



Hard Plywood Cutting Data

DEPTH OF CUT: 1 x D Use recommended chip load
 2 x D Reduce chip load by 25%
 3 x D Reduce chip load by 50%

APPLICATION	GOOD	BETTER	BEST
Single Pass	60-300/60-350	60-100	60-100C
Roughing	60-800	60-000	60-850
Finishing			60-300/60-350

CHIP LOAD PER TOOTH

		Cutting Edge Diameter															
Series	Cut	1/16	3/32	1/8	5/32	3/16	7/32	1/4	5/16	3/8	7/16	1/2	9/16	5/8	3/4	7/8	1
13-50	1 x D											.016-.018			.018-.020		
37-50/60	1/2 CED					.001-.003		.001-.003		.002-.004		.003-.005			.005-.007		.007-.009
38-50/60	1/2 CED			.0005-.0025		.001-.003		.001-.003		.002-.004		.003-.005		.004-.006	.005-.007		
39-00	1 x D																.003-.005
40-50	1 1/2											.003-.005					
48-000	1 x D					.004-.006	.004-.006	.005-.007	.005-.007	.006-.008		.007-.009	.007-.009	.008-.010	.009-.011	.010-.012	.011-.013
48-500	1 x D							.005-.007		.006-.008		.007-.009			.009-.011		
48-700	1 x D							.005-.007		.006-.008		.007-.009		.008-.010	.009-.011		.011-.013
56-200	1 x D			.003-.005	.003-.005	.004-.006	.004-.006	.005-.007	.005-.007	.006-.008	.006-.008	.007-.009		.008-.010	.009-.011		
60-000	1 x D									.014-.016		.016-.018		.018-.020	.020-.022		
60-000	1 x D									.017-.019		.019-.021		.021-.023	.023-.025		
60-090	1 x D													.003-.005			
60-100	1 x D			.012-.018		.012-.018		.014-.016		.016-.018		.018-.020		.020-.022	.022-.024		
60-100DE	1 x D							.014-.016		.016-.018		.018-.020		.020-.022	.022-.024		
60-1003E	1 x D									.020-.022		.022-.024			.026-.028		
60-100C	1 x D									.019-.021		.021-.023		.023-.025	.025-.027		
60-300/ 60-400	1 x D									.019-.021		.021-.023		.023-.025	.025-.027		
60-350/ 60-430	1 x D									.018-.020		.020-.022		.022-.025	.024-.026		
60-500/ 500M	1 x D											.039-.041		.043-.045	.047-.049		
60-600	1 x D											.027-.029		.030-.032	.032-.034		
60-700	1 x D											.027-.029		.029-.031	.032-.034		
60-900	1 x D									.017-.019		.019-.021					
60-950	1 x D									.019-.021		.021-.023					
61-200	1 x D			.005-.007		.006-.008		.007-.009	.007-.009	.008-.010		.009-.011					
64-000/ 65-000	1 x D	.001-.003		.002-.004		.003-.005		.004-.006		.005-.007							
60-800	1 x D									.017-.019		.019-.021		.021-.023	.023-.025		
60-850	1 x D									.017-.019		.019-.021					

FORMULAS: Chip Load = Feed Rate / (RPM x # of cutting edges)
 Feed Rate = RPM x # of cutting edges x chip load
 Speed (RPM) = Feed Rate / (# of cutting edges x chip load)

Chipload Instructions and Example

Instructions

1. Find the cutting data for the material being cut
2. Find the series number of the selected tool under the series column
3. Move across until you find the cutting edge diameter of the tool
4. Note the chipload range.

Example

60-311 selected to cut Hard Plywood

60-300 series

1/2" diameter tool

.021" - .023" chipload range

Feedrate = RPM x # of cutting edges x chipload.

$18,000 \times 2 \times .021 = 756 \text{ IPM}$

$18,000 \times 2 \times .023 = 828 \text{ IPM}$

(RPM = tools are recommended to cut at 18,000 RPM but the customer can vary it based on their machine)