SSP

Solid Surface 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
37-50	1 x D					.003-.006		.003-.006		.003-.006							
37-60	1 x D									.004-.006		.004-.006			.006-.008		.008 -.010
52-000	1 x D			.003-.006		.003-.006		.004-.006		.008-.010		.012-.014					
52-200B/BL	1 x D	.002-.004		.002-.004		.002-.004		.004-.006		.004-.006		.006-.008		.008-.010	.010-.012		
52-600	1 x D							.004-.006		.006-.008		.008-.010		.008-.010	.010-.012		
52-700	1 x D			.002-.004		.003-.005		.004-.006		.005-.007		.006-.008		.007-.009	.008-.010		.009-.011
56-000P	1 x D			.002-.004		.002-.004		.004-.006		.006-.008		.008-.010					
56-450	1 x D			.002-.004		.002-.004		.003-.005		.004-.006		.005-.007					
57-000	1 x D			.002-.004		.002-.004		.003-.005		.004-.006		.005-.007					
57-600	1 x D							.004-.006		.006-.008		.008-.010		.008-.010	.010-.012		
60-200	1 x D							.002-.004		.002-.006		.002-.006		.004-.008			
62-700	1 x D			.002-.004		.004-.006		.006-.010		.006-.010		.010-.012					
62-750	1 x D			.002-.004		.004-.006		.006-.010		.006-.010		.010-.012					
62-800	1 x D			.002-.004		.004-.006		.006-.010		.006-.010		.010-.012					
62-850	1 x D			.002-.004		.004-.006		.006-.010		.006-.010		.010-.012					
63-700	1 x D	.002-.003		.002-.004		.004-.006		.006-.010		.006-.010		.010-.012					
63-750	1 x D	.002-.003		.002-.004		.004-.006		.006-.010		.006-.010		.010-.012					
63-800	1 x D	.002-.003		.002-.004		.004-.006		.006-.010		.006-.010		.010-.012					
63-850	1 x D	.002-.003		.002-.004		.004-.006		.006-.010		.006-.010		.010-.012					
64-000/ 65-000	1 x D	.002-.004		.006-.008		.008-.010	.010-.012	.010-.012		.010-.012							
66-000	1 x D							.002-.004		.003-.005		.004-.006					

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