Chip Load Charts

These charts are base on VERY conservative values

CHIP LOAD BASED ON 2 FLUTE TOOLS

	SPINDLE RPM'S IN THOUSANDS									
FEED RATE	10000	11000	12000	13000	14000	15000	16000	17000	18000	19000
50	0.003	0.002	0.002	0.002	0.002	0.002	0.002	0.001	0.001	0.001
100	0.005	0.005	0.004	0.004	0.004	0.003	0.003	0.003	0.003	0.003
150	0.008	0.007	0.006	0.006	0.005	0.005	0.005	0.004	0.004	0.004
200	0.010	0.009	0.008	0.008	0.007	0.007	0.006	0.006	0.006	0.005
250	0.013	0.011	0.010	0.010	0.009	0.008	0.008	0.007	0.007	0.007
300	0.015	0.014	0.013	0.012	0.011	0.010	0.009	0.009	0.008	0.008
350	0.018	0.016	0.015	0.013	0.013	0.012	0.011	0.010	0.010	0.009
400	0.020	0.018	0.017	0.015	0.014	0.013	0.013	0.012	0.011	0.011
450	0.023	0.020	0.019	0.017	0.016	0.015	0.014	0.013	0.013	0.013
500	0.025	0.023	0.021	0.019	0.018	0.017	0.016	0.015	0.014	0.014
550	0.028	0.025	0.023	0.021	0.020	0.018	0.017	0.016	0.015	0.015
600	0.030	0.027	0.025	0.023	0.021	0.020	0.019	0.018	0.017	0.017
Inches per min.										

CONSERVATIVE VALUES IN THE GRAY

CHIP LOAD BASED ON 3 FLUTE TOOLS

	SPINDLE RPM'S IN THOUSANDS									
FEED RATE	12000	13000	14000	14500	15000	16000	17000	18000	18500	19000
100	0.003	0.003	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
150	0.004	0.004	0.004	0.003	0.003	0.003	0.003	0.003	0.003	0.003
200	0.006	0.005	0.005	0.005	0.004	0.004	0.004	0.004	0.004	0.004
250	0.007	0.006	0.006	0.006	0.006	0.005	0.005	0.005	0.005	0.004
300	0.008	0.008	0.007	0.007	0.007	0.006	0.006	0.006	0.005	0.005
350	0.010	0.009	0.008	0.008	0.008	0.007	0.007	0.006	0.006	0.006
400	0.011	0.010	0.010	0.009	0.009	0.008	0.008	0.007	0.007	0.007
450	0.013	0.012	0.011	0.010	0.010	0.009	0.009	0.008	0.008	0.008
500	0.014	0.013	0.012	0.011	0.011	0.010	0.010	0.009	0.009	0.009
550	0.015	0.014	0.013	0.013	0.012	0.011	0.011	0.010	0.010	0.010
600	0.017	0.015	0.014	0.014	0.013	0.013	0.012	0.011	0.011	0.011
650	0.018	0.017	0.015	0.015	0.014	0.014	0.013	0.012	0.012	0.012
700	0.019	0.018	0.017	0.016	0.016	0.015	0.014	0.013	0.013	0.013
Inches per min.										

CONSERVATIVE VALUES IN THE GRAY

A RANGE OF .007 TO .012 CHIP LOAD IS IDEAL
TO LITTLE CHIP LOAD AND YOU BURN UP THE TOOL
TO HIGH A CHIP LOAD AND YOU BREAK THE TOOL

It is very likely that you will have good results up to 0.017 chip load.

If you would like to calculate your chip load use this formula: Feed Rate in inches per minute divided by RPM's divided by number of cutting edges. Example: Feed Rate of 500in/min divided by 18,000 RPM's divided by 2 (2 flute tool) equals 0.014 chip load.

Find this and other useful tools on our website at www.southeasttool.com