LW | Laminated Plywood Cutting Data

APPLICATION	GOOD	BETTER	BEST
Single Pass	48-000	60-100	60-100C
Roughing			60-850

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
13-50	1 x D											.014-.016			.018-.020		
48-000	1 x D					.004-.006	.005-.007	.005-.007	.006-.008	.006-.008		.007-.009	.008-.010	.009-.011	.010-.012	.011-.013	.012-.014
60-100	1 x D			.013-.015		.014-.016		.015-.017		.016-.018		.018-.020		.019-.021	.021-.023		
60-100DE	1 x D							.015-.017		.016-.018		.018-.020		.019-.021	.021-.023		
60-1003E	1 x D									.018-.020		.020-.022			.022-.024		
60-100C	1 x D									.019-.021		.021-.023		.023-.025	.025-.027		
60-500/ 500M	1 x D											.019-.021		.021-.023	.023-.025		
60-600	1 x D											.027-.029		.030-.032	.032-.034		
60-850	1 x D									.017-.019		.019-.02					

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.	60-163C selected to cut Laminated Plywood 60-100C series 1/2” diameter tool .021” - .023” chipload range Feedrate = RPM x # of cutting edges x chipload. 18,000 x 2 x .021 = 756 IPM 18,000 x 2 x .023 = 828 IPM (RPM = tools are recommended to cut at 18,000 RPM but the customer can vary it based on their machine)