

CW

# Soft Plywood Cutting Data Recommendations

| APPLICATION | GOOD          | BETTER   | BEST    |
|-------------|---------------|----------|---------|
| Single Pass | 52-200/57-200 | 60-100MW | 60-100C |
| Roughing    |               | 60-800   | 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%

| Recommended Chip Load per Tooth by Cutting Diameter (in) |           |           |           |           |           |           |           |           |           |           |           |           |           |           |           |           |       |            |       |             |
|--|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-------|------------|-------|-------------|
| Series   | Cut       | 1/16      | 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 | 2           |
| 37-00/37-20  | Varies    |           |           |           |           |           | .004-.006 |           |           |           |           |           |           |           |           |           |       |            |       |             |
| 37-50  | 1/2 x D   |           |           |           | .003-.006 |           | .003-.006 |           | .003-.006 |           |           |           |           |           |           |           |       |            |       |             |
| 37-60  | 1/2 x D   |           |           |           |           |           |           |           | .004-.006 |           | .004-.006 |           |           | .006-.008 |           | .008-.010 |       |            |       |             |
| 37-80  | Varies    |           |           |           |           |           |           |           |           |           |           |           |           |           |           | .004-.006 |       | .004-.006* |       | .004-.006** |
| 40-50  | 1 1/2 x D |           |           |           |           |           |           |           |           |           | .003-.005 |           |           |           |           |           |       |            |       |             |
| 48-000   | 1 x D     |           |           |           | .005-.007 |           | .005-.007 | .006-.008 | .006-.008 |           | .007-.009 |           | .008-.010 | .009-.011 | .010-.012 | .011-.013 |       |            |       |             |
| 52-200/57-200  | 1 x D     |           | .005-.007 | .005-.007 | .006-.008 | .006-.008 | .006-.008 | .006-.008 | .007-.009 | .007-.009 | .008-.010 | .008-.010 | .009-.011 | .009-.011 |           |           |       |            |       |             |
| 52-900   | 1 x D     |           |           |           |           |           | .006-.008 |           | .007-.009 |           | .008-.010 |           |           |           |           |           |       |            |       |             |
| 56-200   | 1 x D     |           | .003-.005 | .003-.005 | .004-.006 | .004-.006 | .005-.007 | .005-.007 | .006-.008 |           | .007-.009 |           |           | .009-.011 |           |           |       |            |       |             |
| 57-200MD   | 1 x D     |           |           |           |           |           | .009-.011 |           | .010-.012 |           | .011-.013 |           |           |           |           |           |       |            |       |             |
| 60-000 (LH)  | 1 x D     |           |           |           |           |           |           |           | .014-.016 |           | .016-.018 |           | .018-.020 | .020-.022 |           |           |       |            |       |             |
| 60-000 (HH)  | 1 x D     |           |           |           |           |           |           |           | .017-.019 |           | .019-.021 |           | .021-.023 | .023-.025 |           |           |       |            |       |             |
| 60-090   | 1 x D     |           |           |           |           |           |           |           |           |           |           |           | .003-.005 |           |           |           |       |            |       |             |
| 60-100MW   | 1 x D     |           | .013-.015 |           | .014-.016 |           | .017-.019 |           | .019-.021 |           | .021-.023 |           | .023-.025 | .025-.027 |           |           |       |            |       |             |
| 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 |           |           |           |           |           |       |            |       |             |
| 60-300   | 1 x D     |           |           |           |           |           |           |           | .022-.024 |           | .024-.026 |           | .026-.028 | .028-.030 |           |           |       |            |       |             |
| 60-350   | 1 x D     |           |           |           |           |           |           |           | .020-.022 |           | .022-.024 |           | .024-.026 | .026-.028 |           |           |       |            |       |             |
| 60-600   | 1 x D     |           |           |           |           |           |           |           |           |           | .028-.030 |           | .030-.032 | .032-.034 |           |           |       |            |       |             |
| 60-700   | 1 x D     |           |           |           |           |           |           |           |           |           | .028-.030 |           | .030-.032 | .032-.034 |           |           |       |            |       |             |
| 60-800   | 1 x D     |           |           |           |           |           |           |           | .017-.019 |           | .019-.021 |           | .021-.023 | .023-.025 |           |           |       |            |       |             |
| 60-900   | 1 x D     |           |           |           |           |           |           |           | .017-.019 |           | .019-.021 |           |           |           |           |           |       |            |       |             |
| 60-950   | 1 x D     |           |           |           |           |           |           |           | .022-.024 |           | .024-.026 |           |           |           |           |           |       |            |       |             |
| 61-200   | 1 x D     |           | .006-.008 |           | .007-.009 |           | .008-.010 | .008-.010 | .009-.011 |           | .010-.012 |           |           |           |           |           |       |            |       |             |
| 63-200   | 1 x D     |           | .003-.005 |           |           |           | .005-.007 |           |           |           |           |           |           |           |           |           |       |            |       |             |
| 64-000/65-000  | 1 x D     | .001-.003 | .002-.004 |           | .003-.005 |           | .004-.006 |           | .005-.007 |           |           |           |           |           |           |           |       |            |       |             |
| 68-100   |           |           |           |           |           |           |           |           | .010-.012 |           | .012-.014 |           | .017-.019 | .018-.020 |           |           |       |            |       |             |

\* = 16,000 RPM  
 \*\* = 15,000 RPM

**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