

APPLICATION	GOOD	BETTER	BEST
Single Pass	52-900/57-900	52-200/57-200	60-300/60-350
Roughing	60-800	60-000	60-850
Finishing		60-300/60-350	60-200

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	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											.013-.015			.016-.018		
30-00	Varies	.0005-.001	.0005-.001	.001-.003	.001-.003	.001-.003	.001-.003	.001-.003	.002-.004	.002-.004	.002-.004	.002-.004	.003-.005	.003-.005	.004-.006	.004-.006	.006-.008
37-50/60	1/2 CED					.001-.003		.001-.003		.002-.004		.003-.005			.005-.007		.007-.009
38-50/60	1/2 CED			.001-.003		.001-.003		.001-.003		.002-.004		.003-.005		.004-.006	.005-.007		
39-00	1/2																.002-.004
40-50	1 1/2											.003-.005					
48-000	1 x D					.004-.006	.004-.006	.005-.007	.005-.007	.005-.007		.006-.008	.006-.008	.006-.008	.007-.009	.008-.010	.009-.011
48-500	1 x D							.005-.007		.005-.007		.006-.008			.009-.011		
48-700	1 x D							.005-.007		.005-.007		.006-.008		.006-.008	.007-.009		.009-.011
52-200/57-200	1 x D			.005-.007	.005-.007	.006-.008	.006-.008	.006-.008	.006-.008	.007-.009	.007-.009	.008-.010	.008-.010	.009-.011	.009-.011		
52-400/57-400	1 x D				.003-.005	.004-.006		.005-.007	.005-.007	.006-.008		.008-.010	.009-.011	.010-.012	.011-.013	.012-.014	
52-900	1 x D							.006-.008		.007-.009		.008-.010					
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		
57-900	1 x D							.006-.008		.007-.009		.008-.010					
60-000	1 x D									.012-.014		.013-.015		.014-.016	.016-.018		
60-000	1 x D									.017-.019		.018-.020		.020-.022	.023-.025		
60-090	1 x D													.004-.006			
60-100	1 x D			.010-.012		.010-.012		.013-.015		.014-.016		.016-.018		.017-.019	.019-.021		
60-100DE	1 x D							.013-.015		.014-.016		.016-.018		.018-.020	.019-.021		
60-1003E	1 x D									.014-.016		.016-.018			.018-.020		
60-100C	1 x D									.017-.019		.018-.020		.020-.022	.023-.025		
60-200/67-470	1 x D							.004-.006		.005-.007		.005-.007			.006-.008		
60-300/60-400	1 x D									.017-.019		.018-.020		.020-.022	.023-.025		
60-350/60-430	1 x D									.014-.016		.016-.018		.017-.019	.019-.021		
60-450	1 x D								.004-.006	.005-.007		.006-.008		.007-.009	.008-.010		
60-500/500M	1 x D											.014-.016		.016-.018	.018-.020		
60-600	1 x D											.020-.022		.022-.024	.024-.026		
60-700	1 x D											.020-.022		.022-.024	.024-.026		
60-900	1 x D									.017-.019		.019-.021					
60-950	1 x D									.017-.019		.018-.020					
61-200	1 x D			.007-.009		.008-.010		.009-.011	.009-.011	.010-.012		.011-.013					
62-200	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-.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

48-707 selected to cut MDF

48-700 series

1/2" diameter tool

.006" - .008" chipload range

Feedrate = RPM x # of cutting edges x chipload.

$18,000 \times 2 \times .006 = 216 \text{ IPM}$

$18,000 \times 2 \times .008 = 288 \text{ IPM}$

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