## Edge of Arlington Saw & Tool, Inc.

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# Item #DRB-224, Amana Tool CNC Polycrystalline Diamond (PCD) Tipped Compression Up/Down Shear R/H Direction 3/4" Dia x 1 3/8" CH x 3/4" Shank Router Bit (Industrial) \$263.40

Thank you for shopping with us!

Diamond is the hardest naturally-occurring material on the earth. Polycrystalline Diamond (PCD) tooling is manufactured in a high-temperature and high-pressure laboratory that fuses diamond particles onto a carbide substrate, which allows the diamond to be brazed onto a tool body.

If you're looking for the ultimate in tooling, you've found it. Our diamond router bits will cut a wide variety of tough, abrasive materials. The cutting edge lasts up to 100 times longer than carbide; in the long-run, PCD is the most economical choice. Diamond-tipped compression with carbide plunge point router bits for grooving, jointing & rabbeting in composites, MDF (both raw or with melamine), laminate, plastic, wood, veneers, and more. Up/Downshear for double-sided material.

#### **Excellent for Cutting:**

- Fiberglass Reinforced Composites
- Lightweight composites
- Custom composite materials
- Fiber-reinforced urethane
- Fiber-reinforced structural foam floors
- And More . . .

#### **Benefits of Diamond Technology**

- Improved cycle times by enabling high material removal rates
- Faster speeds and feeds compared to conventional cutting tools
- Improved workpiece quality with tight dimensional control
- Optimized machine tool efficiency by increasing production capacity
- Consistently good component surface finish
- Can be reground up to 5 to 7 times
- Wear rate is much less than the carbide-tipped tools







### PCD\* CNC Up/Down Shear Compression Router Bit Speed and Feed Chart



Tool No.	Diameter	No. Teeth	Chip Load Per Tooth	RPM	Feed Rate
	Inch/mm		Inch (mm)/min		Inch (mm)/min
DRB-200	1/2" (12.7mm)	1+1	.008" (0.20mm)	18,000	140" (3,600mm)
DRB-208	1/2" (12.7mm)	1+1	.008" (0.20mm)	18,000	140" (3,600mm)
DRB-212	5/8" (15.9mm)	1+1	.008" (0.20mm)	18,000	140" (3,600mm)
DRB-216	5/8" (15.9mm)	1+1	.008" (0.20mm)	18,000	140" (3,600mm)
DRB-224	3/4" (19.1mm)	1+1	.01" (0.25mm)	18,000	180" (4,500mm)

Multipliers for different materials: 0.8% = MDF with or without Coating 1.1% = Chipboard with or without Coating 0.7% = Cross grain veneer

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: RPM x # of flutes x chip load
To find Chip Load = Feed Rate
RPM x # of Flutes

SPECIFICATIONS		
Manufacturer	Amana Tool	
Diameter	3/4 in	
Flute Geometry	Upcut/Downcut	
Flute	1+1	
Length	2 in Shank Length	
Overall Length	3 3/4 in	
Rotation	Right	
RPM	24,000	
Shank	3/4 in	
Style	Compression with carbide plunge point	