

Soft Wood Cutting Data Recommendations



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%

Cutting Edge Diameter (in)																						
		Chip Load Per Tooth (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
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 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**	
40-50	1 1/2											.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	.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	.006-.008	.007-.009	.007-.009	.008-.010	.008-.010	.009-.011	.009-.011	.010-.012	.011-.013							
52-700	1 x D		.006-.008			.008-.010		.009-.011		.010-.012		.011-.013		.012-.013	.013-.015		.016-.018					
57-200MD	1 x D							.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										
56-200	1 x D		.004-.006	.004-.006	.005-.007	.005-.007	.006-.008	.006-.008	.007-.009	.008-.010		.009-.011			.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							
60-100DC	1 x D									.020-.022		.022-.024										
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							
60-500/ 500M	1 x D											.015-.017		.017-.019	.019-.021							
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														

* = 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