

# Carbide Aerospace Routers CR 100 - Coolant Fed



## center cutting for fiber-reinforced plastics



Long



No. of Flutes



Helix angle



Chamfer



Rake Angle



Slotting



Roughing



Finishing



Tool material

Solid Carbide

Surface finish

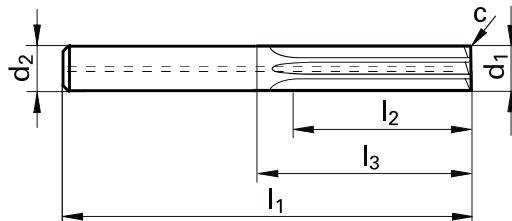
Diamond Coated

Series

6718

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	c	No. of Flutes	Code no.	EDP Number
mm	mm	mm	mm	mm	mm x 45°			
6.000	6.000	70.00	24.00	34.00	0.15	8	6.000	9067180060000
8.000	8.000	80.00	32.00	44.00	0.15	10	8.000	9067180080000
10.000	10.000	90.00	40.00	50.00	0.15	12	10.000	9067180100000
12.000	12.000	110.00	48.00	65.00	0.15	14	12.000	9067180120000
16.000	16.000	130.00	64.00	82.00	0.15	14	16.000	9067180160000

### 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 Aluminium	up to 7% Si	—	—	—	—	—	—	—	—	—	—
	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%