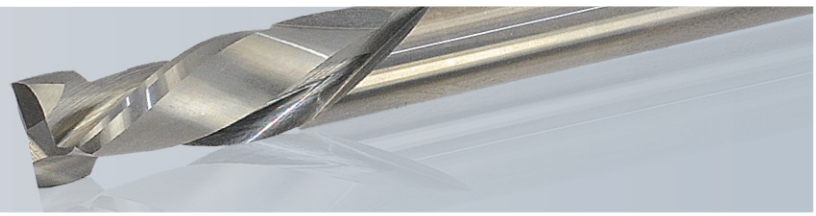
LMT • ONSRUD

MDF Cutting Data Recommendations



APPLICATION	GOOD	BETTER	BEST
Single Pass	52-200 / 57-200	60-100MW	60-100MC
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%

		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
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										
47-00	1 x D															.004-.006			.004-.006	.004-.006		
48-000	1 x D					.004-.006		.005-.007	.005-.007	.005-.007		.006-.008		.006-.008	.007-.009	.008-.010	.009-.011					
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							
57-200MD	1 x D							.009-.011		.010-.012		.011-.013										
52-400/ 57-400	1 x D				.003-.005	.004-.006		.005-.007	.005-.007	.006-.008		.008-.010	.009-.011	.010-.012	.011-.013	.012-.014						
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							
57-900	1 x D							.006-.008		.007-.009		.008-.010										
60-000 (LH)	1 x D									.012-.014		.013-.015		.014-.016	.016-.018							
60-000 (HH)	1 x D									.017-.019		.018-.020		.020-.022	.023-.025							
60-090	1 x D													.004-.006								
60-100MW	1 x D			.010-.012		.010-.012		.013-.015		.014-.016		.016-.018		.018-.020	.019-.021							
60-100C	1 x D									.017-.019		.018-.020		.020-.022	.023-.025							
60-100DC	1 x D									.017-.019		.018-.020										
60-100MC	1 x D									.019-.021		.021-.023										
60-100PLR	1 x D									.021-.023		.023-.025										
60-200	1 x D							.004-.006		.005-.007		.005-.007			.006-.008							
60-300	1 x D									.017-.019		.018-.020		.020-.022	.023-.025							
60-350	1 x D									.014-.016		.016-.018		.017-.019	.019-.021							
60-500/ 500M	1 x D											.014-.016		.016-.018	.018-.020							
60-600	1 x D											.020-.022		.022-.024	.024-.026							
60-700	1 x D											.020-.022		.022-.024	.024-.026							
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									.017-.019		.018-.020										
61-200	1 x D			.007-.009		.008-.010		.009-.011	.009-.011	.010-.012		.011-.013										
62-200	1 x D			.010-.012		.011-.013		.012-.014	.012-.014	.013-.015		.014-.016										
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									.008-.010		.012-.014		.015-.017	.018-.020							
77-100	1 x D			.003-.005				.005-.007														

91-000/91-100 - See Page 73 of catalog for Technical Information

* = 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