

Laminated Chipboard Cutting Data Recommendations

APPLICATION	GOOD	BETTER	BEST
Single Pass	60-100MW	60-100MC	60-100PLR

DEPTH OF CUT: Greater than 3 x D, reduce chip load by 25%

Recommended Chip Load per Tooth by Cutting Diameter (in)																	
Series	Cut	1/8	3/16	7/32	1/4	5/16	3/8	1/2	9/16	5/8	3/4	7/8	1	1-1/8	1-1/4	1-1/2	2
37-00/37-20	Varies				.004-.006												
37-50	1/2 CED		.003-.006		.003-.006		.003-.006										
37-60	1/2 CED						.004-.006		.004-.006			.006-.008					
37-80	Varies												.004-.006			.004-.006	.004-.006
48-000	1 x D				.006-.008	.006-.008	.007-.009	.008-.010		.009-.011	.010-.012	.011-.013	.012-.014				
57-200		.003-.005	.003-.005	.004-.006	.004-.006	.005-.007	.005-.007	.006-.008		.007-.009	.007-.008						
57-200MD					.009-.011		.010-.012	.011-.013									
60-100MW	1 x D	.013-.015	.014-.016		.017-.019		.019-.021	.021-.023		.025-.027	.027-.029						
60-100C	1 x D						.022-.024	.024-.026		.026-.028	.028-.030						
60-100MC	1 x D						.019-.021	.021-.023									
60-100PLR	1 x D						.021-.023	.023-.025									
60-600	1 x D							.028-.030		.030-.032	.032-.034						
68-100	1 x D						.008-.010	.012-.014		.016-.018	.019-.021						

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

Laminated Plywood Cutting Data Recommendations

APPLICATION	GOOD	BETTER	BEST
Single Pass	60-100MW	60-100MC	60-100PLR

DEPTH OF CUT: Greater than 3 x D, reduce chip load by 25%

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 CED					.003-.006		.003-.006		.003-.006													
37-60	1/2 CED									.004-.006		.004-.006			.006-.008		.008-.010						
37-80	Varies																.004-.006			.004-.006		.004-.006	
48-000	1 x D					.004-.006	.005-.007	.005-.007	.006-.008	.006-.008		.007-.009		.009-.011	.010-.012	.011-.013	.012-.014						
57-200	1 x D		.003-.005	.003-.005	.004-.006	.004-.006	.005-.007	.005-.007	.006-.008	.006-.008		.007-.009	.007-.008										
57-200MD	1 x D						.009-.011	.010-.012	.011-.013														
60-100MW	1 x D		.013-.015			.014-.016		.015-.017		.016-.018		.018-.020		.019-.021	.021-.023								
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													
60-600	1 x D									.027-.029		.030-.032	.032-.034										
68-100	1 x D								.008-.010	.012-.014		.016-.018	.019-.021										

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