

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	52-900/57-900	60-100	52-200/57-200
Roughing	60-800	60-000	60-850
Finishing		52-200/57-200	60-200

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
10-00	1 x D	.004-.006	.004-.006	.005-.007	.005-.007	.006-.008	.006-.008	.007-.009	.007-.009	.008-.010	.008-.010	.009-.011	.009-.011	.010-.012	.011-.013	.012-.014	.013-.015
14-00	2											.017-.019					
15-00	2											.017-.019					
16-50	Varies	.001-.003	.002-.004	.003-.005													
30-00	Varies	.0005-.0015	.0005-.0015	.001-.003	.001-.003	.001-.003	.001-.003	.002-.004	.002-.004	.003-.005	.003-.005	.003-.005	.004-.006	.004-.006	.005-.007	.006-.008	.007-.009
37-50/60	1/2 CED					.001-.003		.002-.004		.003-.005		.003-.005			.005-.007		.007-.009
38-00	1/2 CED			.001-.003		.001-.003		.002-.004		.003-.005		.003-.005					
38-50/60	1/2 CED			.001-.003		.001-.003		.002-.004		.003-.005		.003-.005		.004-.006	.005-.007		
39-00	1/2																.004-.006
40-50	1 1/2											.003-.005					
40-000	1 x D			.002-.004	.002-.004	.003-.005	.003-.005	.004-.006	.004-.006	.005-.007		.006-.008					
40-100	1 x D			.005-.007		.005-.007	.005-.007	.006-.008	.006-.008	.007-.009		.008-.010			.010-.012		
40-300	1 x D			.005-.007	.005-.007	.005-.007		.006-.008		.007-.009		.008-.010					
52-200/57-200	1 x D			.006-.008	.006-.008	.006-.008	.006-.008	.007-.009	.007-.009	.008-.010	.008-.010	.009-.011	.009-.011	.010-.012	.011-.013		
52-400/57-400	1 x D				.006-.008	.006-.008		.007-.009	.007-.009	.008-.010		.009-.011	.009-.011	.010-.012	.011-.013	.012-.014	
52-900	1 x D							.007-.009		.008-.010		.009-.011					
56-200	1 x D			.004-.006	.004-.006	.005-.007	.005-.007	.006-.008	.006-.008	.007-.009	.007-.009	.008-.010		.009-.011	.010-.012		
57-900	1 x D							.007-.009		.008-.010		.009-.011					
60-000	1 x D									.013-.015		.015-.017		.017-.019	.019-.021		
60-000	1 x D									.016-.018		.018-.020		.020-.022	.022-.024		
60-090	1 x D													.005-.007			
60-100	1 x D			.011-.013		.013-.015		.015-.017		.017-.019		.019-.021		.021-.023	.023-.025		
60-100DE	1 x D							.018-.020		.020-.022		.022-.024		.024-.026	.026-.028		
60-1003E	1 x D									.017-.019		.019-.021			.021-.023		
60-100C	1 x D									.024-.026		.026-.028		.028-.030	.030-.032		
60-200/67-470	1 x D							.005-.007		.006-.008		.007-.009			.008-.010		
60-300/60-400	1 x D									.024-.026		.026-.028		.028-.030	.030-.032		
60-350/60-430	1 x D									.017-.019		.019-.021			.021-.023		
60-450	1 x D							.005-.007	.006-.008			.007-.009		.008-.010	.009-.011		
60-500/500M	1 x D											.015-.017		.017-.019	.019-.021		
60-600	1 x D											.019-.021		.021-.023	.023-.025		
60-700	1 x D											.019-.021		.021-.023	.023-.025		
60-900	1 x D									.017-.019		.018-.020					
60-950	1 x D									.024-.026		.026-.028					
61-000	1 x D			.008-.010	.008-.010	.009-.011	.009-.011	.010-.012	.010-.012	.011-.013	.011-.013	.012-.014					
61-200	1 x D			.008-.010		.009-.011		.010-.012	.010-.012	.011-.013		.012-.014					
62-200/63-200	1 x D			.010-.012		.011-.013		.012-.014	.012-.014	.013-.015		.014-.016					
64-000/65-000	1 x D	.001-.003		.002-.004		.003-.006		.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

52-280 selected to cut Soft Wood

52-200 series

1/4" diameter tool

.007" - .009" chipload range

Feedrate = RPM x # of cutting edges x chipload.

$18,000 \times 2 \times .007 = 252 \text{ IPM}$

$18,000 \times 2 \times .009 = 324 \text{ IPM}$

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