Edge of Arlington Saw & Tool, Inc.

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Item #AMS-146, Amana AMS Series 3-Pc Solid Carbide Upcut Spiral 2D/3D Carving Ball Nose ZrN Coated CNC Router Bit Set, 1/4" Shank, 1/16" , 1/8" , 1/4" Diameters $211.00

Thank you for shopping with us!

Specially designed for 2D and 3D CNC profiling and carving in plastic, aluminum, and wood with CNC machines. The high-shear ball nose tips cut smooth 2D and 3D contours with reduced stepping while the proprietary ZrN coating (applied by the physical vapor deposition coating process) provides high resistance to wear, sharper cutting edges, extended tool life, and less friction and heat buildup. Some of Amana Tool carving tools, as you can appreciate, have a very small diameter; therefore any material chip-loads need to reflect that small size. It can however withstand RPM's up to 60,000 RPMs. A directed air-blast to keep chips away along with cooling the tool and workpiece are always welcome. Tools are manufactured with high balance that allows them to run up to 60,000 RPMs. Adjust your chip load and feed rate accordingly.

Applications:
• Precision 2D and 3D large scale carving
• Dimensional signage
• 3D millwork
• 2D and 3D contouring, profiling, modeling, and pattern-making for cabinetry, sign-making, furniture-making, and jewelry mold-making
• Compatible with CarveWright™ and CompuCarve woodworking systems
• Perfect for model-makers on large 3D milling profiles in abrasive EPS foam and other materials
Benefits of Zirconium Nitride (ZrN) Coating:
Creates a harder and tougher cutting edge that allows for a prolonged cutting edge life and helps to prevent the buildup of material in the flutes while cutting. Has the tendency to run/spin much faster than an uncoated tool. Optimized flute geometry and low Total Indicated Runout (TIR) guarantees clean cuts, essentially eliminates sanding, and reduces chatter (where the machine or workpiece vibrates) under high chip loads (when used with low TIR spindles). High flute volume supports high feed rates and chip loads. High aspect ratio for single pass deep-reach cutting. Flute geometry optimized for cutting sign foam, sign board, hardwoods, thermoplastics, and phenolic composites.

Milling Plastics: In a milling application, all plastics tend to behave differently so attention must be paid first and foremost to heat input, as that greatly impacts surface finish and chip control. Suggested starting spindle speed might be 18,000 RPM; there needs to be some experimenting on the part of the programmer to best find an acceptable finish.

SPECIFICATIONS	
Manufacturer	Amana Tool
Includes	1/4 in Shank, 1/16 in, 1/8 in, 1/4 in Diameters
Shank	1/4 in
No. of Pieces	3
Note	Specifically designed for precision 2D & 3D applications
Part Desc	Solid Carbide Carving Ball Nose Router Bit Set