

MIL-TEC's Easy Guide to Proper Speeds and Feeds for the Freedom Cutter®



Please contact us at the 800 number listed below for the speeds and feeds of cutters with diameters greater than 10".

Phone: (800) 564-5832

Fax: (866) 244-0298

5578 6th Street W.
Lehigh Acres, FL 33971

www.miltecusa.com

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CHART A:

Safe Starting Parameters for the MIL-TEC Freedom Cutter®

| Workpiece Material | | SFPM | | Recommended Chip Load Per Blade | | |
|--------------------------------------|-------------|------|-------|--------------------------------------------|-----------|-------|
| | | | | Type of Octagon Insert | | |
| | | Min. | Max. | SS45L | PS45L | NP45L |
| Die & High | Below 28RC | 800 | 1200 | .004 | .006 | .012 |
| Carbon Steels | 32 to 42 RC | 450 | 900 | N/A | .006 | .010 |
| Low Carbon Steels | | 850 | 1200 | .004 | .006 | .010 |
| Austenitic Stainless Steels | | 800 | 1800 | .004 | .008 | .012 |
| "PH" Type Stainless Steels | | 800 | 1500 | .004 | .008 | .012 |
| 400 Series Stainless Steel | | 800 | 1500 | .004 | .008 | .012 |
| Aluminum & Al. Alloys | | 800 | 12000 | Super Shear Only - Maximum Chip Load: .018 | | |
| Cast Iron (Soft) Approx. 187 Brinell | | 650 | 1200 | N/A | .008 | .012 |
| Plastic, Non Metals & Wood | | 800 | 8000 | Super Shear Only - Maximum Chip Load: .015 | | |
| Ductile Iron & Nodular Iron | | 900 | 1500 | .004 | .008 | .015 |
| Nickel Based Alloys | | 80 | 500 | N/A | .003/.005 | N/A |
| Copper & Brass | | 1000 | 2500 | .003 | .005 | N/A |
| Titanium | | 80 | 500 | N/A | .003/.008 | N/A |

- STEP 1** SELECT THE WORKPIECE MATERIAL
STEP 2 A) USING UNCOATED CARBIDE, SELECT THE MINIMUM SFPM
 B) USING COATED CARBIDE, SELECT THE MID-RANGE SFPM
STEP 3 GO TO CHART B.

MIL-TEC CARBIDE "MTC"

| Type of Material | Heavy Feeds | Moderate Feeds | General Purpose |
|------------------|-------------|----------------|-----------------|
| Steel | 317 A2 | 357 A2 | 54 A2 |
| Aluminum | 21 | 20 | 51 |
| Cast Iron | 317 A2 | 327 A2 | 327 A2 |

CHART B:

CHART OF SURFACE FEET PER MINUTE

CUTTER DIAMETER IN INCHES

| RPM | 0.5 | 1 | 2 | 3 | 4 | 5 | 6 | 8 | 10 |
|--------|-------|-------|-------|--------|--------|--------|--------|--------|--------|
| 50 | 7 | 13 | 26 | 39 | 52 | 65 | 79 | 105 | 131 |
| 100 | 13 | 26 | 52 | 79 | 105 | 131 | 157 | 209 | 262 |
| 200 | 26 | 52 | 105 | 157 | 209 | 262 | 314 | 419 | 524 |
| 300 | 39 | 79 | 157 | 236 | 314 | 393 | 471 | 628 | 785 |
| 400 | 52 | 105 | 209 | 314 | 419 | 524 | 628 | 838 | 1,047 |
| 500 | 65 | 131 | 262 | 393 | 524 | 654 | 785 | 1,047 | 1,309 |
| 600 | 79 | 157 | 314 | 471 | 628 | 785 | 942 | 1,257 | 1,571 |
| 700 | 92 | 183 | 366 | 550 | 733 | 916 | 1,099 | 1,466 | 1,832 |
| 800 | 105 | 209 | 419 | 628 | 838 | 1,047 | 1,257 | 1,675 | 2,094 |
| 900 | 118 | 236 | 471 | 707 | 942 | 1,178 | 1,414 | 1,885 | 2,356 |
| 1,000 | 131 | 262 | 524 | 785 | 1,047 | 1,309 | 1,571 | 2,094 | 2,618 |
| 1,500 | 196 | 393 | 785 | 1,178 | 1,571 | 1,963 | 2,356 | 3,141 | 3,927 |
| 2,000 | 262 | 524 | 1,047 | 1,571 | 2,094 | 2,618 | 3,141 | 4,188 | 5,236 |
| 2,500 | 327 | 654 | 1,309 | 1,963 | 2,618 | 3,272 | 3,927 | 5,236 | 6,545 |
| 3,000 | 393 | 785 | 1,571 | 2,356 | 3,141 | 3,927 | 4,712 | 6,283 | 7,853 |
| 3,500 | 458 | 916 | 1,832 | 2,749 | 3,665 | 4,581 | 5,497 | 7,330 | 9,162 |
| 4,000 | 524 | 1,047 | 2,094 | 3,141 | 4,188 | 5,236 | 6,283 | 8,377 | 10,471 |
| 4,500 | 589 | 1,178 | 2,356 | 3,534 | 4,712 | 5,890 | 7,068 | 9,424 | 11,780 |
| 5,000 | 654 | 1,309 | 2,618 | 3,927 | 5,236 | 6,545 | 7,853 | 10,471 | 13,089 |
| 5,500 | 720 | 1,440 | 2,880 | 4,319 | 5,759 | 7,199 | 8,639 | 11,518 | 14,398 |
| 6,000 | 785 | 1,571 | 3,141 | 4,712 | 6,283 | 7,853 | 9,424 | 12,565 | 15,707 |
| 6,500 | 851 | 1,702 | 3,403 | 5,105 | 6,806 | 8,508 | 10,209 | 13,613 | 17,016 |
| 7,000 | 916 | 1,832 | 3,665 | 5,497 | 7,330 | 9,162 | 10,995 | 14,660 | 18,325 |
| 7,500 | 982 | 1,963 | 3,927 | 5,890 | 7,853 | 9,817 | 11,780 | 15,707 | 19,634 |
| 8,000 | 1,047 | 2,094 | 4,188 | 6,283 | 8,377 | 10,471 | 12,565 | 16,754 | 20,942 |
| 8,500 | 1,113 | 2,225 | 4,450 | 6,675 | 8,901 | 11,126 | 13,351 | 17,801 | 22,251 |
| 9,000 | 1,178 | 2,356 | 4,712 | 7,068 | 9,424 | 11,780 | 14,136 | 18,848 | 23,560 |
| 9,500 | 1,243 | 2,487 | 4,974 | 7,461 | 9,948 | 12,435 | 14,921 | 19,895 | 24,869 |
| 10,000 | 1,309 | 2,618 | 5,236 | 7,853 | 10,471 | 13,089 | 15,707 | 20,942 | 26,178 |
| 10,500 | 1,374 | 2,749 | 5,497 | 8,246 | 10,995 | 13,743 | 16,492 | 21,990 | 27,487 |
| 11,000 | 1,440 | 2,880 | 5,759 | 8,639 | 11,518 | 14,398 | 17,277 | 23,037 | 28,796 |
| 11,500 | 1,505 | 3,010 | 6,021 | 9,031 | 12,042 | 15,052 | 18,063 | 24,084 | 30,105 |
| 12,000 | 1,571 | 3,141 | 6,283 | 9,424 | 12,565 | 15,707 | 18,848 | 25,131 | 31,414 |
| 12,500 | 1,636 | 3,272 | 6,545 | 9,817 | 13,089 | 16,361 | 19,634 | 26,178 | 32,723 |
| 13,000 | 1,702 | 3,403 | 6,806 | 10,209 | 13,613 | 17,016 | 20,419 | 27,225 | 34,031 |
| 13,500 | 1,767 | 3,534 | 7,068 | 10,602 | 14,136 | 17,670 | 21,204 | 28,272 | 35,340 |
| 14,000 | 1,832 | 3,665 | 7,330 | 10,995 | 14,660 | 18,325 | 21,990 | 29,319 | 36,649 |
| 14,500 | 1,898 | 3,796 | 7,592 | 11,387 | 15,183 | 18,979 | 22,775 | 30,366 | 37,958 |
| 15,000 | 1,963 | 3,927 | 7,853 | 11,780 | 15,707 | 19,634 | 23,560 | 31,414 | 39,267 |

- STEP 1** FIND THE DIAMETER OF YOUR CUTTER ON THE TOP ROW.
STEP 2 LOOK DOWN THAT COLUMN TO FIND THE SFPM FIGURE CLOSEST TO THE ONE SELECTED FOR YOUR WORKPIECE MATERIAL.
STEP 3 LOOK LEFT TO THE FIRST COLUMN TO FIND THE APPROPRIATE RPM FOR APPLICATION (NOW GO TO CHART C).

CHART C:

BLADES PER MINUTE

BLADES PER CUTTER

| RPM | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 |
|--------|--------|--------|--------|--------|--------|--------|---------|---------|---------|---------|
| 50 | 50 | 100 | 150 | 200 | 250 | 300 | 350 | 400 | 450 | 500 |
| 100 | 100 | 200 | 300 | 400 | 500 | 600 | 700 | 800 | 900 | 1,000 |
| 200 | 200 | 400 | 600 | 800 | 1,000 | 1,200 | 1,400 | 1,600 | 1,800 | 2,000 |
| 300 | 300 | 600 | 900 | 1,200 | 1,500 | 1,800 | 2,100 | 2,400 | 2,700 | 3,000 |
| 400 | 400 | 800 | 1,200 | 1,600 | 2,000 | 2,400 | 2,800 | 3,200 | 3,600 | 4,000 |
| 500 | 500 | 1,000 | 1,500 | 2,000 | 2,500 | 3,000 | 3,500 | 4,000 | 4,500 | 5,000 |
| 600 | 600 | 1,200 | 1,800 | 2,400 | 3,000 | 3,600 | 4,200 | 4,800 | 5,400 | 6,000 |
| 700 | 700 | 1,400 | 2,100 | 2,800 | 3,500 | 4,200 | 4,900 | 5,600 | 6,300 | 7,000 |
| 800 | 800 | 1,600 | 2,400 | 3,200 | 4,000 | 4,800 | 5,600 | 6,400 | 7,200 | 8,000 |
| 900 | 900 | 1,800 | 2,700 | 3,600 | 4,500 | 5,400 | 6,300 | 7,200 | 8,100 | 9,000 |
| 1,000 | 1,000 | 2,000 | 3,000 | 4,000 | 5,000 | 6,000 | 7,000 | 8,000 | 9,000 | 10,000 |
| 1,500 | 1,500 | 3,000 | 4,500 | 6,000 | 7,500 | 9,000 | 10,500 | 12,000 | 13,500 | 15,000 |
| 2,000 | 2,000 | 4,000 | 6,000 | 8,000 | 10,000 | 12,000 | 14,000 | 16,000 | 18,000 | 20,000 |
| 2,500 | 2,500 | 5,000 | 7,500 | 10,000 | 12,500 | 15,000 | 17,500 | 20,000 | 22,500 | 25,000 |
| 3,000 | 3,000 | 6,000 | 9,000 | 12,000 | 15,000 | 18,000 | 21,000 | 24,000 | 27,000 | 30,000 |
| 3,500 | 3,500 | 7,000 | 10,500 | 14,000 | 17,500 | 21,000 | 24,500 | 28,000 | 31,500 | 35,000 |
| 4,000 | 4,000 | 8,000 | 12,000 | 16,000 | 20,000 | 24,000 | 28,000 | 32,000 | 36,000 | 40,000 |
| 4,500 | 4,500 | 9,000 | 13,500 | 18,000 | 22,500 | 27,000 | 31,500 | 36,000 | 40,500 | 45,000 |
| 5,000 | 5,000 | 10,000 | 15,000 | 20,000 | 25,000 | 30,000 | 35,000 | 40,000 | 45,000 | 50,000 |
| 5,500 | 5,500 | 11,000 | 16,500 | 22,000 | 27,500 | 33,000 | 38,500 | 44,000 | 49,500 | 55,000 |
| 6,000 | 6,000 | 12,000 | 18,000 | 24,000 | 30,000 | 36,000 | 42,000 | 48,000 | 54,000 | 60,000 |
| 6,500 | 6,500 | 13,000 | 19,500 | 26,000 | 32,500 | 39,000 | 45,500 | 52,000 | 58,500 | 65,000 |
| 7,000 | 7,000 | 14,000 | 21,000 | 28,000 | 35,000 | 42,000 | 49,000 | 56,000 | 63,000 | 70,000 |
| 7,500 | 7,500 | 15,000 | 22,500 | 30,000 | 37,500 | 45,000 | 52,500 | 60,000 | 67,500 | 75,000 |
| 8,000 | 8,000 | 16,000 | 24,000 | 32,000 | 40,000 | 48,000 | 56,000 | 64,000 | 72,000 | 80,000 |
| 8,500 | 8,500 | 17,000 | 25,500 | 34,000 | 42,500 | 51,000 | 59,500 | 68,000 | 76,500 | 85,000 |
| 9,000 | 9,000 | 18,000 | 27,000 | 36,000 | 45,000 | 54,000 | 63,000 | 72,000 | 81,000 | 90,000 |
| 9,500 | 9,500 | 19,000 | 28,500 | 38,000 | 47,500 | 57,000 | 66,500 | 76,000 | 85,500 | 95,000 |
| 10,000 | 10,000 | 20,000 | 30,000 | 40,000 | 50,000 | 60,000 | 70,000 | 80,000 | 90,000 | 100,000 |
| 10,500 | 10,500 | 21,000 | 31,500 | 42,000 | 52,500 | 63,000 | 73,500 | 84,000 | 94,500 | 105,000 |
| 11,000 | 11,000 | 22,000 | 33,000 | 44,000 | 55,000 | 66,000 | 77,000 | 88,000 | 99,000 | 110,000 |
| 11,500 | 11,500 | 23,000 | 34,500 | 46,000 | 57,000 | 69,000 | 80,500 | 92,000 | 103,500 | 115,000 |
| 12,000 | 12,000 | 24,000 | 36,000 | 48,000 | 60,000 | 72,000 | 84,000 | 96,000 | 108,000 | 120,000 |
| 12,500 | 12,500 | 25,000 | 37,500 | 50,000 | 62,500 | 75,000 | 87,500 | 100,000 | 112,500 | 125,000 |
| 13,000 | 13,000 | 26,000 | 39,000 | 52,000 | 65,000 | 78,000 | 91,000 | 104,000 | 117,000 | 130,000 |
| 13,500 | 13,500 | 27,000 | 40,500 | 54,000 | 67,500 | 81,000 | 94,500 | 108,000 | 121,500 | 135,000 |
| 14,000 | 14,000 | 28,000 | 42,000 | 56,000 | 70,000 | 84,000 | 98,000 | 112,000 | 126,000 | 140,000 |
| 14,500 | 14,500 | 29,000 | 43,500 | 58,000 | 72,500 | 87,000 | 101,500 | 116,000 | 130,500 | 145,000 |
| 15,000 | 15,000 | 30,000 | 45,000 | 60,000 | 75,000 | 90,000 | 105,000 | 120,000 | 135,000 | 150,000 |

- STEP 1** USING THE RPM FIGURE FROM CHART B, GO ACROSS THE ROW TO THE COLUMN INDICATING THE NUMBER OF BLADES IN YOUR CUTTER
- STEP 2** THE RESULTING FIGURE IS THE BLADES PER MINUTE.
- STEP 3** GO TO THE FEED RATE CHART (CHART D).

| BLADES PER MIN | 0.001 | 0.002 | 0.003 | 0.004 | 0.005 | 0.006 | 0.007 | 0.008 | 0.009 | 0.010 | 0.011 | 0.012 | 0.013 | 0.014 | 0.015 | 0.016 | 0.017 | 0.018 | 0.019 | 0.020 |
|----------------|--------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|
| 50 | 0.050 | 0.100 | 0.150 | 0.200 | 0.250 | 0.300 | 0.350 | 0.400 | 0.450 | 0.500 | 0.550 | 0.600 | 0.650 | 0.700 | 0.750 | 0.800 | 0.850 | 0.900 | 0.950 | 1.000 |
| 100 | 0.100 | 0.200 | 0.300 | 0.400 | 0.500 | 0.600 | 0.700 | 0.800 | 0.900 | 1.000 | 1.100 | 1.200 | 1.300 | 1.400 | 1.500 | 1.600 | 1.700 | 1.800 | 1.900 | 2.000 |
| 200 | 0.200 | 0.400 | 0.600 | 0.800 | 1.000 | 1.200 | 1.400 | 1.600 | 1.800 | 2.000 | 2.200 | 2.400 | 2.600 | 2.800 | 3.000 | 3.200 | 3.400 | 3.600 | 3.800 | 4.000 |
| 300 | 0.300 | 0.600 | 0.900 | 1.200 | 1.500 | 1.800 | 2.100 | 2.400 | 2.700 | 3.000 | 3.300 | 3.600 | 3.900 | 4.200 | 4.500 | 4.800 | 5.100 | 5.400 | 5.700 | 6.000 |
| 400 | 0.400 | 0.800 | 1.200 | 1.600 | 2.000 | 2.400 | 2.800 | 3.200 | 3.600 | 4.000 | 4.400 | 4.800 | 5.200 | 5.600 | 6.000 | 6.400 | 6.800 | 7.200 | 7.600 | 8.000 |
| 500 | 0.500 | 1.000 | 1.500 | 2.000 | 2.500 | 3.000 | 3.500 | 4.000 | 4.500 | 5.000 | 5.500 | 6.000 | 6.500 | 7.000 | 7.500 | 8.000 | 8.500 | 9.000 | 9.500 | 10.000 |
| 1,000 | 1.000 | 2.000 | 3.000 | 4.000 | 5.000 | 6.000 | 7.000 | 8.000 | 9.000 | 10.000 | 11.000 | 12.000 | 13.000 | 14.000 | 15.000 | 16.000 | 17.000 | 18.000 | 19.000 | 20.000 |
| 2,000 | 2.000 | 4.000 | 6.000 | 8.000 | 10.000 | 12.000 | 14.000 | 16.000 | 18.000 | 20.000 | 22.000 | 24.000 | 26.000 | 28.000 | 30.000 | 32.000 | 34.000 | 36.000 | 38.000 | 40.000 |
| 3,000 | 3.000 | 6.000 | 9.000 | 12.000 | 15.000 | 18.000 | 21.000 | 24.000 | 27.000 | 30.000 | 33.000 | 36.000 | 39.000 | 42.000 | 45.000 | 48.000 | 51.000 | 54.000 | 57.000 | 60.000 |
| 4,000 | 4.000 | 8.000 | 12.000 | 16.000 | 20.000 | 24.000 | 28.000 | 32.000 | 36.000 | 40.000 | 44.000 | 48.000 | 52.000 | 56.000 | 60.000 | 64.000 | 68.000 | 72.000 | 76.000 | 80.000 |
| 5,000 | 5.000 | 10.000 | 15.000 | 20.000 | 25.000 | 30.000 | 35.000 | 40.000 | 45.000 | 50.000 | 55.000 | 60.000 | 65.000 | 70.000 | 75.000 | 80.000 | 85.000 | 90.000 | 95.000 | 100.000 |
| 6,000 | 6.000 | 12.000 | 18.000 | 24.000 | 30.000 | 36.000 | 42.000 | 48.000 | 54.000 | 60.000 | 66.000 | 72.000 | 78.000 | 84.000 | 90.000 | 96.000 | 102.000 | 108.000 | 114.000 | 120.000 |
| 7,000 | 7.000 | 14.000 | 21.000 | 28.000 | 35.000 | 42.000 | 49.000 | 56.000 | 63.000 | 70.000 | 77.000 | 84.000 | 91.000 | 98.000 | 105.000 | 112.000 | 119.000 | 126.000 | 133.000 | 140.000 |
| 8,000 | 8.000 | 16.000 | 24.000 | 32.000 | 40.000 | 48.000 | 56.000 | 64.000 | 72.000 | 80.000 | 88.000 | 96.000 | 104.000 | 112.000 | 120.000 | 128.000 | 136.000 | 144.000 | 152.000 | 160.000 |
| 9,000 | 9.000 | 18.000 | 27.000 | 36.000 | 45.000 | 54.000 | 63.000 | 72.000 | 81.000 | 90.000 | 99.000 | 108.000 | 117.000 | 126.000 | 135.000 | 144.000 | 153.000 | 162.000 | 171.000 | 180.000 |
| 10,000 | 10.000 | 20.000 | 30.000 | 40.000 | 50.000 | 60.000 | 70.000 | 80.000 | 90.000 | 100.000 | 110.000 | 120.000 | 130.000 | 140.000 | 150.000 | 160.000 | 170.000 | 180.000 | 190.000 | 200.000 |
| 15,000 | 15.000 | 30.000 | 45.000 | 60.000 | 75.000 | 90.000 | 105.000 | 120.000 | 135.000 | 150.000 | 165.000 | 180.000 | 195.000 | 210.000 | 225.000 | 240.000 | 255.000 | 270.000 | 285.000 | 300.000 |
| 20,000 | 20.000 | 40.000 | 60.000 | 80.000 | 100.000 | 120.000 | 140.000 | 160.000 | 180.000 | 200.000 | 220.000 | 240.000 | 260.000 | 280.000 | 300.000 | 320.000 | 340.000 | 360.000 | 380.000 | 400.000 |
| 25,000 | 25.000 | 50.000 | 75.000 | 100.000 | 125.000 | 150.000 | 175.000 | 200.000 | 225.000 | 250.000 | 275.000 | 300.000 | 325.000 | 350.000 | 375.000 | 400.000 | 425.000 | 450.000 | 475.000 | 500.000 |
| 30,000 | 30.000 | 60.000 | 90.000 | 120.000 | 150.000 | 180.000 | 210.000 | 240.000 | 270.000 | 300.000 | 330.000 | 360.000 | 390.000 | 420.000 | 450.000 | 480.000 | 510.000 | 540.000 | 570.000 | 600.000 |
| 35,000 | 35.000 | 70.000 | 105.000 | 140.000 | 175.000 | 210.000 | 245.000 | 280.000 | 315.000 | 350.000 | 385.000 | 420.000 | 455.000 | 490.000 | 525.000 | 560.000 | 595.000 | 630.000 | 665.000 | 700.000 |
| 40,000 | 40.000 | 80.000 | 120.000 | 160.000 | 200.000 | 240.000 | 280.000 | 320.000 | 360.000 | 400.000 | 440.000 | 480.000 | 520.000 | 560.000 | 600.000 | 640.000 | 680.000 | 720.000 | 760.000 | 800.000 |
| 45,000 | 45.000 | 90.000 | 135.000 | 180.000 | 225.000 | 270.000 | 315.000 | 360.000 | 405.000 | 450.000 | 495.000 | 540.000 | 585.000 | 630.000 | 675.000 | 720.000 | 765.000 | 810.000 | 855.000 | 900.000 |
| 50,000 | 50.000 | 100.000 | 150.000 | 200.000 | 250.000 | 300.000 | 350.000 | 400.000 | 450.000 | 500.000 | 550.000 | 600.000 | 650.000 | 700.000 | 750.000 | 800.000 | 850.000 | 900.000 | 950.000 | 1,000.000 |
| 60,000 | 60.000 | 120.000 | 180.000 | 240.000 | 300.000 | 360.000 | 420.000 | 480.000 | 540.000 | 600.000 | 660.000 | 720.000 | 780.000 | 840.000 | 900.000 | 960.000 | 1,020.000 | 1,080.000 | 1,140.000 | 1,200.000 |
| 65,000 | 65.000 | 130.000 | 195.000 | 260.000 | 320.000 | 380.000 | 440.000 | 500.000 | 560.000 | 620.000 | 680.000 | 740.000 | 800.000 | 860.000 | 920.000 | 980.000 | 1,040.000 | 1,100.000 | 1,160.000 | 1,220.000 |
| 70,000 | 70.000 | 140.000 | 210.000 | 280.000 | 340.000 | 400.000 | 460.000 | 520.000 | 580.000 | 640.000 | 700.000 | 760.000 | 820.000 | 880.000 | 940.000 | 1,000.000 | 1,060.000 | 1,120.000 | 1,180.000 | 1,240.000 |
| 75,000 | 75.000 | 150.000 | 225.000 | 300.000 | 375.000 | 450.000 | 525.000 | 600.000 | 675.000 | 750.000 | 825.000 | 900.000 | 975.000 | 1,050.000 | 1,125.000 | 1,200.000 | 1,275.000 | 1,350.000 | 1,425.000 | 1,500.000 |

- STEP 1** FIND THE BLADES PER MINUTE FROM CHART C IN THE FIRST COLUMN BY ROUNDING TO THE NEAREST FIGURE IN THE COLUMN.
- STEP 2** FIND THE SUGGESTED CHIP LOAD PER BLADE FROM CHART A ON THE THE TOP ROW OF THIS CHART
- STEP 3** FIND THE FEED RATE IN INCHES PER MINUTE WHERE THE VALUES FROM STEP 1 AND STEP 2 INTERSECT

FRACTION DECIMAL METRIC EQUIVALENT CHART

| Fraction | Decimal |
|----------|---------|
|----------|---------|