

Hard Plywood Cutting Data Recommendations

CW

APPLICATION	GOOD	BETTER	BEST
Single Pass	60-100MW	60-100C	60-100MC
Roughing		60-800	60-000

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%

Recommended Chip Load per Tooth by Cutting Diameter (in)																							
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	1 1/8	1 1/4	1 1/2	1 3/4	2	
37-00/37-20	Varies							.004-.006															
37-50	1/2 x D					.003-.006		.003-.006		.003-.006													
37-60	1/2 x D									.004-.006		.004-.006			.006-.008		.008-.010						
37-80	Varies																.004-.006		.004-.006*				.004-.006**
40-50	1 1/2											.003-.005											
48-000	1 x D					.004-.006		.005-.007	.005-.007	.006-.008		.007-.009		.008-.010	.009-.011	.010-.012	.011-.013						
52-200	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								
52-900	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		.007-.009			.009-.011								
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								
57-200MD	1 x D							.009-.011		.010-.012		.011-.013											
60-000 (LH)	1 x D									.014-.016		.016-.018		.018-.020	.020-.022								
60-000 (HH)	1 x D									.017-.019		.019-.021		.021-.023	.023-.025								
60-090	1 x D													.003-.005									
60-100MW	1 x D			.012-.014		.012-.014		.014-.016		.016-.018		.018-.020		.020-.022	.022-.024								
60-100C	1 x D									.019-.021		.021-.023		.023-.025	.025-.027								
60-100MC	1 x D									.019-.021		.021-.023											
60-100PLR	1 x D									.021-.023		.023-.025											
60-300	1 x D									.019-.021		.021-.023		.023-.025	.025-.027								
60-350	1 x D									.018-.020		.020-.022		.022-.025	.024-.026								
60-600	1 x D											.027-.029		.030-.032	.032-.034								
60-700	1 x D											.027-.029		.029-.031	.032-.034								
60-800	1 x D									.017-.019		.019-.021		.021-.023	.023-.025								
60-900	1 x D									.017-.019		.019-.021											
60-950	1 x D									.019-.021		.021-.023											
61-200	1 x D			.005-.007				.007-.009	.007-.009	.008-.010		.009-.011											
63-200	1 x D			.003-.005				.005-.007															
64-000/ 65-000	1 x D	.001-.003		.002-.004		.003-.005		.004-.006		.005-.007													
68-100	1 x D									.010-.012		.012-.014		.017-.019	.018-.020								
77-100				.003-.005				.005-.007															

* = 16,000 RPM
 ** = 15,000 RPM

FORMULAS: Chip Load = Feed Rate / (RPM x # of cutting edges)
 Feed Rate (IPM) = RPM x # of cutting edges x chip load
 Speed (RPM) = Feed Rate / (# of cutting edges x chip load)

DEFINITIONS: IPM = Inches Per Minute