

Solid Carbide Low Helix Spiral Finisher Chip Load Per Tooth

INDUSTRIAL

Up-Cut Tool No.	Down-Cut Tool No.	Softwood	Hardwood	Plastic	Solid Surface	Composite Plastic
51630	51730	.005" - .007"	.003" - .005"	.004" - .006"	.002" - .004"	.002" - .004"
51632	51732	.006" - .008"	.004" - .006"	.004" - .006"	.002" - .006"	.002" - .006"

Based on 18,000 RPM spindle.

Note: Always have sufficient spoil-board chip clearance when utilizing down spiral tooling.

Simple Machining Calculations:

To find **RPM:** SFM x 3.82 / diameter of tool

To find **SFM:** 0.262 x diameter of tool x RPM

To find **Feed Rate:** RPM x # of flutes x chip load

