

Carbide Aerospace Routers CR 100

for fiber-reinforced plastics



Standard



No. Flutes



Helix angle



Rake Angle



Slotting



Roughing



Plunging



Finishing

Tool material

Surface finish



Solid Carbide

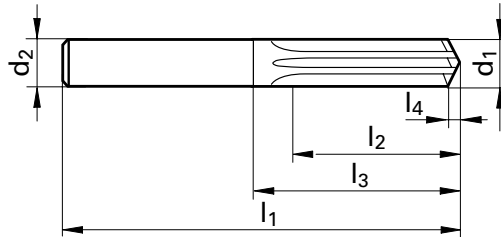
Diamond Coated

Series

6720

Application group	Material examples	Ideal for
P	Steel	—
M	Stainless steel	—
K	Cast iron	—
N	Aluminum	—
S	Ni / Ti alloys	—
H	Hardened steel	—
	Composites	●

● = Optimal ○ = Secondary



d1 e10	d2 h6	l1	l2	l3	l4	No. of Flutes	Code no.	EDP Number
mm	mm	mm	mm	mm	mm			
4.000	4.000	55.00	12.00	27.00	1.30	6	4.000	9067200040000
6.000	6.000	65.00	18.00	29.00	1.90	8	6.000	9067200060000
8.000	8.000	75.00	24.00	39.00	2.50	10	8.000	9067200080000
10.000	10.000	80.00	30.00	40.00	3.10	12	10.000	9067200100000
12.000	12.000	93.00	36.00	48.00	3.70	14	12.000	9067200120000
16.000	16.000	108.00	48.00	60.00	4.90	14	16.000	9067200160000

Cutting values: Slotting*, HPC-roughing and copy milling

Type	Characteristic	Feed depth a_p	Feed width** a_e	Cutting speed v_c	fz (mm/z) with nom. Ø						
					4	6	8	10	12	16	20
N	up to 7% Si	—	—	—	—	—	—	—	—	—	—
Aluminium	up to 17% Si	0.5xd	1xd	220	0.02	0.03	0.04	0.05	0.06	0.07	0.09
Graphite	up to 8 µm grain size	1.5xd	1xd	350	0.04	0.06	0.08	0.1	0.12	0.15	0.18
Composites	over 50% fiber content	1xd	1xd	200	0.015	0.03	0.04	0.05	0.06	0.08	0.09

* peripheral cooling "Guhrojet" is recommended for optimal chip evacuation and tool life, for graphite and Kevlar-machining air cooling

** at lower feed width the cutting speed v_c and feed rate f_z can be increased by 30%