

Chipload Calculator

Target Area

Below are the suggested chip load ranges based on material being machined and tool diameter. This calculator should be used as a starting reference range only for shank tools and is based on **cutting depth being equal to cutting diameter** of the tool. For deeper cuts, it is necessary to reduce the chipload as follows:

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Tool Diameter	Hardwood	Softwood/Plywood	MDF/Particle Board	▼ Soft Plastic	Hard Plastic
1/2" & up	.019"-.021"	.021"-.023"	.025"-.027"	.012"-.016	.010"-.012"
3/8"	.015"-.018"	.018"-.020"	.020"-.023"	.010"-.012"	.008"-.010"
1/4"	.009"-.011"	.011"-.013"	.013"-.016	.007"-.010	.006"-.009"

1/8"

.003"-.005"

.004"-.006"

.004"-.007

.003"-.006

.002"-.004"

Calculate Chip Load

FEED RATE	UNITS	RPM	NUMBER OF FLUTES
600	<div>Inches/Minute</div>	18000	2

Your Chipload 0.017

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