Soft Wood Cutting Data Recommendations

SW

Application	Good	Better	Best
Single Pass	52-200/57-200	60-300/60-350	60-100C
Roughing	52-200/57-200	60-800/60-900	60-000
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%

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	113/4	2
10-00	1 x D	.004-.006	.004-.006	.005-.007				.007-.009		.008-.010												
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										
40-000	1 x D		.002-.004	.002-.004	.003-.005			.004-.006	.004-.006	.005-.007												
40-100	1 x D		.005-.007			.005-.007	.005-.007	.006-.008	.006-.008	.007-.009		.008-.010			.010-.012							
52-200/57-200	1 x D		.006-.008	.006-.008	.006-.008	.006-.008		.007-.009	.007-.009	.008-.010	.008-.010	.009-.011	.009-.011	.010-.012	.011-.013							
52-400/57-400	1 x D			.006-.008	.006-.008			.007-.009	.007-.009	.008-.010		.009-.011										
52-900	1 x D							.007-.009		.008-.010		.009-.011										
57-200MD	1 x D							.009-.011		.010-.012		.011-.013										
56-200	1 x D		.004-.006	.004-.006	.005-.007	.005-.007		.006-.008	.006-.008	.007-.009		.008-.010			.010-.012							
57-900	1 x D							.007-.009		.008-.010		.009-.011										
60-000 (LH)	1 x D									.013-.015		.015-.017		.017-.019	.019-.021							
60-000 (HH)	1 x D									.016-.018		.018-.020		.020-.022	.022-.024							
60-090	1 x D													.005-.007								
60-100MW	1 x D			.011-.013		.013-.015		.018-.020		.020-.022		.022-.024		.024-.026	.026-.028							
60-100C	1 x D									.024-.026		.026-.028		.028-.030	.030-.032							
60-100MC	1 x D									.019-.021		.021-.023										
60-100PLR	1 x D									.021-.023		.023-.025										
60-200	1 x D							.005-.007		.006-.008		.007-.009			.008-.010							
60-300	1 x D									.024-.026		.026-.028		.028-.030	.030-.032							
60-350	1 x D									.017-.019		.019-.021			.021-.023							
60-600	1 x D											.019-.021			.023-.025							
60-700	1 x D											.019-.021		.021-.023	.023-.025							
60-800	1 x D									.017-.019		.019-.021		.021-.023	.023-.025							
60-900	1 x D									.017-.019		.018-.020										
60-950	1 x D									.024-.026		.026-.028										
61-000	1 x D			.008-.010	.008-.010	.009-.011	.009-.011	.010-.012	.010-.012	.011-.013	.011-.013	.012-.014										
61-200	1 x D			.008-.010				.010-.012	.010-.012	.011-.013		.012-.014										
63-200	1 x D			.003-.005				.005-.007														
64-000/65-000	1 x D	.001-.003		.002-.004		.003-.006		.004-.006		.005-.007												
68-100	1 x D									.014-.015		.015-.016										
77-100	1 x D			.003-.005				.005-.007														

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