Laminated Plywood 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	1/16	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	1/2 CED					.003-.006		.003-.006		.003-.006												
37-60	1/2 CED									.004-.006		.004-.006			.006-.008		.008-.010					
37-80	Varies																.004-.006			.004-.006		.004-.006
48-000	1 x D					.004-.006	.005-.007	.005-.007	.006-.008	.006-.008		.007-.009		.009-.011	.010-.012	.011-.013	.012-.014					
57-200	1 x D			.003-.005	.003-.005	.004-.006	.004-.006	.005-.007	.005-.007	.006-.008		.007-.009	.007-.008									
57-200MD	1 x D						.009-.011		.010-.012	.011-.013												
60-100MW	1 x D			.013-.015		.014-.016		.015-.017		.016-.018		.018-.020		.019-.021	.021-.023							
60-100C	1 x D									.019-.021		.021-.023		.023-.025	.025-.027							
60-100MC	1 x D									.019-.021		.021-.023										
60-100PLR	1 x D									.021-.023		.023-.025										
60-600	1 x D											.027-.029		.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