Specialty Tool Chiploads

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

Material: Foam

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**	**1 1/8**	**1 1/4**	**1 1/2**	**1 3/4**	**2**
12-00	1 x D			.0005 - .002		.0005 - .002		.001 - .003	.001 - .003	.002 - .004		.003 - .005		.004 - .006	.005 - .007		.006 - .008		.007 - .009			
13-50	1"											.015 - .017			.017 - .019							
40-550	1 x D											.004 - .006										
48-000	1 x D			.002 - .004		.002 - .004		.003 - .005	.003 - .005	.004 - .006		.005 - .007		.006 - .008	.007 - .009		.008 - .010		.009 - .011			.010 - .012
52-550	1 x D			.002 - .004		.002 - .004		.004 - .006	.004 - .006	.004 - .006												

Material: Wood

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**	**1 1/8**	**1 1/4**	**1 1/2**	**1 3/4**	**2**
37-50	1/2 CED					.003 - .006		.003 - .006		.003 - .006												
37-60	1/2 CED									.004 - .006		.004 - .006			.006 - .008		.008 - .010					
37-00/ 37-20	Varies							.004-.006														

Material: Plastic

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**	**1 1/8**	**1 1/4**	**1 1/2**	**1 3/4**	**2**
37-50*	1 x D					.003 - .006		.003 - .006		.003 - .006												
37-60*	1 x D									.004 - .006		.004 - .006			.006 - .008		.008 - .010					
66-000	1 x D							.004 - .008		.004 - .008		.004 - .008										
66-200	1 x D							.004 - .006		.006 - .008												
66-250	1 x D							.004 - .006		.006 - .008												
66-300	1 x D			.002 - .004				.004 - .006		.006 - .008		.006 - .008										
66-350	1 x D			.002 - .004				.004 - .006		.006 - .008		.006 - .008										
75-000	1 x D									.001 - .002		.0005 - .002			.001 - .002		.001 - .002					
37-00/ 37-20	Varies							.004-.006														

Material: Aluminum

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**	**1 1/8**	**1 1/4**	**1 1/2**	**1 3/4**	**2**
66-200	1 x D							.004 - .006		.006 - .008												
66-250	1 x D							.004 - .006		.006 - .008												
66-300	1 x D			.002 - .004				.004 - .006		.006 - .008		.006 - .008										
66-350	1 x D			.002 - .004				.004 - .006		.006 - .008		.006 - .008										
37-00/ 37-20	Varies							.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	**Example**
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.	52-554 selected to cut Foam 52-550 series 1/8” diameter tool .002” - .004” chipload range Feedrate = RPM x # of cutting edges x chipload. 18,000 x 2 x .004 = 72 IPM 18,000 x 2 x .006 = 144 IPM