



The Gilman Brothers Company

CUTTING GUIDELINES



Material	Thickness	Type of Cut	Tool	Blade	Degree Angle	Milling Bit	Speed Meters/Min	Milling RPM's	Plunging Speed Meters/Min	Acceleration in %
Eagle Cell	1/4"	Less Detail	Electric	500			80		8	100
Eagle Cell	1/4"	Medium Detail	Electric	502			80		8	100
Eagle Cell	1/4"	More Detail	Electric	502			60		8	100
Eagle Cell	1/4"	Less Detail	Pneumatic	501			20		8	100
Eagle Cell	1/4"	Medium Detail	Pneumatic	513			20		8	100
Eagle Cell	1/4"	More Detail	Pneumatic	508			10		8	100
Eagle Cell	1/4"	'V' Cut	V2	529	45		80		8	100
Eagle Cell	1/2"	Less Detail	Electric	516			80		8	100
Eagle Cell	1/2"	Medium Detail	Electric	516			65		8	100
Eagle Cell	1/2"	More Detail	Electric	516			50		8	65
Eagle Cell	1/2"	Less Detail	Pneumatic	516 or 504			20		8	100
Eagle Cell	1/2"	Medium Detail	Pneumatic	516 or 504			20		8	100
Eagle Cell	1/2"	More Detail	Pneumatic	516			10		8	50
Eagle Cell	1/2"	'V' Cut	V2	529	45		80		8	100
Infinity	3/16	Less Detail	Electric	502			80		4	100
Infinity	3/16	Medium Detail	Electric	502 or 517			80		4	100
Infinity	3/16	More Detail	Electric	508			60		4	100
Infinity	3/16	Less Detail	Pneumatic	517			20		4	100
Infinity	3/16	Medium Detail	Pneumatic	517			20		4	100
Infinity	3/16	More Detail	Pneumatic	508			15		4	100
Infinity	3/16	Less Detail	Mill			1R64	40	60K	4	75
Infinity	3/16	Medium Detail	Mill			1R62	25	60K	4	75
Infinity	3/16	More Detail	Mill			1R62	16	60K	4	75
Infinity	3/16	'V' Cut	V2	529	45		80		8	100



The Gilman Brothers Company

CUTTING GUIDELINES



Material	Thickness	Type of Cut	Tool	Blade	Degree Angle	Milling Bit	Speed Meters/Min	Milling RPM's	Plunging Speed Meters/Min	Acceleration in %
Infinity	1/2	Less Detail	Electric	516			80		4	100
Infinity	1/2	Medium Detail	Electric	516			80		4	100
Infinity	1/2	More Detail	Electric	516			60		4	100
Infinity	1/2	Less Detail	Pneumatic	516 or 504			20		4	100
Infinity	1/2	Medium Detail	Pneumatic	516 or 504			15		4	85
Infinity	1/2	More Detail	Pneumatic	516			10		4	50
Infinity	1/2	Less Detail	Mill			1R64	40	60K	4	65
Infinity	1/2	Medium Detail	Mill			1R64	20	60K	4	65
Infinity	1/2	More Detail	Mill			1R64	16	60K	4	65
Infinity	1/2	'V' Cut	V2	529	45		80		8	100
Insite	3/16	Less Detail	Electric	502			80		8	100
Insite	3/16	Medium Detail	Electric	502 or 517			80		8	100
Insite	3/16	More Detail	Electric	508			60		8	100
Insite	3/16	Less Detail	Pneumatic	517			20		8	100
Insite	3/16	Medium Detail	Pneumatic	517			20		8	100
Insite	3/16	More Detail	Pneumatic	508			15		8	100
Insite	3/16	'V' Cut	V2	529	45		80		8	100
Resilient w/b/b	3/4	Less Detail	Pneumatic	504 or 506			20		8	100
Resilient w/b/b	3/4	Medium Detail	Pneumatic	504 or 506			20		8	100
Resilient w/b/b	3/4	More Detail	Pneumatic	504			15		8	100
Resilient w/b/b	3/4	'V' Cut	V2	529	45		80		8	100