



Soft Plastic Cutting Data

< 1/2" DIAMETER TOOL

APPLICATION	GOOD	BETTER	BEST
Single Pass	61-000P	65-000	63-750
Roughing			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%

> 1/2" DIAMETER TOOL

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

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	
10-00	1 x D	.002 - .004		.004 - .006		.006 - .008		.006 - .008		.007 - .009		.008 - .010											
38-50/ 38-60	1 x D			.001 - .003		.002 - .004		.003 - .005		.004 - .006		.005 - .007		.006 - .008	.007 - .009								
52-200B/BL	1 x D	.002 - .004		.002 - .004		.004 - .006		.004 - .006		.004 - .006		.006 - .008		.010 - .012	.012 - .014								
52-400	1 x D			.002 - .004		.003 - .005		.004 - .006		.005 - .007		.006 - .008		.007 - .009									
52-600	1 x D									.008 - .010		.010 - .012		.012 - .014	.014 - .016	.016 - .018							
52-700	1 x D											.012 - .014		.014 - .016	.016 - .018								
56-430	1 x D			.006 - .008		.006 - .008		.007 - .009		.008 - .010		.009 - .011											
56-600	1 x D			.004 - .006		.006 - .008		.008 - .010		.010 - .012		.012 - .014											
57-600	1 x D							.008 - .010		.010 - .012		.012 - .014		.014 - .016	.016 - .018								
60-000	1 x D									.004 - .006		.006 - .008		.008 - .010	.012 - .014								
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			.004 - .006		.006 - .008		.008 - .012		.014 - .018		.018 - .022											
61-400	1 x D			.017 - .019		.017 - .019		.018 - .020		.019 - .021		.020 - .021											
62-750	1 x D			.004 - .006		.006 - .008		.008 - .012		.008 - .012		.010 - .014											
62-850	1 x D			.004 - .006		.006 - .008		.008 - .012		.008 - .012		.010 - .014											
63-500	1 x D	.002 - .004		.004 - .006		.005 - .007		.006 - .008		.007 - .009													
63-750	1 x D	.002 - .004		.004 - .006		.006 - .008		.008 - .012		.008 - .012		.010 - .014											
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		.004 - .006		.006 - .008		.008 - .012		.008 - .012													
65-200B/ 65-300B	1 x D	.002-003		.002-003		.003-004		.003-005	.003-005	.004-006		.006-008											
77-100 (DE)	1 x D			.005 - .007																			
77-100 (SE)	1 x D							.008 - .010															

* = 12,500 RPM

NOTE: To eliminate rewelding increase the feedrate or change to a single edge tool
 If using a downcut spiral and chip rewelding occurs, cut a slot in your spoilboard to allow the chips a place to expand
 Incorrect chiploads can lead to knife marks occurring

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)