



Solid Surface Cutting Data

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%

CHIP LOAD PER TOOTH

		Cutting Edge Diameter															
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
37-50	1 x D					.003 - .006		.003 - .006		.003 - .006							
37-60	1 x D									.004 - .006		.004 - .006			.006 - .008		.008 - .010
38-50/ 38-60	1 x D			.002 - .004		.002 - .004		.003 - .005		.004 - .006		.005 - .007		.006 - .008	.007 - .009		
52-000	1 x D			.003 - .006		.003 - .006		.004 - .006		.008 - .010		.012 - .014					
52-200B/BL	1 x D	.002 - .004		.002 - .004		.002 - .004		.004 - .006		.004 - .006		.006 - .008		.008 - .010	.010 - .012		
52-400	1 x D			.002 - .004		.002 - .004		.003 - .005		.004 - .006		.005 - .007		.006 - .008	.007 - .009		
52-600	1 x D							.004 - .006		.006 - .008		.008 - .010		.008 - .010	.010 - .012		
56-000P	1 x D			.002 - .004		.002 - .004		.004 - .006		.006 - .008		.008 - .010					
56-450	1 x D			.002 - .004		.002 - .004		.003 - .005		.004 - .006		.005 - .007					
57-000	1 x D			.002 - .004		.002 - .004		.003 - .005		.004 - .006		.005 - .007					
57-200	1 x D			.002 - .004		.002 - .004		.003 - .005		.004 - .006		.005 - .007		.006 - .008	.007 - .009		
57-400	1 x D			.002 - .004		.002 - .004		.003 - .005		.004 - .006		.005 - .007		.006 - .008	.007 - .009		
57-600	1 x D							.004 - .006		.006 - .008		.008 - .010		.008 - .010	.010 - .012		
60-200	1 x D							.002 - .004		.002 - .006		.002 - .006		.004 - .008			
60-470	1 x D							.002 - .004		.002 - .006		.002 - .006		.004 - .008			
62-700	1 x D			.002 - .004		.004 - .006		.006 - .010		.006 - .010		.010 - .012					
62-750	1 x D			.002 - .004		.004 - .006		.006 - .010		.006 - .010		.010 - .012					
62-800	1 x D			.002 - .004		.004 - .006		.006 - .010		.006 - .010		.010 - .012					
62-850	1 x D			.002 - .004		.004 - .006		.006 - .010		.006 - .010		.010 - .012					
63-700	1 x D	.002 - .003		.002 - .004		.004 - .006		.006 - .010		.006 - .010		.010 - .012					
63-750	1 x D	.002 - .003		.002 - .004		.004 - .006		.006 - .010		.006 - .010		.010 - .012					
63-800	1 x D	.002 - .003		.002 - .004		.004 - .006		.006 - .010		.006 - .010		.010 - .012					
63-850	1 x D	.002 - .003		.002 - .004		.004 - .006		.006 - .010		.006 - .010		.010 - .012					
64-000/ 65-000	1 x D	.002 - .004		.006 - .008		.008 - .010	.010 - .012	.010 - .012									
66-000	1 x D							.002 - .004		.003 - .005		.004 - .006					

FORMULAS: Chip Load = Feed Rate / (RPM x # of cutting edges)
 Feed Rate = RPM x # of cutting edges x chip load
 Speed (RPM) = Feed Rate / (# of cutting edges x chip load)

Chipload Instructions and Example

Instructions

1. Find the cutting data for the material being cut
2. Find the series number of the selected tool under the series column
3. Move across until you find the cutting edge diameter of the tool
4. Note the chipload range.

Example

65-023 selected to cut Solid Surface

65-000 series
1/4" diameter tool
.010" - .012" chipload range

Feedrate = RPM x # of cutting edges x chipload.

$18,000 \times 1 \times .010 = 180 \text{ IPM}$

$18,000 \times 1 \times .012 = 216 \text{ IPM}$