Hard Plastic Cutting Data Recommendations

< 1/2" Diameter Tool

APPLICATION	GOOD	BETTER	BEST
Single Pass	56-000P	65-000	63-700
Roughing			60-000
Finishing		60-200	75-100

> 3/4" Diameter Tool

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

		Cutting Edge Diameter (in)																				
		Chip Load Per Tooth (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 x D					.003-.006		.003-.006		.003-.006												
37-60*	1 x D									.004-.006		.004-.006			.006-.008		.008-.010					
37-80	Varies																.001-.003		.001-.003			.001-.003
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-.012	.012-.016							
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												
66-000	1 x D							.004-.008		.004-.008		.004-.008										
66-200	1 x D							.004-.006		.006-.008												
66-300	1 x D			.002-.004				.004-.006		.006-.008		.006-.008										
66-350	1 x D			.002-.004				.004-.006		.006-.008		.006-.008										
77-000	1 x D	.002-.004		.002-.004		.006-.008		.008-.012														
77-100 (DE)	1 x D			.005-.007																		
77-100 (3E)	1 x D							.008-.010														
91-100 - See Page 73 of catalog for Technical Information																						

NOTE: When chip rewelding occurs while cutting hard plastic, increase feed rate 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