

# Foam Cutting Data Recommendations

**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	
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		0.010						
52-550	1 x D			.002-.004		.002-.004		.004-.006	.004-.006	.004-.006													
52-700	1 x D			.002-.004		.002-.004		.004-.006	.004-.006	.004-.006		.005-.007		.006-.008	.007-.009		0.010						
56-000P	1 x D			.002-.004		.002-.004		.004-.006		.004-.006		.005-.007											
77-100	1 x D			.002-.004				.004-.006															