



Hard Plastic Cutting Data

< 1/2" DIAMETER TOOL

APPLICATION	GOOD	BETTER	BEST
Single Pass	65-000	63-700	56-000P
Roughing			60-000
Finishing		60-200	75-000

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%

> 1/2" DIAMETER TOOL

APPLICATION	GOOD	BETTER	BEST
Single Pass	52-700	52-600	56-000P
Roughing			60-000
Finishing			60-200

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	1 1/8	1 1/4	1 1/2	1 3/4	2	
52-200B/BL	1 x D	.002 - .004		.002 - .004		.004 - .006		.004 - .006		.004 - .006		.006 - .008		.008 - .010	.010 - .012								
52-600	1 x D							.006 - .008		.008 - .010		.010 - .012		.012 - .014	.014 - .016								
56-000P	1 x D			.002 - .004		.004 - .006		.004 - .006		.006 - .008		.008 - .010											
56-430	1 x D			.005 - .007		.005 - .007		.006 - .008		.007 - .009		.008 - .010											
56-450	1 x D					.005 - .007		.006 - .008		.007 - .009		.008 - .010											
56-600	1 x D			.003 - .005		.005 - .007		.007 - .009		.009 - .011		.011 - .013											
57-600	1 x D							.006 - .008		.008 - .010		.010 - .012		.012 - .014	.014 - .016								
60-000	1 x D									.004 - .006		.006 - .008		.008 - .010	.010 - .012								
60-200	1 x D							.004 - .006		.004 - .006		.006 - .010			.012 - .016								
60-900	1 x D									.004 - .006		.006 - .008											
61-000P	1 x D			.003 - .005		.005 - .007		.007 - .011		.013 - .017		.017 - .021											
61-400	1 x D			.014 - .016		.014 - .016		.015 - .017		.016 - .018		.017 - .019											
62-700	1 x D			.006 - .008		.008 - .010		.010 - .012		.010 - .012		.012 - .016											
62-750	1 x D			.004 - .006		.006 - .008		.008 - .012		.008 - .012		.010 - .014											
62-800	1 x D			.006 - .008		.008 - .010		.010 - .012		.010 - .012		.012 - .016											
62-850	1 x D			.004 - .006		.006 - .008		.008 - .012		.008 - .012		.010 - .014											
63-500	1 x D	.002 - .004		.003 - .005		.003 - .005		.004 - .006		.005 - .007													
63-700	1 x D	.002 - .004		.006 - .008		.008 - .010		.010 - .012		.010 - .012		.012 - .016											
63-750	1 x D	.002 - .004		.004 - .006		.006 - .008		.008 - .012		.008 - .012		.010 - .014											
63-800	1 x D	.002 - .004		.006 - .008		.008 - .010		.010 - .012		.010 - .012		.012 - .016											
63-850	1 x D	.002 - .004		.004 - .006		.006 - .008		.008 - .012		.008 - .012		.010 - .014											
64-000/ 65-000	1 x D	.002 - .004		.006 - .008		.008 - .010		.010 - .012		.010 - .012													
77-000	1 x D	.002 - .004		.002 - .004		.006 - .008		.008 - .012															
77-100 (DE)	1 x D			.005 - .007																			
77-100 (SE)	1 x D							.008 - .010															

NOTE: When chip rewelding occurs while cutting soft plastic, increase feedrate or go to a single edge tool. Incorrect chiploads can result in cratering

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
 IPR = Inches Per Revolution