



# Soft Plywood Cutting Data

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

**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	1/16	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										.016-.018							
37-50/60	1/2 CED				.001-.003		.001-.003		.002-.004		.002-.004			.004-.006		.006-.008		
38-50/60	1/2 CED		.0005-.0025		.001-.003		.002-.004		.002-.004		.003-.005		.003-.005	.004-.006				
39-00	1/2															.003-.005		
40-50	1 1/2										.003-.005							
48-000	1 x D				.005-.007	.005-.007	.005-.007	.006-.008	.006-.008		.007-.009	.007-.009	.008-.010	.009-.011	.010-.012	.011-.013	.012-.014	.013-.015
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		.013-.015		.014-.016		.015-.017		.016-.018		.018-.020		.020-.022	.022-.024				
60-100DE	1 x D						.017-.019		.019-.021		.021-.023		.023-.025	.025-.027				
60-1003E	1 x D								.020-.022		.022-.024			.024-.026				
60-100C	1 x D								.022-.024		.024-.026		.026-.028	.028-.030				
60-300/ 60-400	1 x D								.022-.024		.024-.026		.026-.028	.028-.030				
60-350 60-430	1 x D								.020-.022		.022-.024		.024-.026	.026-.028				
60-500/ 500M	1 x D										.021-.023		.023-.025	.025-.027				
60-600	1 x D										.028-.030		.030-.032	.032-.034				
60-700	1 x D										.028-.030		.030-.032	.032-.034				
60-900	1 x D								.017-.019		.019-.021							
60-950	1 x D								.022-.024		.024-.026							
61-200	1 x D		.006-.008		.007-.009		.008-.010	.008-.010	.009-.011		.010-.012							
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							

## 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 Soft 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)