Soft Plywood Cutting Data Recommendations

CW

Application	Good	Better	Best
Single Pass	52-200/57-200	60-100MW	60-100C
Roughing		60-800	60-000
Finishing			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%

Recommended Chip Load per Tooth by Cutting Diameter (in)

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	1-1/2	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 x D										.003-.005									
48-000	1 x D				.005-.007		.005-.007	.006-.008	.006-.008		.007-.009		.008-.010	.009-.011	.010-.012	.011-.013				
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						
52-900	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						
57-200MD	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		.013-.015		.014-.016		.017-.019		.019-.021		.021-.023		.023-.025	.025-.027						
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									
60-300	1 x D								.022-.024		.024-.026		.026-.028	.028-.030						
60-350	1 x D								.020-.022		.022-.024		.024-.026	.026-.028						
60-600	1 x D										.028-.030		.030-.032	.032-.034						
60-700	1 x D										.028-.030		.030-.032	.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								.022-.024		.024-.026									
61-200	1 x D		.006-.008		.007-.009		.008-.010	.008-.010	.009-.011		.010-.012									
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									.010-.012		.012-.014			.017-.019	.018-.020					

* = 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