

LW

Laminated Chipboard 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	1/8	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