



Laminated Chipboard Cutting Data

APPLICATION	GOOD	BETTER	BEST
Single Pass	48-000	60-100	60-100C
Roughing			60-850

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%

CHIP LOAD PER TOOTH

		Cutting Edge Diameter															
Series	Cut	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	1-1/8	1-1/4
13-50	1 x D									.017-.019			.019-.021				
48-000	1 x D			.005-.007	.005-.007	.006-.008	.006-.008	.007-.009		.008-.010	.008-.010	.009-.011	.010-.012	.011-.013	.012-.014	.013-.015	.014-.016
60-100	1 x D	.013-.015		.014-.016		.015-.017		.016-.018		.018-.020		.019-.021	.021-.023				
60-100DE	1 x D					.017-.019		.019-.021		.021-.023		.025-.027	.027-.029				
60-1003E	1 x D							.020-.022		.022-.024			.024-.026				
60-100C	1 x D							.022-.024		.024-.026		.026-.028	.028-.030				
60-500/ 500m	1 x D									.021-.023		.023-.025	.025-.027				
60-600	1 x D									.028-.030		.030-.032	.032-.034				
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

60-163C selected to cut Laminated Plywood

60-100C 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)