

SW

# Soft Wood Cutting Data Recommendations

APPLICATION	GOOD	BETTER	BEST
Single Pass	52-200/57-200	60-300/60-350	60-100C
Roughing	52-200/57-200	60-800/60-900	60-000
Finishing		60-300/60-350	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%

Recommended Chip Load per Tooth by Cutting Diameter (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	
10-00	1 x D	.004-.006	.004-.006	.005-.007				.007-.009		.008-.010													
37-00/37-20	Varies							.004-.006															
37-50	1/2 x D					.003-.006		.003-.006		.003-.006													
37-60	1/2 x D									.004-.006		.004-.006			.006-.008		.008-.010						
37-80	Varies																.004-.006		.004-.006*				.004-.006**
40-50	1 1/2 X D											.003-.005											
40-000	1 x D		.002-.004	.002-.004	.003-.005		.004-.006	.004-.006	.005-.007														
40-100	1 x D		.005-.007		.005-.007	.005-.007	.006-.008	.006-.008	.007-.009			.008-.010			.010-.012								
52-200/57-200	1 x D		.006-.008	.006-.008	.006-.008	.006-.008	.007-.009	.007-.009	.008-.010	.008-.010	.009-.011	.009-.011	.010-.012	.011-.013									
52-400/57-400	1 x D			.006-.008	.006-.008		.007-.009	.007-.009	.008-.010		.009-.011												
52-900	1 x D						.007-.009	.008-.010	.008-.010		.009-.011												
57-200MD	1 x D						.009-.011	.010-.012	.010-.012		.011-.013												
56-200	1 x D		.004-.006	.004-.006	.005-.007	.005-.007	.006-.008	.006-.008	.007-.009	.008-.010		.008-.010			.010-.012								
57-900	1 x D						.007-.009	.008-.010	.008-.010		.009-.011												
60-000 (LH)	1 x D							.013-.015	.013-.015		.015-.017		.017-.019	.019-.021									
60-000 (RH)	1 x D							.016-.018	.016-.018		.018-.020		.020-.022	.022-.024									
60-090	1 x D												.005-.007										
60-100MW	1 x D		.011-.013		.013-.015		.018-.020		.020-.022	.022-.024		.024-.026	.026-.028		.028-.030	.030-.032							
60-100C	1 x D								.024-.026	.024-.026		.026-.028	.028-.030	.030-.032									
60-100MC	1 x D								.019-.021	.019-.021		.021-.023	.023-.025										
60-100PLR	1 x D								.021-.023	.021-.023		.023-.025	.025-.027										
60-200	1 x D						.005-.007		.006-.008	.006-.008		.007-.009			.008-.010								
60-300	1 x D								.024-.026	.024-.026		.026-.028	.028-.030	.030-.032									
60-350	1 x D								.017-.019	.017-.019		.019-.021	.021-.023	.023-.025									
60-600	1 x D											.019-.021	.021-.023	.023-.025									
60-700	1 x D											.019-.021	.021-.023	.023-.025									
60-800	1 x D							.017-.019	.017-.019		.019-.021	.021-.023	.023-.025										
60-900	1 x D							.017-.019	.017-.019		.018-.020												
60-950	1 x D							.024-.026	.024-.026		.026-.028												
61-000	1 x D		.008-.010	.008-.010	.009-.011	.009-.011	.010-.012	.010-.012	.011-.013	.011-.013	.012-.014												
61-200	1 x D		.008-.010				.010-.012	.010-.012	.011-.013	.011-.013	.012-.014												
63-200	1 x D		.003-.005				.005-.007																
64-000/65-000	1 x D	.001-.003	.002-.004		.003-.006		.004-.006		.005-.007														
68-100	1 x D							.014-.015		.015-.016													
77-100	1 x D		.003-.005				.005-.007																

\* = 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

# HP Hard Wood Cutting Data Recommendations

APPLICATION	GOOD	BETTER	BEST
Single Pass	52-200/57-200	60-300/60-350	60-100C
Roughing	52-200/57-200	60-800/60-900	60-000
Finishing		60-300/60-350	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%

Recommended Chip Load per Tooth by Cutting Diameter (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											
40-000	1 x D		.006-.008	.006-.008	.007-.009			.008-.010	.008-.010	.009-.007													
40-100	1 x D		.004-.006		.005-.007	.005-.007	.005-.007	.006-.008	.006-.008	.006-.008		.007-.009			.009-.011								
48-000	1 x D			.004-.006		.005-.007	.005-.007	.005-.007	.005-.007	.005-.007		.006-.008		.007-.009	.008-.010	.009-.011	.010-.012						
52-200/57-200	1 x D		.003-.005	.003-.005	.004-.006	.004-.006	.005-.007	.005-.007	.006-.008	.006-.008	.007-.009	.007-.009	.008-.010	.009-.011									
52-700	1 x D		.002-.004		.003-.005			.004-.006		.005-.007		.006-.008		.007-.009	.008-.010		.009-.011						
57-200MD	1 x D							.009-.011		.010-.012		.011-.013											
52-400/57-400	1 x D			.004-.006	.004-.006			.005-.007	.005-.007	.006-.008		.007-.009											
52-900	1 x D							.006-.008		.007-.009		.007-.009											
56-200	1 x D		.003-.005	.003-.005	.004-.006	.004-.006	.005-.007	.005-.007	.006-.008	.006-.008		.007-.009			.009-.011								
57-900	1 x D							.005-.007		.006-.008		.007-.009											
60-000 (LH)	1 x D									.013-.015		.014-.016		.016-.018	.017-.019								
60-000 (HH)	1 x D									.015-.017		.017-.019		.019-.021	.021-.023								
60-090	1 x D													.005-.007									
60-100MW	1 x D		.010-.012		.012-.014			.014-.016		.016-.018		.018-.020		.020-.022	.022-.024								
60-100C	1 x D									.019-.021		.021-.023		.023-.025	.025-.027								
60-100MC	1 x D									.019-.021		.021-.023											
60-100PLR	1 x D									.021-.023		.023-.025											
60-200	1 x D							.005-.007		.006-.008		.007-.009			.008-.010								
60-300	1 x D									.024-.026		.026-.028		.028-.030	.030-.032								
60-350	1 x D									.018-.020		.020-.022		.022-.025	.024-.026								
60-600	1 x D											.018-.020			.022-.024								
60-700	1 x D											.018-.020		.020-.022	.022-.024								
60-800	1 x D									.017-.019		.019-.021		.021-.023	.023-.025								
60-900	1 x D									.015-.017		.017-.019			.019-.021								
60-950	1 x D									.019-.021		.021-.023											
61-200	1 x D			.007-.009				.009-.011	.009-.011	.010-.012													
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									.010-.012		.011-.013		.012-.014	.013-.015								
77-100	1 x D			.003-.005				.005-.007															

\* = 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

# MDF Cutting Data Recommendations

CW

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

Recommended Chip Load per Tooth by Cutting Diameter (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															
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	.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								
60-100MC	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								
60-600	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											
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															

\* = 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

CW

# Soft Plywood Cutting Data Recommendations

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

Recommended Chip Load per Tooth by Cutting Diameter (in)																				
Series	Cut	1/16	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	2
37-00/37-20	Varies						.004-.006													
37-50	1/2 x D				.003-.006		.003-.006		.003-.006											
37-60	1/2 x D								.004-.006		.004-.006			.006-.008		.008-.010				
37-80	Varies															.004-.006		.004-.006*		.004-.006**
40-50	1 1/2 x D										.003-.005									
48-000	1 x D				.005-.007		.005-.007	.006-.008	.006-.008		.007-.009		.008-.010	.009-.011	.010-.012	.011-.013				
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						
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						
57-200MD	1 x D						.009-.011				.010-.012			.011-.013						
60-000 (LH)	1 x D								.014-.016		.016-.018		.018-.020	.020-.022						
60-000 (HH)	1 x D								.017-.019		.019-.021		.021-.023	.023-.025						
60-090	1 x D												.003-.005							
60-100MW	1 x D		.013-.015		.014-.016		.017-.019		.019-.021		.021-.023		.023-.025	.025-.027						
60-100C	1 x D								.022-.024		.024-.026		.026-.028	.028-.030						
60-100MC	1 x D								.019-.021		.021-.023									
60-100PLR	1 x D								.021-.023		.023-.025									
60-300	1 x D								.022-.024		.024-.026		.026-.028	.028-.030						
60-350	1 x D								.020-.022		.022-.024		.024-.026	.026-.028						
60-600	1 x D										.028-.030		.030-.032	.032-.034						
60-700	1 x D										.028-.030		.030-.032	.032-.034						
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								.022-.024		.024-.026									
61-200	1 x D		.006-.008		.007-.009		.008-.010	.008-.010	.009-.011		.010-.012									
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									.010-.012		.012-.014		.017-.019	.018-.020						

\* = 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

# Hard Plywood Cutting Data Recommendations

CW

APPLICATION	GOOD	BETTER	BEST
Single Pass	60-100MW	60-100C	60-100MC
Roughing		60-800	60-000

**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%

Recommended Chip Load per Tooth by Cutting Diameter (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 x D					.003-.006		.003-.006		.003-.006													
37-60	1/2 x D									.004-.006		.004-.006			.006-.008		.008-.010						
37-80	Varies																.004-.006		.004-.006*				.004-.006**
40-50	1 1/2											.003-.005											
48-000	1 x D					.004-.006		.005-.007	.005-.007	.006-.008		.007-.009		.008-.010	.009-.011	.010-.012	.011-.013						
52-200	1 x D		.005-.007	.005-.007	.006-.008	.006-.008	.006-.008	.006-.008	.007-.009	.007-.009	.007-.009	.008-.010	.008-.010	.009-.011	.009-.011								
52-900	1 x D							.006-.008	.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								
57-200	1 x D		.005-.007	.005-.007	.006-.008	.006-.008	.006-.008	.006-.008	.007-.009	.007-.009	.007-.009	.008-.010	.008-.010	.009-.011	.009-.011								
57-200MD	1 x D							.009-.011		.010-.012		.011-.013											
60-000 (LH)	1 x D								.014-.016		.016-.018		.018-.020	.018-.020	.020-.022								
60-000 (HH)	1 x D								.017-.019		.019-.021		.021-.023	.021-.023	.023-.025								
60-090	1 x D													.003-.005									
60-100MW	1 x D		.012-.014		.012-.014		.014-.016		.016-.018		.018-.020		.020-.022	.020-.022	.022-.024								
60-100C	1 x D								.019-.021		.021-.023		.023-.025	.023-.025	.025-.027								
60-100MC	1 x D								.019-.021		.021-.023												
60-100PLR	1 x D								.021-.023		.023-.025												
60-300	1 x D								.019-.021		.021-.023		.023-.025	.023-.025	.025-.027								
60-350	1 x D								.018-.020		.020-.022		.022-.025	.022-.025	.024-.026								
60-600	1 x D										.027-.029		.030-.032	.030-.032	.032-.034								
60-700	1 x D										.027-.029		.029-.031	.029-.031	.032-.034								
60-800	1 x D								.017-.019		.019-.021		.021-.023	.021-.023	.023-.025								
60-900	1 x D								.017-.019		.019-.021												
60-950	1 x D								.019-.021		.021-.023												
61-200	1 x D		.005-.007					.007-.009	.007-.009	.008-.010		.009-.011											
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								.010-.012		.012-.014		.017-.019	.017-.019	.018-.020								
77-100			.003-.005					.005-.007															

\* = 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

# Laminated Chipboard Cutting Data Recommendations

LW

APPLICATION	GOOD	BETTER	BEST
Single Pass	60-100MW	60-100MC	60-100PLR

**DEPTH OF CUT:** Greater than 3 x D, reduce chip load by 25%

Recommended Chip Load per Tooth by Cutting Diameter (in)																	
Series	Cut	1/8	3/16	7/32	1/4	5/16	3/8	1/2	9/16	5/8	3/4	7/8	1	1-1/8	1-1/4	1-1/2	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					
37-80	Varies												.004-.006			.004-.006	.004-.006
48-000	1 x D				.006-.008	.006-.008	.007-.009	.008-.010		.009-.011	.010-.012	.011-.013	.012-.014				
57-200		.003-.005	.003-.005	.004-.006	.004-.006	.005-.007	.005-.007	.006-.008		.007-.009	.007-.008						
57-200MD					.009-.011		.010-.012	.011-.013									
60-100MW	1 x D	.013-.015	.014-.016		.017-.019		.019-.021	.021-.023		.025-.027	.027-.029						
60-100C	1 x D						.022-.024	.024-.026		.026-.028	.028-.030						
60-100MC	1 x D						.019-.021	.021-.023									
60-100PLR	1 x D						.021-.023	.023-.025									
60-600	1 x D							.028-.030		.030-.032	.032-.034						
68-100	1 x D						.008-.010	.012-.014		.016-.018	.019-.021						

**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

# Laminated Plywood Cutting Data Recommendations

APPLICATION	GOOD	BETTER	BEST
Single Pass	60-100MW	60-100MC	60-100PLR

**DEPTH OF CUT:** Greater than 3 x D, reduce chip load by 25%

Recommended Chip Load per Tooth by Cutting Diameter (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
48-000	1 x D					.004-.006	.005-.007	.005-.007	.006-.008	.006-.008		.007-.009		.009-.011	.010-.012	.011-.013	.012-.014					
57-200	1 x D		.003-.005	.003-.005	.004-.006	.004-.006	.005-.007	.005-.007	.006-.008		.007-.009	.007-.008										
57-200MD	1 x D						.009-.011		.010-.012	.011-.013												
60-100MW	1 x D		.013-.015			.014-.016		.015-.017		.016-.018		.018-.020		.019-.021	.021-.023							
60-100C	1 x D								.019-.021	.021-.023		.021-.023		.023-.025	.025-.027							
60-100MC	1 x D								.019-.021	.021-.023												
60-100PLR	1 x D								.021-.023	.023-.025												
60-600	1 x D											.027-.029		.030-.032	.032-.034							
68-100	1 x D								.008-.010	.012-.014		.012-.014		.016-.018	.019-.021							

**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