and machining centers with CNC control.



ØD	B	Ød	Tool No.	L	Max. RPM	# of knives	Repl. T.C. Knife
50(2")	56(2-13/64")	3/4"	RC-2350	113(4-1/2")	18,000	10	AMA-12
50(2")	78(3-1/16")	3/4"	RC-2354	135(5-5/16")	18,000	14	AMA-12



For solid carbide spiral & compression bits see pages 9-11



Spiral & Compression



Straight Plunge



Miter Fold & Signmaking



Chamfering & Profiling



RABBETING



Door Making



Jointing



Grooving



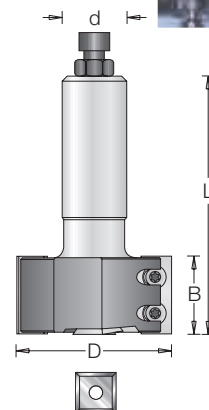
Planing & Hogging

CNC Router Bits



INSERT STRAIGHT RABBETING WITH SCORER 2+2 DESIGN

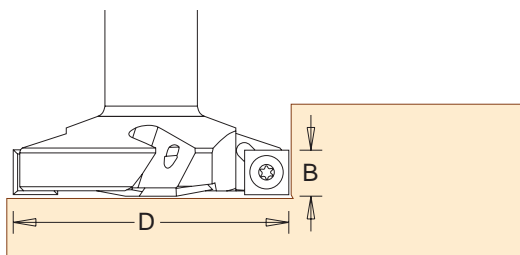
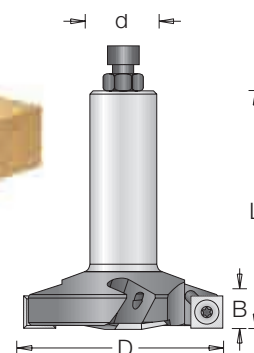
Insert rabbeting router bit complete with two cutting flutes and scorer. Suitable for trimming and rabbeting in softwood, hardwood and man-made boards. Scorer will give an improved finish at the bottom of the cut.



ØD	B	Ød	L	Tool No.	Max. RPM	Repl. T.C. Knife	Repl. T.C. Knife
40(1-1/2")	30(1-3/16")	3/4"	100(4")	RC-2380	18,000	RCK-30	RCK-70
40(1-1/2")	50(2")	3/4"	120(4-3/4")	RC-2381	18,000	RCK-50	RCK-70
60(2-3/8")	30(1-3/16")	3/4"	100(4")	RC-2382	18,000	RCK-30	RCK-70
60(2-3/8")	50(2")	3/4"	120(4-3/4")	RC-2383	18,000	RCK-50	RCK-70

INSERT SPOILBOARD SURFACING & RABBETING WITH SCORER 2+2 DESIGN

Insert spoilboard, planing and rabbeting router bit complete with two cutting flutes and two up-shear scorer will give excellent results in MDF, Balsa Core, hardwood, softwood and all man-made materials. A good tool for fast removal of materials over a large surface area. The scorer will give an improved finish at the bottom of the cut.



ØD	B	Ød	Tool No.	L	Max. RPM	Repl. T.C. Knife
80(3-1/8")	12(15/32")	3/4"	RC-2252	90(3-1/2")	18,000	HMA-12, HCK-70

For Additional Knives see page 160.



To produce MDF Shaker cabinet doors use RC-2252 and square corners with 45200.

Wood profiles shown at actual size. 3D renderings & tool illustrations not shown at actual size.

For a complete replacement parts listing for the above tools please refer to our website: www.amanatool.com



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CNC ROUTER BITS

GIN-GROOVE™ CNC INSERT ENGRAVING SYSTEM

New

SIGNMAKING, LETTERING AND ENGRAVING

2 FLUTE

The Most Versatile CNC Insert Tooling System for Sign Making, Lettering & Engraving.

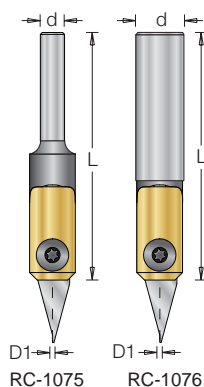
This Insert Engraving System features one tool body with over 30 unique insert knives designed for a variety of applications.

Industrial quality insert knives produce crisp, clean cuts and last at least twice as long as comparable solid carbide bits.

The system was engineered to quickly interchange inserts while mounted in CNC machines to eliminate down-time and to maintain consistent cutting accuracy.

Tool bodies are expertly balanced for virtually no vibration to provide superior cutting results.

Ideal for cutting laminated materials, veneers, MDF, plastics, wood and solid surface. V-Tip inserts can also cut aluminum.



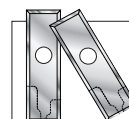
AS GOOD AS
gold!



Insert knives sold separately.

Tool No.	Ød	L
RC-1075	1/4	2-1/2
RC-1076	1/2	2-1/2

Replacement hex key #5004. Replacement screw #67127.



Design Your Own Custom Profile
10 pc. Minimum

KNIVES FOR RC-1075 (G1853X04) AND RC-1076 (G1853X08)



V-TIP ($\alpha^\circ = 30^\circ$)



Tool No.	ØD1
RCK-360	0.005"
RCK-361	0.010"
RCK-362	0.020"
RCK-363	0.030"
RCK-364	0.040"
RCK-366	0.060"
RCK-369	0.090"



V-TIP ($\alpha^\circ = 60^\circ$)



Tool No.	ØD1
RCK-380	0.005"
RCK-381	0.010"
RCK-382	0.020"
RCK-383	0.030"
RCK-384	0.040"
RCK-385	0.060"
RCK-386	0.090"



V-TIP ($\alpha^\circ = 90^\circ$)



Tool No.	ØD1
RCK-390	0.005"
RCK-391	0.010"
RCK-392	0.020"
RCK-393	0.040"



STRAIGHT BITS



Tool No.	ØDia.
RCK-400	1/8"
RCK-402	3/16"
RCK-404	1/4"
RCK-406	5/16"



CORNER ROUND



Tool No.	Radius	Small D
RCK-410	1/16"	3mm (1/8")
RCK-412	3/32"	3mm (1/8")
RCK-414	1/8"	3mm (1/8")



CORE BOX



Tool No.	Radius	ØDia.
RCK-420	1/16"	1/8"
RCK-422	3/32"	3/16"
RCK-424	1/8"	1/4"
RCK-426	5/32"	5/16"

www.amanatool.com/ingroove

Wood profiles shown at actual size. 3D renderings & tool illustrations not shown at actual size.

For a complete replacement parts listing for the above cutters please refer to our website: www.amanatool.com



CNC Router Bits



New

'V' GROOVE - "MITER FOLD" & SIGNMAKING INSERT ROUTER BIT

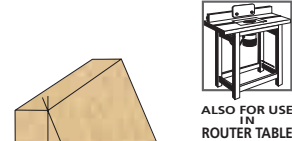
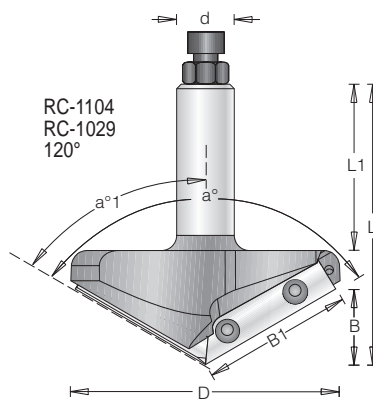
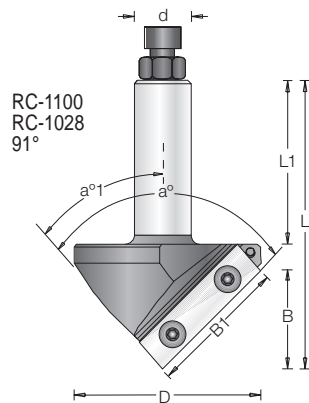
SINGLE FLUTE & 2 FLUTE

Designed to miter fold MDF, melamine and wood to a perfect joint.

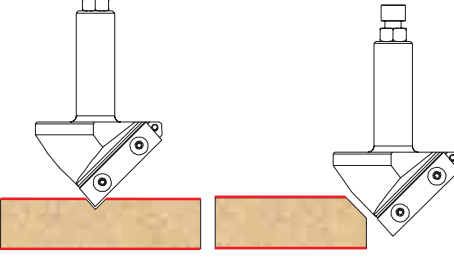
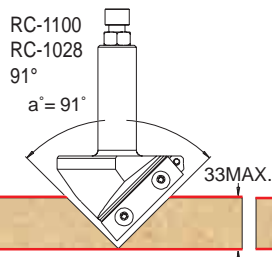
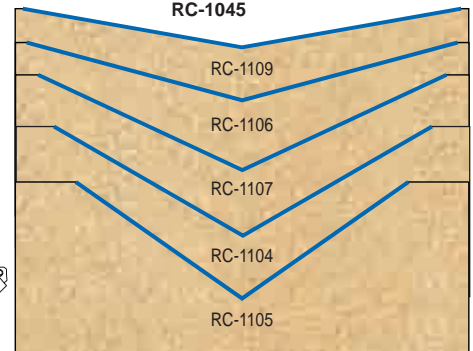
3/4" SHANK



	ØD	a°	a°1	B	B1	Flutes	Ød	Tool No.	L1	L	Gen. Purpose Repl.T.C Knife	MDF Repl.T.C Knife	Torx Screw
18	1-5/8	60°	30°	1-3/8	1-5/8	1	3/4	RC-1032	2-7/8	4-5/8	RCK-131	RCK-358	67110
18	2-5/8	90°	45°	1-9/32	1-27/32	1	3/4	RC-1030	2-5/32	3-13/16	RCK-133	RCK-355	67110
18	3	90°	45°	1-1/2	27/64	1	3/4	RC-1034	2-23/64	4-23/64	RCK-138	RCK-359	67115
18	2-5/8	91°	45.5°	1-5/16	1-3/8	1	3/4	RC-1028	2-3/8	3-7/8	RCK-117	RCK-356	67110
12	3-13/32	120°	60°	31/32	1-31/32	2	3/4	RC-1029	2-3/8	3-27/32	RCK-112	RCK-357	67115
12	3-27/32	130°	60°	13/16	1-31/32	2	3/4	RC-1025	2-3/8	3-7/8	RCK-112	RCK-357	67115
12	3-25/32	150°	75°	1/2	1-31/32	2	3/4	RC-1027	2-3/8	3-1/2	RCK-112	RCK-357	67115



22.5°
RC-1045



1/2" SHANK

	ØD	a°	a°1	B	B1	Flutes	Ød	Tool No.	L1	L	Gen. Purpose Repl.T.C Knife	MDF Repl.T.C Knife	Torx Screw
18	13/16	45°	22.5°	1	1-1/16	1	1/2	RC-1045	1-3/8	2-3/8	RCK-56	RCK-350	67117
18	27/32	46°	23°	63/64	1-1/16	1	1/2	RC-1047	1-3/8	2-3/8	RCK-56	RCK-350	67117
18	7/8	50°	25°	31/32	1-1/16	1	1/2	RC-1046	1-1/2	2-9/16	RCK-56	RCK-350	67117
18	1-1/32	60°	30°	29/32	1-1/16	1	1/2	RC-1108	1-3/8	2-7/16	RCK-56	RCK-350	67117
18	1-7/32	70°	35°	7/8	1-1/16	1	1/2	RC-1048	1-1/2	2-9/16	RCK-56	RCK-350	67117
22	1-1/2	90°	45°	3/4	1-1/16	1	1/2	RC-1102	1-25/32	3	RCK-134	RCK-351	67117
22	1-1/2	91°	45.5°	3/4	1-1/16	1	1/2	RC-1100	1-25/32	3	RCK-119	RCK-352	67115
22	1-5/8	100°	50°	11/16	1-1/16	1	1/2	RC-1103	2	3-3/16	RCK-119	RCK-352	67117
22	1-3/4	110°	55°	5/8	1-1/16	2	1/2	RC-1105	2	3-3/16	RCK-119	RCK-352	67117
18	2-1/32	120°	60°	9/16	1-5/32	2	1/2	RC-1104	2	3-1/16	RCK-136	RCK-353	67139
16	2-1/8	130°	65°	1/2	1-5/32	2	1/2	RC-1107	2	3	RCK-137	RCK-354	67115
14	2-1/4	150°	75°	19/64	1-5/32	2	1/2	RC-1106	2	2-15/16	RCK-137	RCK-354	67115
14	2-5/16	160°	80°	13/64	1-5/32	2	1/2	RC-1109	2	2-25/32	RCK-137	RCK-354	67115

WARNING: Maximum RPM Δ_{12} = 12,000; Δ_{14} = 14,000; Δ_{16} = 16,000; Δ_{18} = 18,000; Δ_{22} = 22,000
Wood profiles shown at actual size. 3D renderings & tool illustrations not shown at actual size.
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DOOR MAKING



Jointing



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CNC Router Bits



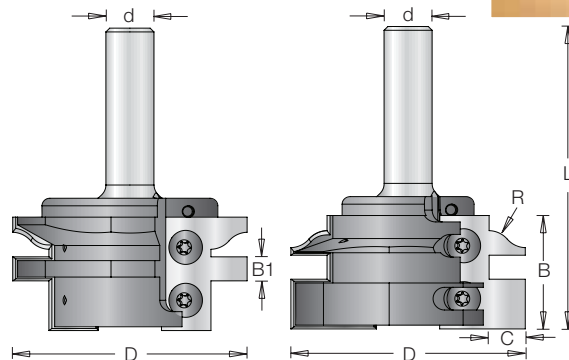
INSERT STILE & RAIL SET FOR 3/4" TO 1-3/16" MATERIAL

New

Our stile and rail sets give you two complete bits, one for doing the rail cuts and one for the stiles. Make cabinet doors and all varieties of frame-and-panel assemblies for furniture and architectural applications.

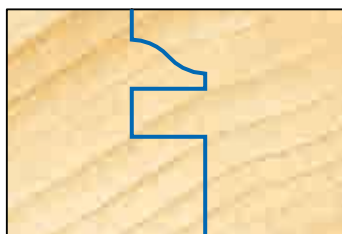


ALSO FOR USE
IN
ROUTER TABLE

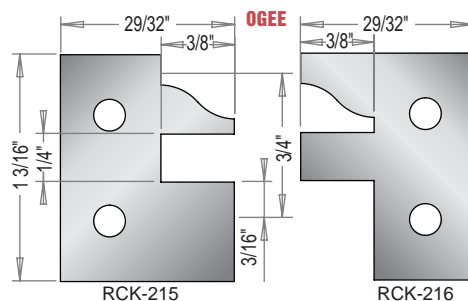


ØD	B	B1	R	Tool No.	Ød	C	L	Max. RPM
2-5/8	1-11/64	1/4	1/4	*RC-1130	1/2	3/8	3-1/8	18,000

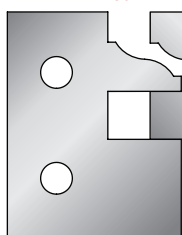
*Set comes with Ogee Knives installed (RCK-215 & RCK-216)



Additional knives sold separately.



Ogee Fillet

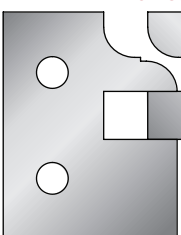


RCK-211



RCK-212

Classical

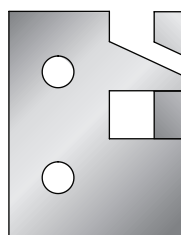


RCK-213

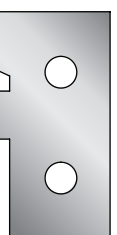


RCK-214

Traditional

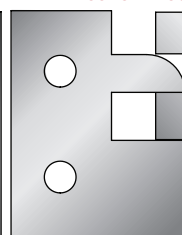


RCK-217

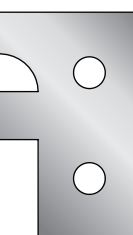


RCK-218

Concave Convex



RCK-219



RCK-221

INSERT STILE & RAIL WITH EASED EDGE SET 1/2" DEEP TONGUE & GROOVE

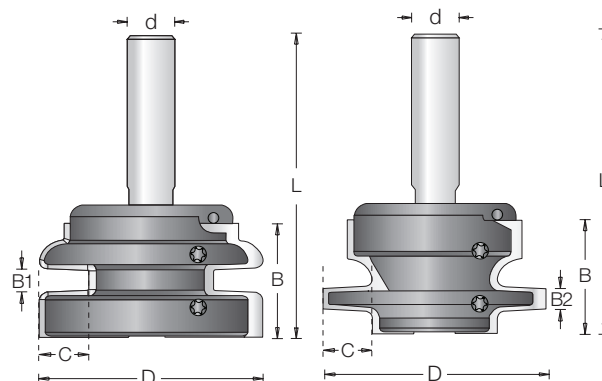
New

FOR 3/4" TO 1-5/16" MATERIAL

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ALSO FOR USE
IN
ROUTER TABLE



ØD	B	B1	B2	Ød	Tool No.	C	L	Max. RPM	Repl. T.C. Knife
2-3/8"	1-3/16"	1/4"	5.5(7/32")	1/2"	RC-1132	1/2"	2"	18,000	RCK-340 RCK-342

Wood profiles shown at actual size. 3D renderings & tool illustrations not shown at actual size.

For a complete replacement parts listing for the above tools please refer to our website: www.amanatool.com

Amana Tool®



Spiral & Compression



Straight Plunge



Miter Fold & Signmaking



Chamfering & Profiling



Rabbeting



DOOR MAKING



Joining



Grooving



Planing & Hogging

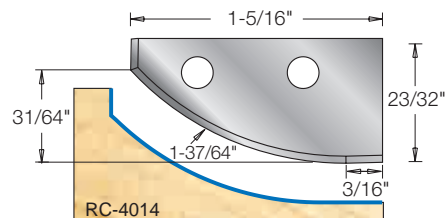
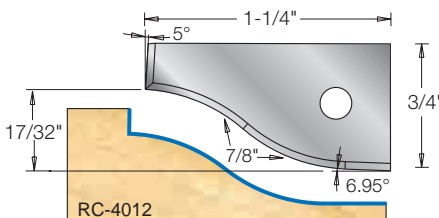
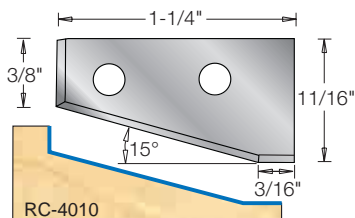
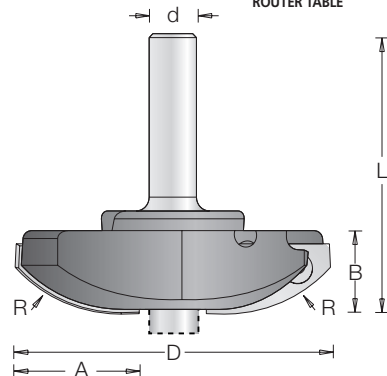
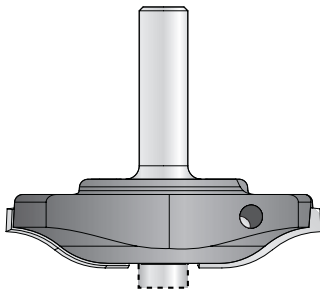
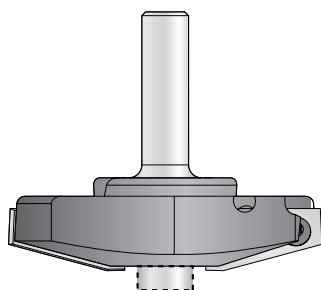
INSERT RAISED PANEL *New*

2 FLUTE

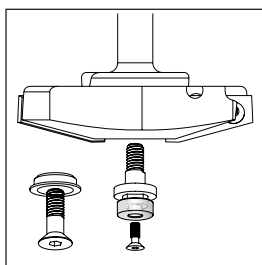
Insert Raised panel bits for CNC machine or router table. Bits include ball bearing & anti-dust plug. May also be used with optional back cutter below. Remove bearing for CNC work.



ALSO FOR USE
IN
ROUTER TABLE

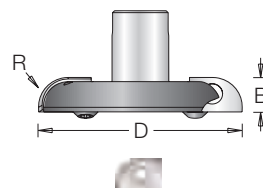


ØD	B	Ød	R	Tool No.	A	L	Repl. T.C. Knife
3-3/8	51/64	1/2	—	RC-4010	1-3/8	2-3/4	RCK-224
3-3/8	3/4	1/2	7/8	RC-4012	1-3/8	2-3/4	RCK-226
3-3/8	27/32	1/2	1-37/64	RC-4014	1-7/16	2-7/8	RCK-228

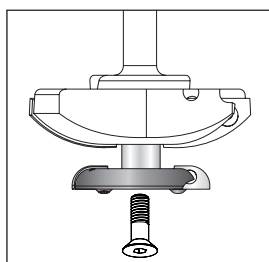


All above Insert Raised panel bits include plug, ball bearing and retaining screw.

BACK CUTTER (OPTIONAL) FOR ABOVE INSERT RAISED PANELS 2 FLUTE



ØD	B	Tool No.	R	Repl. T.C. Knife
2-1/8	23/64	RC-4102	5/16	RCK-232





Spiral & Compression



Straight Plunge



Miter Fold & Signmaking



Chamfering & Profiling



Rabbeting



DOOR MAKING



Jointing



Grooving



Planing & Hogging

CNC Router Bits



ADJUSTABLE INSERT MISSION TONGUE & GROOVE SET FOR 5/8" TO 1-3/16" MATERIAL

Adjust the panel groove width from 5.4mm - 6.6mm using the easy to use adjustment knob - no shims necessary.

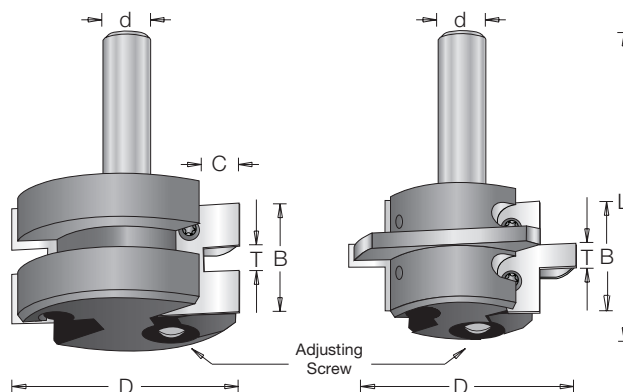


MISSION STYLE
FLAT PANEL CABINET DOOR MAKING ROUTER BIT SET

PATENT PENDING

The perfect fix for undersized plywood flat panel "Mission Style, Arts & Crafts and Shaker" cabinet doors! Set includes unique adjustment system.

- Designed to cut precise grooves to provide undersized plywood veneered panels with a snug rattle free fit.
- Each set includes 2 pcs. (1 for stile cuts & 1 for rail cuts)

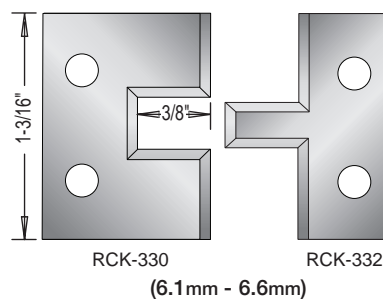
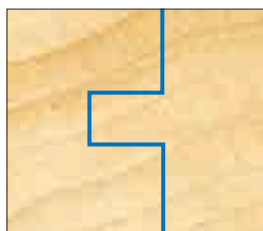


ØD	B	Ød	C	Tool No.	T	L	Max. RPM
2-3/8"	1-3/16"	1/2"	3/8"	*RC-4022	6.1-6.6(1/4" + -)	2-15/16"	18,000

*Set includes RCK-330 & RCK-332



ALSO FOR USE
IN
ROUTER TABLE

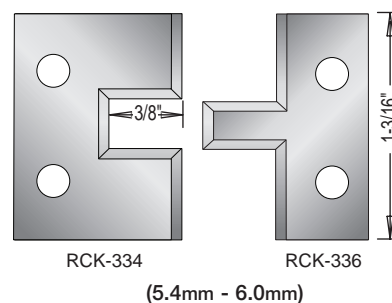


(6.1mm - 6.6mm)



Optional Knives:

- For 5.5mm undersized 1/4" plywood.
- For 5.9mm oversized 1/4" veneered plywood.



(5.4mm - 6.0mm)

Wood profiles shown at actual size. 3D renderings & tool illustrations not shown at actual size.

For a complete replacement parts listing for the above tools please refer to our website: www.amanatool.com





Spiral & Compression



Straight Plunge



Miter Fold & Signmaking



Chamfering & Profiling



Rabbeting



DOOR MAKING



Jointing



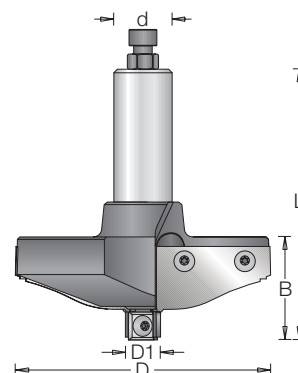
Grooving



Planing & Hogging

INSERT MULTI PROFILE RAISED PANEL ROUTER BIT

Insert profile router bit with two cutting flutes. Suitable for producing various raised panel profiles in softwood, hardwood and man-made boards. Tool can be supplied complete with a small trimmer for machining the edge of the panel. One router will take all eight different profiles. For use on routers and machining centers with CNC control.



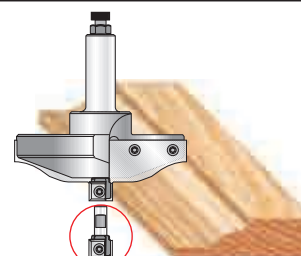
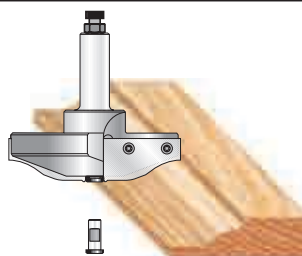
INFINITY SYSTEM™

ØD	ØD1	B	Tool No.	Ød	L	Max. RPM	Repl. T.C. Knife
112(4-7/16")	18(23/32")	28(1-1/8")	RC-4000	3/4"	110(4-11/32")	12,000	RCK-200
112(4-7/16")	18(23/32")	28(1-1/8")	RC-4001	3/4"	110(4-11/32")	12,000	RCK-210
112(4-7/16")	18(23/32")	28(1-1/8")	RC-4002	3/4"	110(4-11/32")	12,000	RCK-220
112(4-7/16")	18(23/32")	28(1-1/8")	RC-4003	3/4"	110(4-11/32")	12,000	RCK-230
112(4-7/16")	18(23/32")	28(1-1/8")	RC-4004	3/4"	110(4-11/32")	12,000	RCK-240
112(4-7/16")	18(23/32")	28(1-1/8")	RC-4005	3/4"	110(4-11/32")	12,000	RCK-250
112(4-7/16")	18(23/32")	28(1-1/8")	RC-4006	3/4"	110(4-11/32")	12,000	RCK-260
112(4-7/16")	18(23/32")	28(1-1/8")	RC-4007	3/4"	110(4-11/32")	12,000	RCK-270

TRIMMER BIT (OPTIONAL)

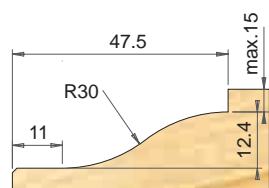


ØD1	B	B1	Tool No.	Ød	L	Repl. T.C. Knife
18(23/32")	12(15/32")	18(23/32")	RC-4100	8(5/16")	31(1-1/4")	AMA-12

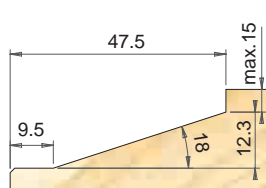


RC-4100

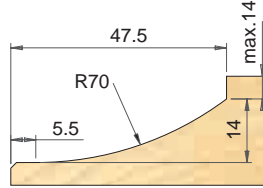
INSERT KNIVES FOR MULTI PROFILE RAISED PANEL ROUTER BIT



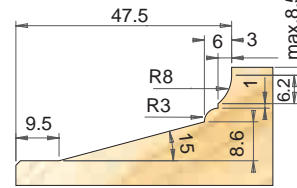
RCK-200



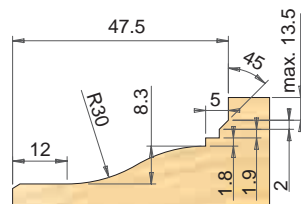
RCK-210



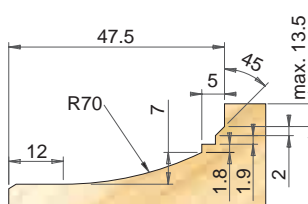
RCK-220



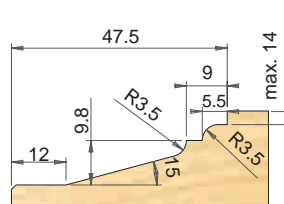
RCK-230



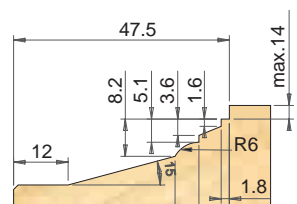
RCK-240



RCK-250



RCK-260



RCK-270

(Wood profiles not shown at actual size.)

3D renderings & tool illustrations not shown at actual size.

For a complete replacement parts listing for the above tools please refer to our website: www.amanatool.com



Spiral & Compression



Straight Plunge



Miter Fold & Signmaking



Chamfering & Profiling



Rabbeting



DOOR MAKING



Jointing



Grooving



Planing & Hogging

CNC Router Bits



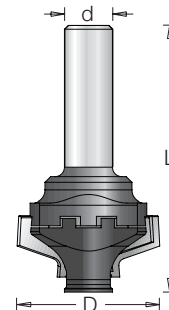
INSERT CABINET DOOR EDGE BIT

New

Cuts a decorative edge on door cabinet fronts. Shallow design will also work well with European hinges.



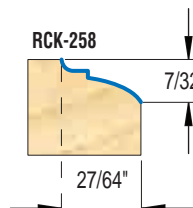
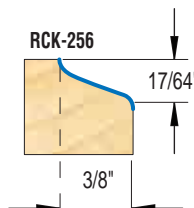
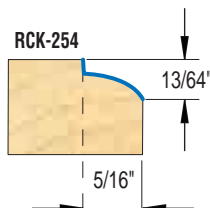
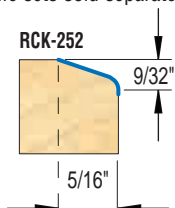
ALSO FOR USE IN ROUTER TABLE



ØD	Ød	Tool No.	L
1-1/2	1/2	* RC-2120	2-25/32

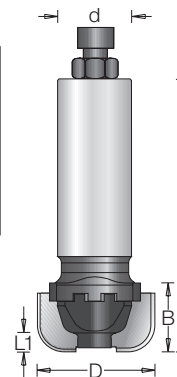
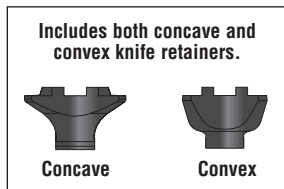
*RCK-252 included (2).

Additional knife sets sold separately.



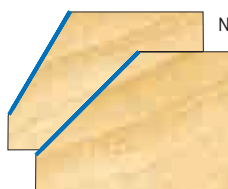
MULTI-FACE PROFILE (EDGE) FORM ROUTER BIT

This innovative cutter is part of our patent pending Nova System (see pages 50-51). The hard, durable carbide blades provide durability, even on abrasive sheet stock. And because the profiles are interchangeable, you'll only need to purchase one bit. Choose from a wide variety of popular profiles illustrated below.



ØD	B	Ød	Tool No.	L	L1	Max. RPM
40(1-1/2")	17.5(11/16")	3/4"	* RC-2470	110.5(4-3/8")	2.5(3/32")	28,000

*NRC-A13 included.



NRC-A01

NRC-A02

NRC-A07

NRC-A06

NRC-A05

NRC-A04

NRC-A03

NRC-A14

NRC-A15

NRC-A16

NRC-A10

NRC-A09

NRC-A08

NRC-A19

NRC-A18

NRC-A20

NRC-A11

NRC-A12

NRC-A23

NRC-A22

NRC-A21

NRC-A17

Wood profiles shown at actual size. 3D renderings & tool illustrations not shown at actual size.

For a complete replacement parts listing for the above tools please refer to our website: www.amanatool.com



CNC Router Bits



Spiral & Compression



Straight Plunge



Miter Fold & Signmaking



Chamfering & Profiling



Rabbeting



DOOR MAKING



Jointing



Grooving



Planing & Hogging

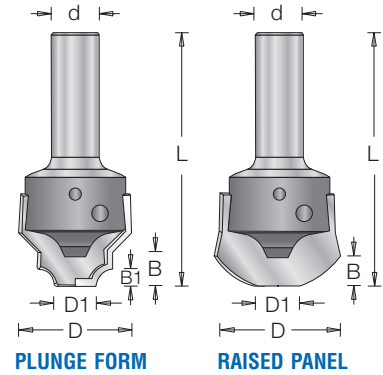
MDF CABINET DOORS INSERT BITS

New

This series of profiles utilizing our patented Nova™ Tool body system of interchangeable carbide insert knives (see pages 50-51) are designed to give the appearance of a Raised Panel door in MDF or solid panels.

One pass is all that is needed for a simple raised panel look using one of the "Plunge Form" profiles.

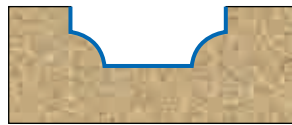
Replacement knives are MDF Grade Carbide and will last much longer than standard brazed carbide tipped bits.



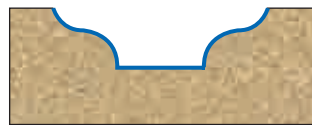
ØD	D1	B	Style	Tool No.	B1	Ød	L	Repl. T.C. Knife
25/32	7/16	23/64	Bead	RC-2480	3/16	1/2	2-5/8	RCK-480
25/32	7/16	15/32	Ogee	RC-2481	—	1/2	2-5/8	RCK-481
25/32	7/16	7/16	Ogee	RC-2482	1/4	1/2	2-5/8	RCK-482
1-3/8	15/32	25/64	Traditional	RC-2483	—	1/2	2-5/8	RCK-483
1-7/64	7/16	1/4	Cove	RC-2484	7/64	1/2	2-5/8	RCK-484
1-11/32	23/64	17/64	Traditional	RC-2485	—	1/2	2-5/8	RCK-485
1-11/32	25/64	21/64	Ogee	RC-2486	—	1/2	2-5/8	RCK-486

Replacement knives are interchangeable and may be purchased separately.

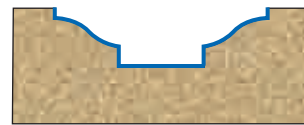
PLUNGE FORM



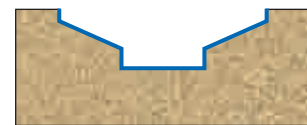
RC-2480



RC-2481



RC-2482



RC-2483

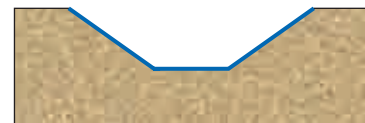
RAISED PANEL



RC-2484

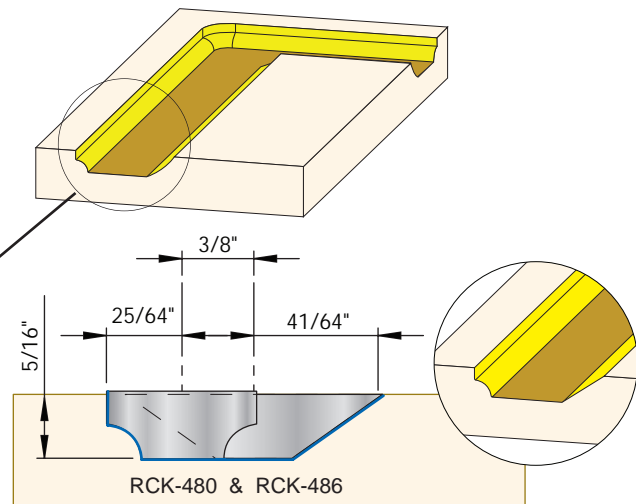
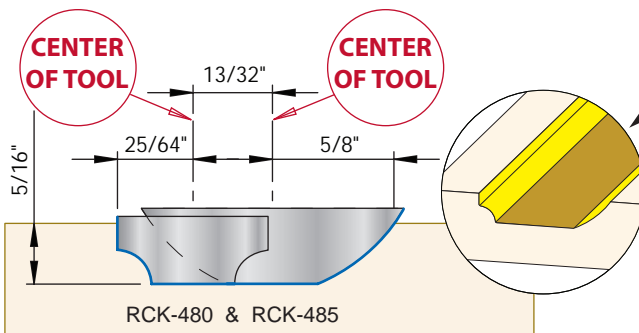


RC-2485



RC-2486

To create a more authentic raised panel with a deeper reveal, use one of the many "Raised Panel" profiles in conjunction with the "Plunge Form" profile for one pass each. Complete the look with one pass of the "door edge" (see page 137) on the outside of the door.





Spiral & Compression



Straight Plunge



Miter Fold & Signmaking



Chamfering & Profiling



Rabbeting



DOOR MAKING



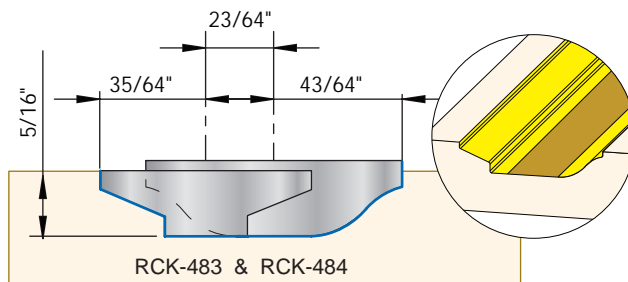
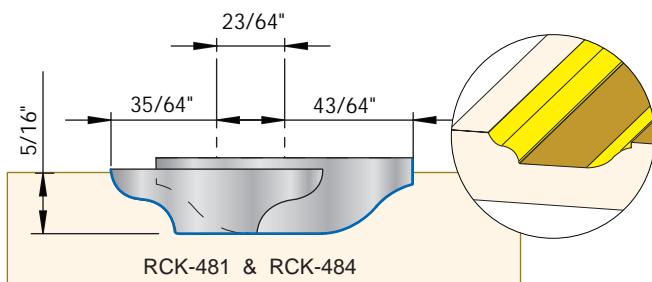
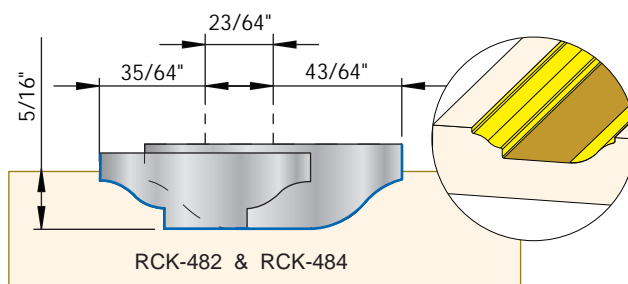
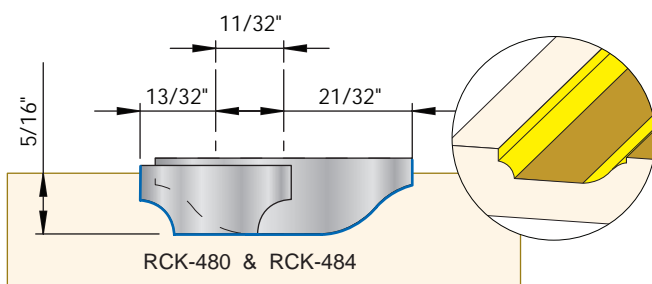
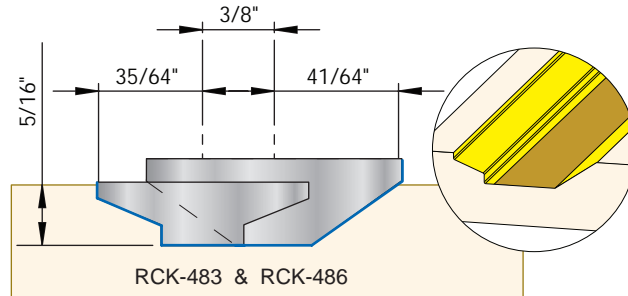
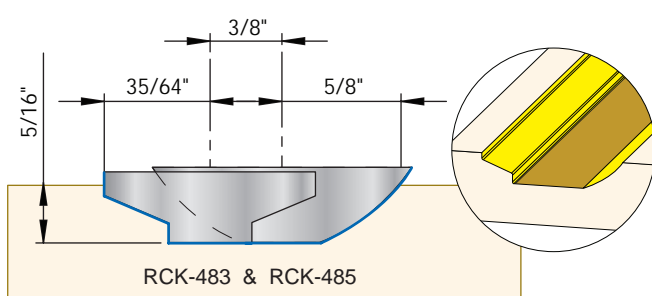
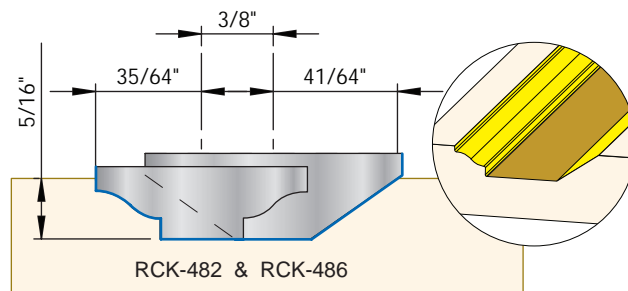
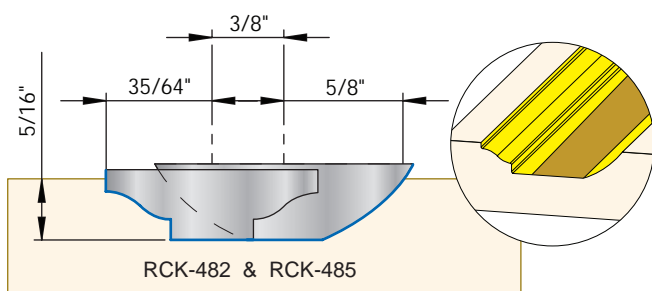
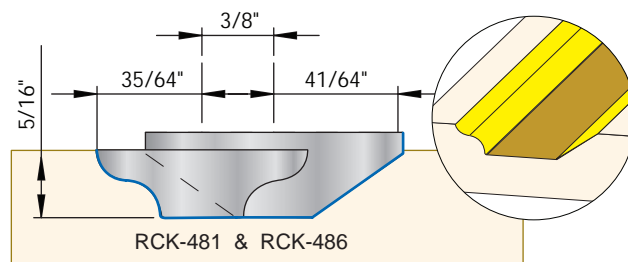
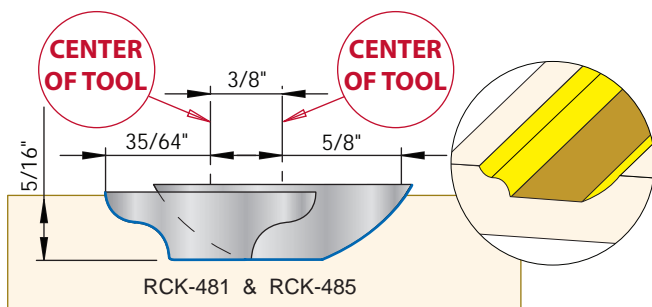
Jointing



Grooving



Planing & Hogging

CNC Router Bits**MDF CABINET DOORS INSERT BITS (CONTINUED)****CNC ROUTER BITS**

MDF profiles shown at actual size. 3D renderings & tool illustrations not shown at actual size.

For a complete replacement parts listing for the above cutters please refer to our website: www.amanatool.com**Amana Tool®**

CNC Router Bits



Spiral & Compression



Straight Plunge



Miter Fold & Signmaking



Chamfering & Profiling



Rabbeting



DOOR MAKING



Jointing



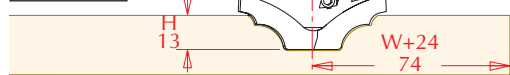
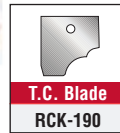
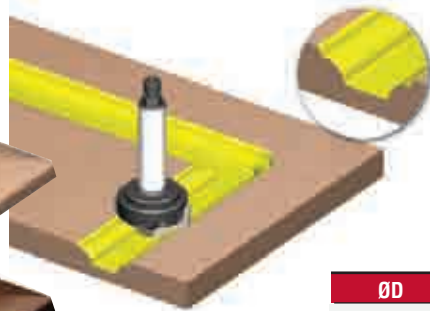
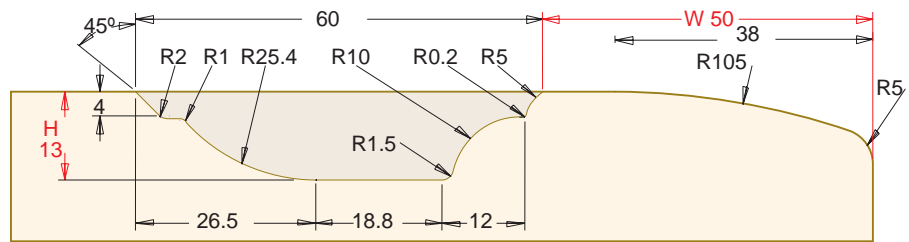
Grooving



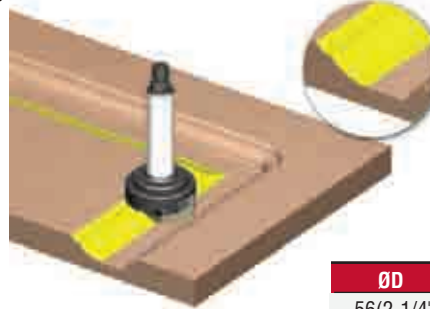
Planing & Hogging

CNC MULTI PROFILE CARBIDE INSERT ROUTER BITS FOR MDF CABINET DOORS

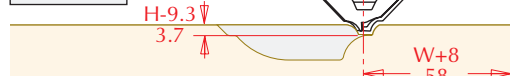
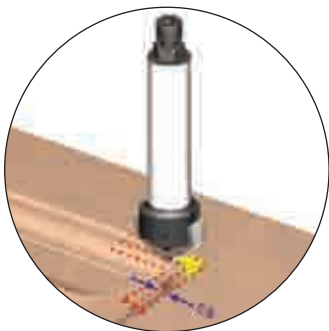
VIOLA
Style



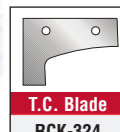
ØD	B	Tool No.	L	Ød
56(2-1/4")	25(1")	RC-2450	109(4-5/16")	3/4"



ØD	B	Tool No.	L	Ød
56(2-1/4")	25(1")	RC-2452	109(4-5/16")	3/4"



ØD	B	Tool No.	L	Ød
32(1-9/32")	24(15/16")	RC-2454	109(4-5/16")	3/4"



ØD	B	Tool No.	L	Ød
106(4-3/16")	20(7/8")	RC-4070	99.5(3-29/32")	3/4"

W = width of the frame.

H = maximum depth of the frame.

The dimension **W** determines the frame width.

The dimension **H** determines the profile depth.

In the example shown,

W = 50 and **H** = 13.

Any change in the dimensions of the frame width and depth should be done according to the formula that is written on each tool drawing.



Spiral & Compression



Straight Plunge



Miter Fold & Signmaking



Chamfering & Profiling



Rabbeting



DOOR MAKING



Jointing



Grooving



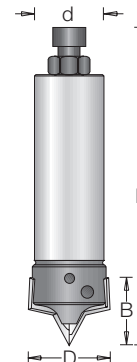
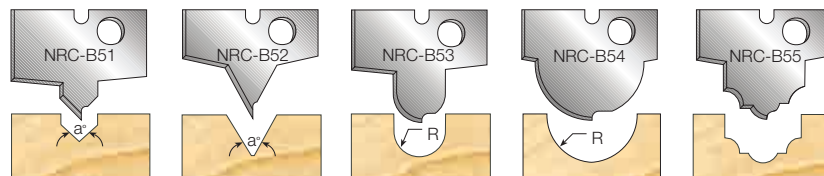
Planing & Hogging

CNC Router Bits



MULTI-FACE PROFILE ROUTER BIT

This selection of bits is specifically designed for plunge cutting. The sharp point ensures a clean, smooth entry, and the special carbide inserts can be quickly and easily replaced.



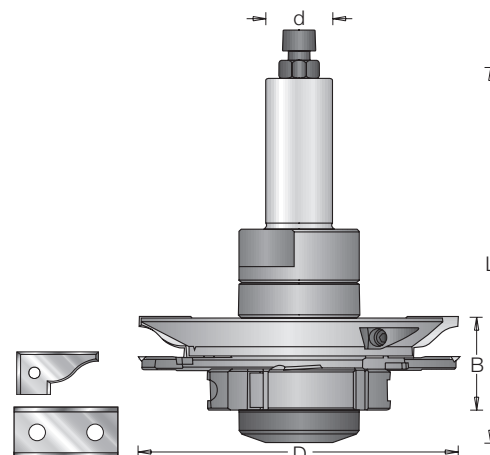
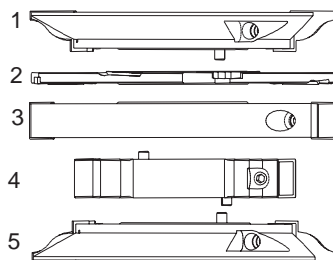
ØD	a°	R	Profile	Tool No.	Ød	L	Max. RPM
29.5(1-5/32")	45	—	NRC-B51	RC-2460	3/4"	82.5(3-1/4")	28,000
29.5(1-5/32")	30	—	NRC-B52	RC-2462	3/4"	82.5(3-1/4")	28,000
29.5(1-5/32")	—	6.3(1/4")	NRC-B53	RC-2464	3/4"	82.5(3-1/4")	28,000
29.5(1-5/32")	—	12.5(1/2")	NRC-B54	RC-2466	3/4"	82.5(3-1/4")	28,000
29.5(1-5/32")	—	4(5/32")	NRC-B55	RC-2468	3/4"	82.5(3-1/4")	28,000

Custom sizes available.

INSERT STILE & RAIL ROUTER BIT SETS

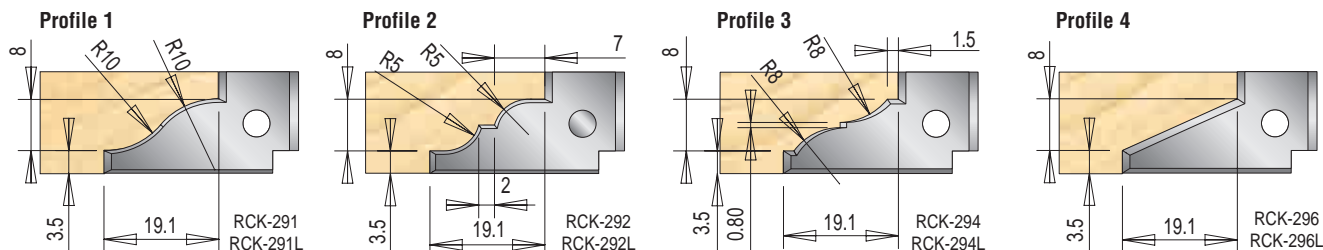
Insert stile and rail CNC router bit set comes with up to five different stacking cutters and interchangeable knives for producing various stile and rail profiles.

For softwood, hardwood and man-made boards.

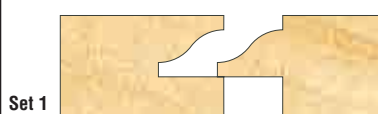


Sets:

ØD	Set No.	Cutters	B	Profile	Ød	Tool No.	Max. RPM	Repl. T.C. Knife
120(4-3/4")	1	1,2,3,4	20-35(7/8"-1-3/8")	1	3/4"	RC-2260	12,000	RCK-291, RCK-19, RCK-71, RCK-68, RCK-11
120(4-3/4")	1	1,2,3,4	20-35(7/8"-1-3/8")	2	3/4"	RC-2262	12,000	RCK-292, RCK-19, RCK-71, RCK-68, RCK-11
120(4-3/4")	1	1,2,3,4	20-35(7/8"-1-3/8")	3	3/4"	RC-2264	12,000	RCK-294, RCK-19, RCK-71, RCK-68, RCK-11
120(4-3/4")	1	1,2,3,4	20-35(7/8"-1-3/8")	4	3/4"	RC-2266	12,000	RCK-296, RCK-19, RCK-71, RCK-68, RCK-11
120(4-3/4")	2	1,2,3,4,5	20-35(7/8"-1-3/8")	1	3/4"	RC-2268	12,000	RCK-291, RCK-19, RCK-71, RCK-68, RCK-11, RCK-291L
120(4-3/4")	2	1,2,3,4,5	20-35(7/8"-1-3/8")	2	3/4"	RC-2270	12,000	RCK-292, RCK-19, RCK-71, RCK-68, RCK-11, RCK-292L
120(4-3/4")	2	1,2,3,4,5	20-35(7/8"-1-3/8")	3	3/4"	RC-2272	12,000	RCK-294, RCK-19, RCK-71, RCK-68, RCK-11, RCK-294L
120(4-3/4")	2	1,2,3,4,5	20-35(7/8"-1-3/8")	4	3/4"	RC-2274	12,000	RCK-296, RCK-19, RCK-71, RCK-68, RCK-11, RCK-296L



Profile 1 Shown





CNC Router Bits



Spiral & Compression



Straight Plunge



Miter Fold & Signmaking



Chamfering & Profiling



Rabbeting



Door Making



JOINING



GROOVING



Planing & Hogging

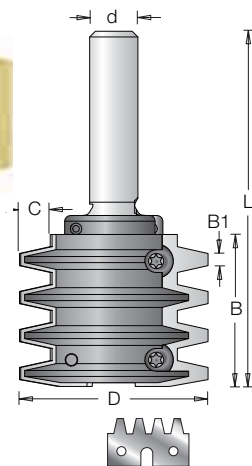
INSERT GLUE JOINT

New

Insert glue joint router bit complete with two cutting flutes. Suitable for producing finger joints in softwood, hardwood and man-made boards. For use on routers and machining centers with CNC control.



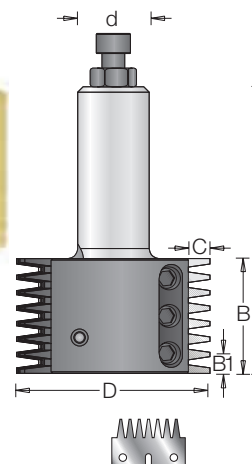
ALSO FOR USE
IN
ROUTER TABLE



ØD	B	B1	C	Ød	Tool No.	L	Max. RPM	Repl. T.C. Knife
50(2")	40(1-1/2")	3(1/8")	8(5/16")	1/2"	RC-2246	94(3-11/16")	18,000	RCK-234

INSERT FINGER JOINT ROUTER BIT

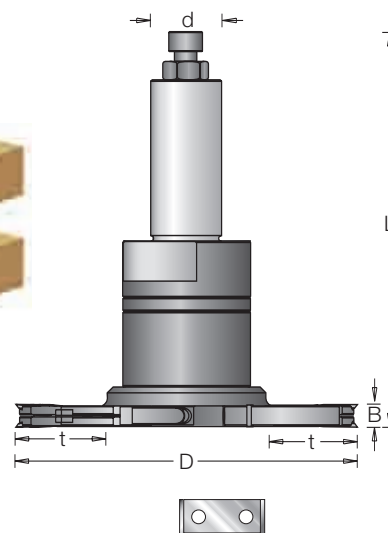
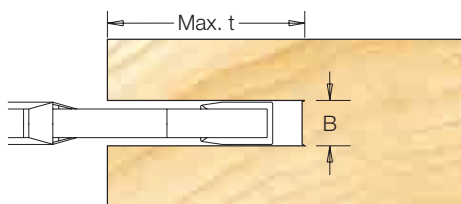
Insert finger jointing router bit complete with two cutting flutes. Suitable for producing finger joints in softwood, hardwood and man-made boards. For use on routers and machining centers with CNC control.



ØD	B	B1	C	Ød	Tool No.	L	Max. RPM	Repl. T.C. Knife
70(2-3/4")	40(1-1/2")	5.4(7/32")	8(5/16")	3/4"	RC-2240	100(4")	12,000	RCK-92

INSERT ADJUSTABLE GROOVING ROUTER BIT (4-15.5MM)

Hard wearing steel body complete with tungsten carbide knives and scorer for improved finish. Suitable for producing various thickness grooves and slots in softwood, hardwood and man-made boards (with or without coating). Cutting width can be adjusted in 0.1mm steps by using supplied spacer rings. Replaceable inserts ensure a constant cutting diameter and finish quality. For use on routers and machining centers with CNC control.



ØD	B	t	Ød	Tool No.	L	Max. RPM	Repl. T.C. Knife
120(4-3/4")	4-15.5(5/32"-5/8")	1-5/16"	3/4"	RC-2340	139(5-1/2")	12,000	AMA-17, RCK-71, RCK-18



Spiral & Compression



Straight Plunge



Miter Fold & Signmaking



CHAMFERING & PROFILING



Rabbeting



Door Making



Jointing



Grooving

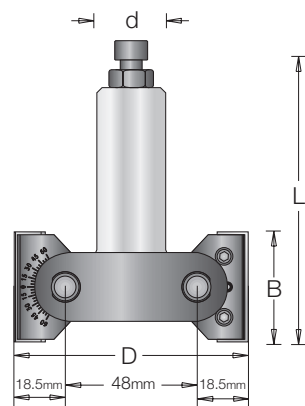
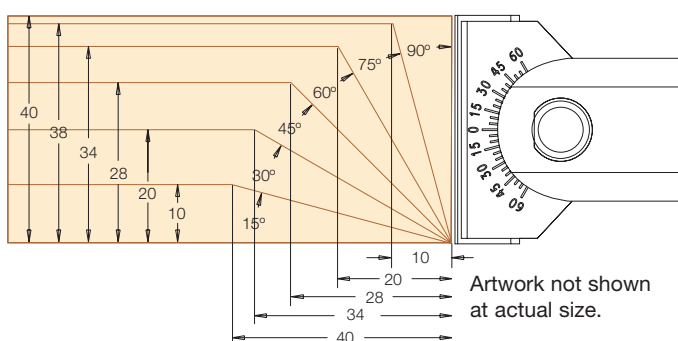
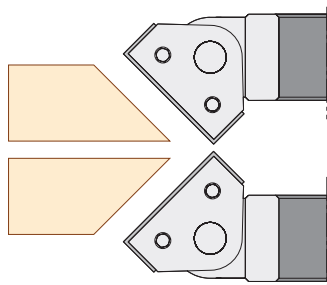


Planing & Hogging

CNC Router Bits

INSERT ADJUSTABLE CHAMFER ROUTER BIT

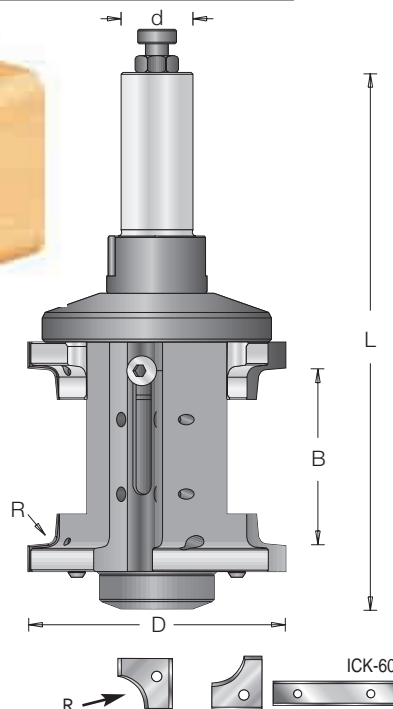
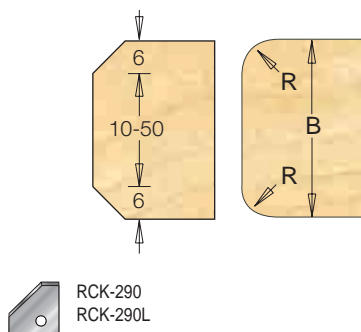
Insert router bit complete with two cutting flutes. Suitable for producing chamfer cuts at various angles in softwood, hardwood and man-made boards. Cutting angle can be adjusted in 7.5° steps by using a notched scale. Fine adjustment of 1° is also possible. For use on routers and machining centers with CNC control.

**CNC ROUTER BITS**

ØD	B	a°	Ød	Tool No.	L	Max. RPM	Repl. T.C. Knife
85(3-3/8")	40(1-1/2")	-45° → +90°	3/4"	RC-2370	100(4")	12,000	RCK-40

INSERT DOUBLE ROUNDING AND CHAMFERING ROUTER BIT SYSTEM

Insert profile router bit with two cutting flutes. Suitable for profiling in softwood, hardwoods and man-made boards (with or without coating). Tool will be supplied with special inserts and backing plates ground to the customer's own specification. For use on routers and machining centers with CNC control.



ØD	R/a°	B	Tool No.	Ød	L	Max. RPM	Repl. T.C. Knife		
							UPPER	LOWER	
90(3-9/16")	3	18-58(25/32 to 2-9/32")	RC-2200	3/4"	186(7-5/16")	10,000	RCK-280	RCK-280L	ICK-60
90(3-9/16")	4	18-58(25/32 to 2-9/32")	RC-2202	3/4"	186(7-5/16")	10,000	RCK-282	RCK-282L	ICK-60
90(3-9/16")	5	18-58(25/32 to 2-9/32")	RC-2204	3/4"	186(7-5/16")	10,000	RCK-284	RCK-284L	ICK-60
90(3-9/16")	6	18-58(25/32 to 2-9/32")	RC-2206	3/4"	186(7-5/16")	10,000	RCK-286	RCK-286L	ICK-60
90(3-9/16")	8	20-60(13/16" to 2-3/8")	RC-2208	3/4"	186(7-5/16")	10,000	RCK-288	RCK-288L	ICK-60
90(3-9/16")	10	22-62(7/8" to 2-7/16")	RC-2210	3/4"	186(7-5/16")	10,000	RCK-289	RCK-289L	ICK-60
90(3-9/16")	45°	12-62(1/2" to 2-7/16")	RC-2212	3/4"	186(7-5/16")	10,000	RCK-290	RCK-290L	ICK-60
Complete Set	3-10 & 45°	12-62(1/2" to 2-7/16")	RC-2214	3/4"	186(7-5/16")	10,000			

Available in 25x55 (1" to 2-5/32") - Special Order.

Wood profiles shown at actual size. 3D renderings & tool illustrations not shown at actual size.

For a complete replacement parts listing for the above tools please refer to our website: www.amanatool.com

**Amana Tool®**



CNC Router Bits



Spiral & Compression



PLUNGE



Miter Fold & Signmaking



Chamfering & Profiling



Rabbeting



Door Making



Jointing



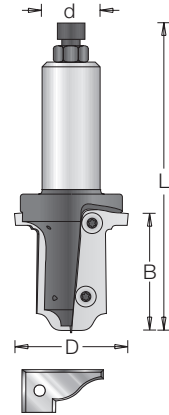
Grooving



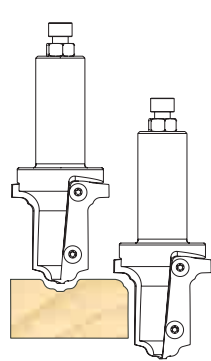
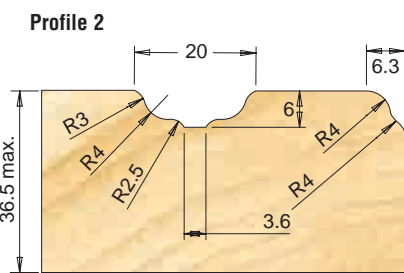
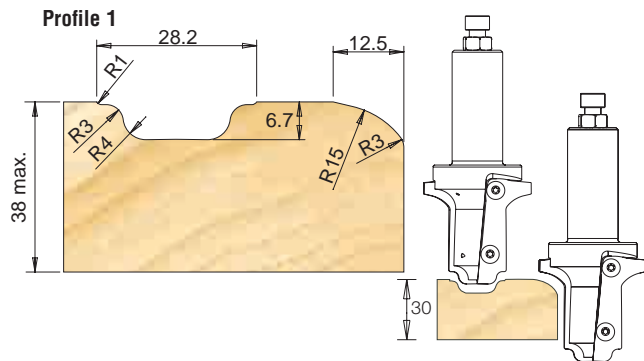
Planing & Hogging

INSERT MULTI PURPOSE PROFILE ROUTER BIT

Insert straight router bit with two cutting flutes. Suitable for profiling in softwood, hardwood and man-made board (with or without coating). Tool will be supplied with standard inserts (profile 1 or 2), or can be supplied with special inserts, ground to the customer's own specification. For use on routers and machining centers with CNC control.

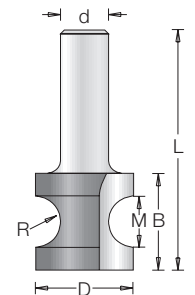


ØD	B	Profile	Ød	Tool No.	L	Max. RPM	Repl. T.C. Knife
50(2")	60(2-3/8")	1	3/4"	RC-2360	120(4-3/4")	18,000	RCK-172
50(2")	60(2-3/8")	2	3/4"	RC-2362	120(4-3/4")	18,000	RCK-174



BULLNOSE 2 FLUTE & 3 FLUTE

Shape the full edge of a workpiece with a bullnose radius bit. Ideal for shaping stair treads, window sills, table and counter edges, shelves, and making moldings. The "nose diameter" (M) is the thickness of stock that can be nosed, i.e., given a full 180-degree roundover. Flats at top and bottom of the cutting edges create fillets on stock thicker than the nose diameter. Must be used with an edge guide on handheld routers or the fence on a router table.



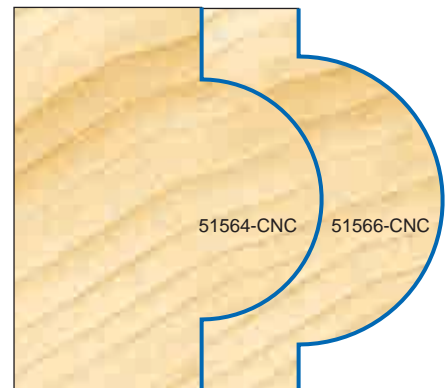
*'M'	R	B	Flute	Tool No.	ØD	Ød	L	Max. RPM
1-1/4	5/8	2	2	★51564-CNC	2	1/2	3-1/2	18,000
1-1/2	3/4	2	3	★51566-CNC	2-3/8	1/2	3-1/2"	18,000

*'M' denotes thickness of material on which a full 180 roundover can be accomplished.

★**WARNING:** These tools have an open flute design (not anti-kickback) and are intended for high feed-rate CNC machine use only. Do not use in portable routers.



For solid carbide spiral & compression bits see pages 9-11





Spiral & Compression



Straight Plunge



Miter Fold & Signmaking



CHAMFERING & PROFILING



Rabbeting



Door Making



Jointing



Grooving



Planing & Hogging

CNC Router Bits

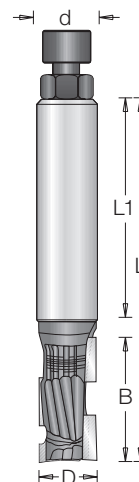
DIAMOND TECHNOLOGY

POLYCRYSTALLINE DIAMOND (PCD)

If you're looking for the ultimate in tooling, you've found it. Our Polycrystalline Diamond tooling will cut a wide variety of tough, abrasive materials including particleboard, medium density fiberboard (MDF), plywood and plastic. Yet the cutting edge lasts up to 200 times longer than carbide. In the long run Polycrystalline Diamond is the most economical choice.

DIAMOND TIPPED (PCD) ROUTER BIT UP/DOWN-SHEAR W/CARBIDE PLUNGE POINT RH ROTATION

Diamond tipped router bit for grooving, jointing & rabbeting in composite materials (particleboard, MDF both raw or with melamine, veneer, hardwood, etc.). Up/Down-shear for double sided material. Resharpener one to two times. Number of blades 1+1.

**CNC ROUTER BITS**

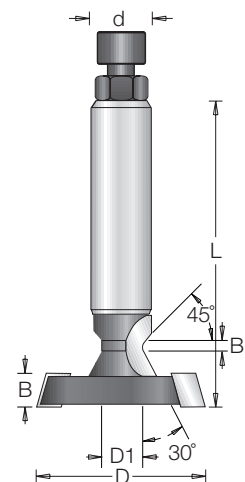
CHIPBOARD WITH PLASTIC COATING
Multipliers for Different Materials:
MDF: 0.8, Chipboard without coating: 1.1
Cross grain veneer: 0.7

Feed Rate mm/min Feed Rate inches/min

ØD	B	Ød	L1	L	Tool No.	Max. RPM	FROM	UP TO	FROM	UP TO
1/2	1	1/2	1-3/8	2-3/4	DRB-200	30,000	5,400	9,000	213	354
1/2	1	1/2	1-3/4	3-3/8	DRB-204	30,000	5,400	9,000	213	354
1/2	1-3/8	1/2	1-3/4	3-3/4	DRB-208	30,000	5,040	8,400	198	331
5/8	1	1/2	1-3/8	2-7/8	DRB-212	27,000	6,300	9,450	248	372
5/8	1-5/8	5/8	1-3/4	4	DRB-216	27,000	3,600	5,400	128	170
3/4	1	3/4	2	3-3/8	DRB-220	24,000	7,560	10,080	298	397
3/4	1-3/8	3/4	2	3-3/4	DRB-224	24,000	6,660	8,880	262	350
3/4	1-5/8	3/4	2	4	DRB-228	24,000	5,760	7,680	227	302
3/4	2-1/16	3/4	2	4-1/2	DRB-232	24,000	4,500	6,000	0	0

DIAMOND TIPPED (PCD) 'T' SLOT ROUTER BIT

'T' Slot diamond tipped router (standard 'T' slot). Use with particleboard MDF, both raw or with melamine, veneer, hardwood, etc. Re-sharpener one to two times.



ØD	B	D1	# of blades	Tool No.	B1	Ød	L	Max. RPM
1-3/8	1/4	3/8	2+1	DRB-300-RH	1/16	1/2	2-3/8	30,000
1-3/8	1/4	3/8	2+1	DRB-304-LH	1/16	1/2	2-3/8	30,000

Wood profiles shown at actual size. 3D renderings & tool illustrations not shown at actual size.

For a complete replacement parts listing for the above cutters please refer to our website: www.amanatool.com

Amana Tool®

REPLACEMENT PARTS — ADAPTER/HOLDER

STRAIGHT ADAPTER FOR ER COLLETS

ØD	Adapter Standard	Tool No.	B	Ød	Collet Standard
50(2")	—	H0-100	55(2-5/32")	20(7/8")	ER32
63(2-1/2")	—	H0-104	55(2-5/32")	25(1")	ER40

STRAIGHT ADAPTER FOR ER32 COLLETS

ØD	Adapter Standard	Tool No.	B	Collet Standard
50(2")	M2	H0-108	60(2-3/8")	ER32

ISO TOOL HOLDER WITH PULL STUD FOR MORBIDELLI & SCM MACHINES

ØD	Adapter Standard	Tool No.	B	Collet Standard
50(2")	ISO30	H0-112	55(2-5/32")	ER32

ISO TOOL HOLDER

D	Adapter Standard	Tool No.	B	Collet Standard
50(2")	ISO30	H0-116	50(2")	ER32
63(2-1/2")	ISO30	H0-120	55(2-5/32")	ER40
50(2")	ISO40	H0-124	63(2-1/2")	ER32
63(2-1/2")	ISO40	H0-128	73(2-7/8")	ER40

HSK TOOL HOLDER

ØD	Adapter Standard	Tool No.	B	Collet Standard
50(2")	HSK63F	H0-132	68(2-11/16")	ER32
63(2-1/2")	HSK63F	H0-136	68(2-11/16")	ER40

ISO TOOL HOLDER WITH ARBOR FOR MORBIDELLI MACHINES*

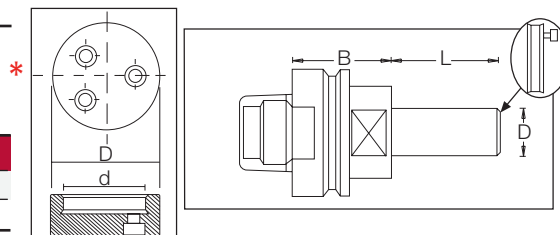
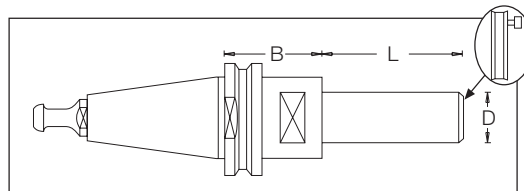
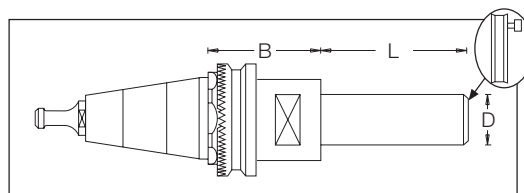
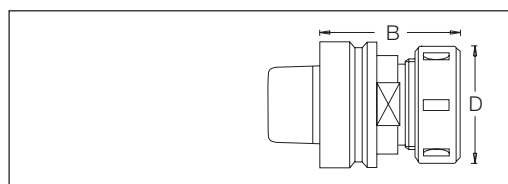
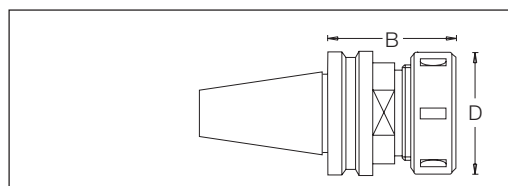
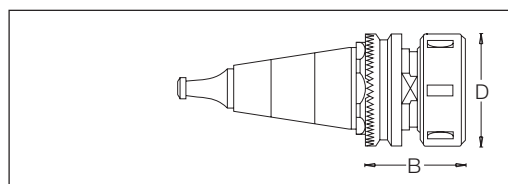
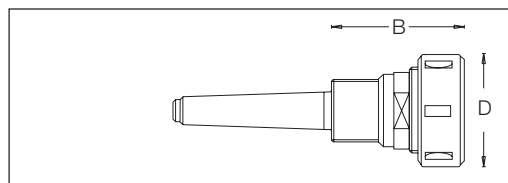
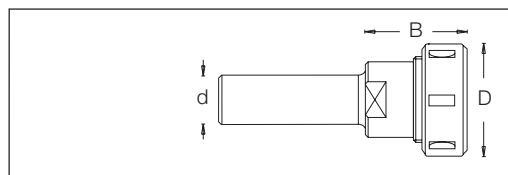
ØD	Adapter Standard	Tool No.	B	L
30(1-3/16")	ISO30	H0-140	35(1-3/8")	70(2-3/4")
30(1-3/16")	ISO30	H0-144	35(1-3/8")	100(4")

ISO TOOL HOLDER WITH ARBOR*

ØD	Adapter Standard	Tool No.	B	L
30(1-3/16")	ISO30	H0-148	35(1-3/8")	70(2-3/4")
30(1-3/16")	ISO30	H0-152	35(1-3/8")	100(4")

HSK TOOL HOLDER WITH AN ARBOR*

ØD	Adapter Standard	Tool No.	B	L
30(1-3/16")	HSK63F	H0-156	33(1-5/16")	70(2-3/4")
30(1-3/16")	HSK63F	H0-160	33(1-5/16")	100(4")



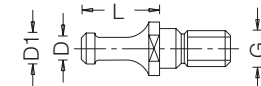
*Fixing flange on arbor supplied with screws.



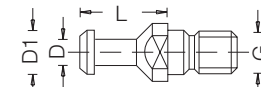
REPLACEMENT PARTS — RETAINING STUD FOR MACHINES



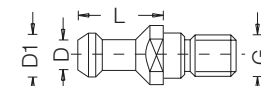
Machine	ØD1	ØD	Tool No.	Adapter	L	G
Morbidelli, SCM	8.5(11/32")	6.5(1/4")	CO-300	ISO30	22(7/8")	M10



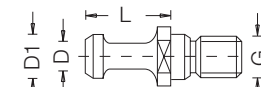
Busellato, Weeke, Bulleri, Maka	13(1/2")	9(3/8")	CO-304	ISO30	24(15/16")	M12
Cosmec, Reichenbacher	19(3/4")	14(9/16")	CO-308	ISO40	26(1-1/32")	M16



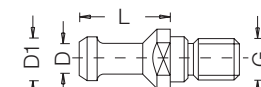
Alberti, Vitap, Masterwood	13(1/2")	9(3/8")	CO-312	ISO30	24(15/16")	M12
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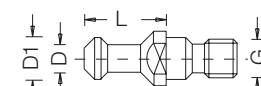
Esseteam	12(15/32")	8(5/16")	CO-316	ISO30	24(15/16")	M12
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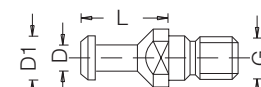
CMS	12.8(1/2")	9(3/8")	CO-320	ISO30	24(15/16")	M12
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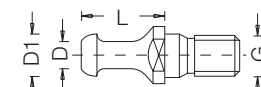
Belotti	13(1/2")	9(3/8")	CO-324	ISO30	23(15/16")	M12
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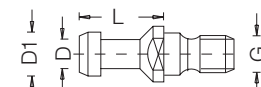
Biesse	13(1/2")	9(3/8")	CO-328	ISO30	24(15/16")	M12
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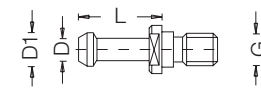
Biesse, Masterwood	12(15/32")	8(5/16")	CO-332	ISO30	24(15/16")	M12
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Komo	13(1/2")	9(3/8")	CO-336	BT30	24(15/16")	M12
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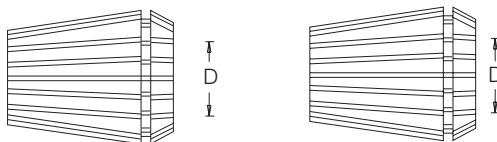


Shoda (BT30-BT40), Heian (BT35)	11(7/16")	7(9/32")	CO-340	BT30	23(15/16")	M12
	13(1/2")	8.5(11/32")	CO-344	BT35	28(1-1/8")	M12
	15(19/32")	10(13/32")	CO-348	BT40	35(1-3/8")	M16





REPLACEMENT PARTS — COLLETS FOR ER32 NUT & ER40 NUT



ØD	ER32 Tool No.	ER40 Tool No.
2-3	C0-100	-
3-4	C0-104	C0-200
4-5	C0-108	C0-202
5-6	C0-112	C0-204
6-7	C0-116	C0-206
7-8	C0-120	C0-208
8-9	C0-124	C0-210
9-10	C0-130	C0-212
10-11	C0-134	C0-214
11-12	C0-138	C0-216
12-13	C0-142	C0-218
13-14	C0-146	C0-220
14-15	C0-150	C0-222
15-16	C0-154	C0-224
16-17	C0-158	C0-226
17-18	C0-162	C0-228
18-19	C0-166	C0-230
19-20	C0-170	C0-232
20-21	—	C0-234
21-22	—	C0-236
22-23	—	C0-238
23-24	—	C0-240
24-25	—	C0-242
25-26	—	C0-244
1/4"	C0-174	C0-246
3/8"	C0-178	C0-248
1/2"	C0-182	C0-250
5/8"	C0-186	C0-252
3/4"	C0-190	C0-254



REPLACEMENT PARTS — KEY

ØD	Tool No.
For ER32 nut	WR-100
For ER40 nut	WR-104



For CNC Collets see page 146.



CNC Router Bit Feed Rate Info

The following charts give you the **recommended** feed rates for working with different spiral family groups on different wood types, plastics & aluminium. 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.

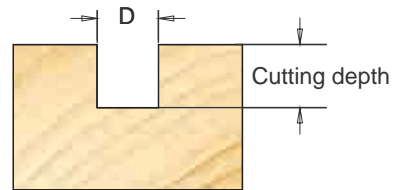
Explanation of the charts

Each chart is relating to one type of the different tool families on a different type of wood. Each line on a chart is relating to the cutting diameter of the tool. If you cannot find the exact diameter, please relate it as a parallel line to the existing lines.

The information on the charts require a rotation speed of 18,000 RPM. Changing the rotation speed has a proportionally straight relation to the feed rate. For example, if your tool is rotating at 12,000 RPM you have to decrease the feed rate by the relation of 12,000/18,000. Cutting depth or wood thickness is given with values which relate to the diameter. For example, cutting diameter is 10mm and wood thickness is 20mm so it becomes a cutting depth of 2xD.

How to get a feed rate value from the chart

1. Choose the correct chart according to the tool family and the wood type.
2. Locate your line on the chart according to diameter size.
3. Evaluate your cutting depth according to the cutting diameter - is it equal to 1xD or 2xD or 1.5xD, etc.
4. Find the right feed rate according to the wood thickness on the chart.

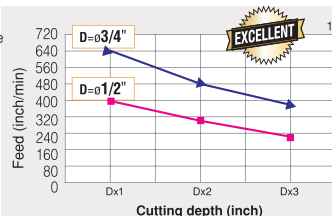
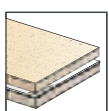


Solid Carbide Spiral W/Chipbreaker

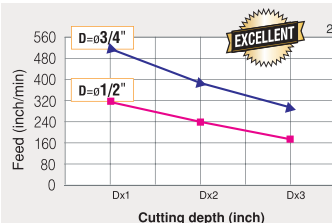
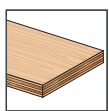


Refer to page 11

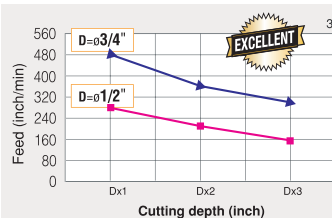
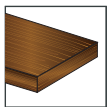
particle boards
laminates/unlaminates



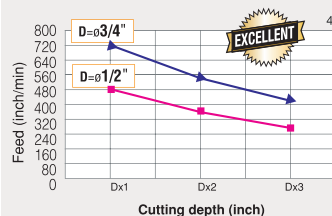
plywood laminates/
unlaminates



hardwood



softwood



Solid Carbide Spiral Flute Plunge



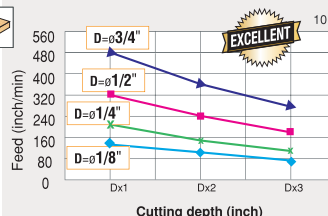
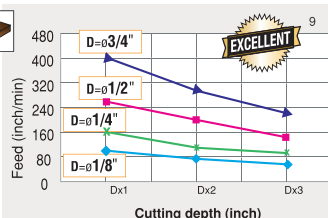
Refer to page 10



NOT RECOMMENDED
Amana Tool® doesn't recommend using the Solid Carbide Spiral Flute Plunge router bit on Particle Boards.



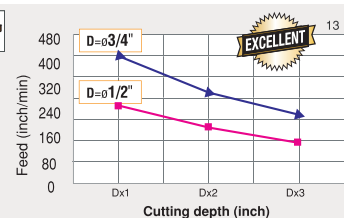
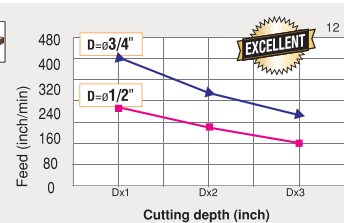
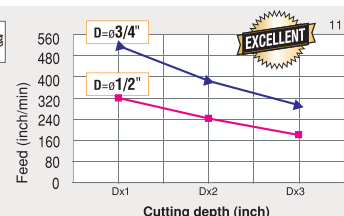
NOT RECOMMENDED
Amana Tool® doesn't recommend using the Solid Carbide Spiral Flute Plunge router bit on Plywood.



Spiral Flute Plunge Solid Carbide



Refer to page 8



NOT RECOMMENDED
Amana Tool® doesn't recommend using the Spiral Flute Plunge Solid Carbide router bit on Softwood

CNC Router Bit Feed Rate Info

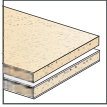


Solid Carbide Spiral Roughing W/Chipbreaker



Refer to page 11

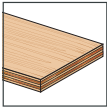
particle boards
laminates / unlaminates



NOT RECOMMENDED

Amana Tool® doesn't recommend using the Solid Carbide Spiral Roughing with Chipbreaker router bit on Particle Boards.

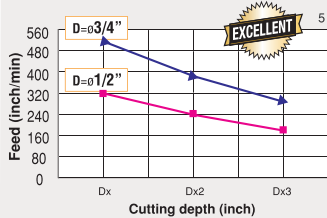
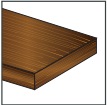
plywood laminates / unlaminates



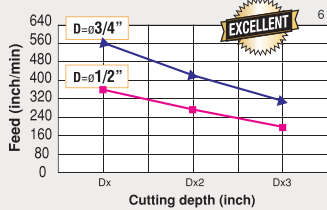
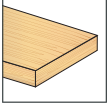
NOT RECOMMENDED

Amana Tool® doesn't recommend using the Solid Carbide Spiral Roughing with Chipbreaker router bit on Plywood.

hardwood



softwood



Compression Spiral for Solid Wood



Refer to page 10



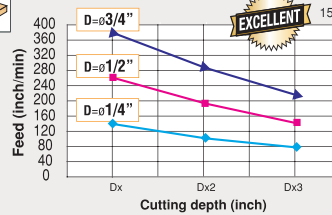
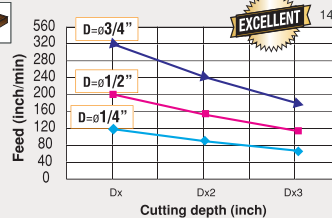
NOT RECOMMENDED

Amana Tool® doesn't recommend using the Compression Spiral for Solid Wood router bit on Particle Boards.



NOT RECOMMENDED

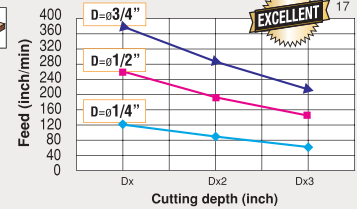
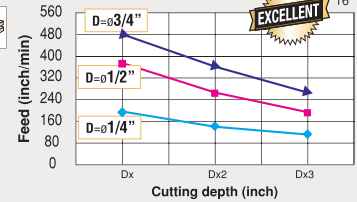
Amana Tool® doesn't recommend using the Compression Spiral for Solid Wood router bit on Plywood.



Compression Spiral for MDF/Laminate



Refer to page 9



NOT RECOMMENDED

Amana Tool® doesn't recommend using the Compression Spiral MDF/Laminate router bit on Hardwood.



NOT RECOMMENDED

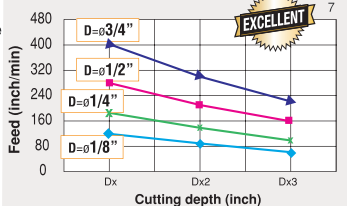
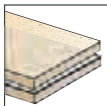
Amana Tool® doesn't recommend using the Compression Spiral MDF/Laminate router bit on Softwood.

Spiral Flute Plunge for Solid Wood

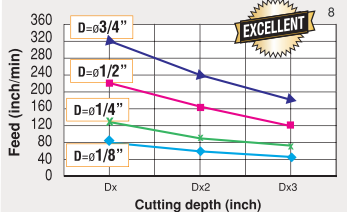
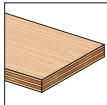


Refer to page 8

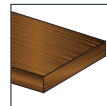
particle boards
laminates / unlaminates



plywood laminates / unlaminates



hardwood



NOT RECOMMENDED

Amana Tool® doesn't recommend using the Spiral Flute Plunge for Solid Wood router bit on Hardwood.

softwood



NOT RECOMMENDED

Amana Tool® doesn't recommend using the Spiral Flute Plunge for Solid Wood router bit on Softwood.