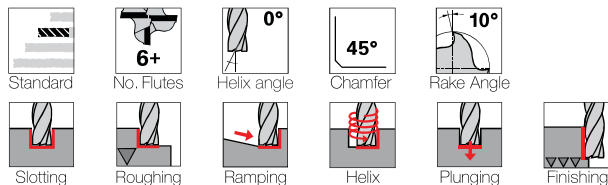


# Carbide Aerospace Routers CR 100

for fiber-reinforced plastics



Tool material

**Solid Carbide**

Surface finish

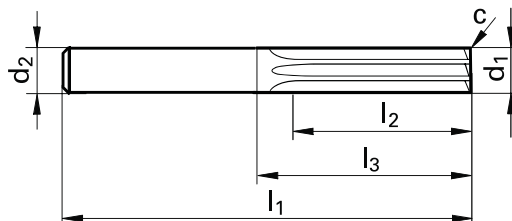
Diamond Coated

Series

**6719**

Application group	Material examples	Ideal for
<b>P</b>	Steel	—
<b>M</b>	Stainless steel	—
<b>K</b>	Cast iron	—
<b>N</b>	Aluminum	—
<b>S</b>	Ni / Ti alloys	—
<b>H</b>	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°			
4.000	6.000	57.00	10.00	19.40	0.10	6	4.000	9067190040000
6.000	6.000	65.00	15.00	29.00	0.15	8	6.000	9067190060000
8.000	8.000	75.00	20.00	39.00	0.15	10	8.000	9067190080000
10.000	10.000	80.00	25.00	40.00	0.15	12	10.000	9067190100000
12.000	12.000	93.00	32.00	48.00	0.15	14	12.000	9067190120000
16.000	16.000	108.00	34.00	60.00	0.15	14	16.000	9067190160000

### 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	
<b>N</b> 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	
<b>Graphite</b>	up to 8 µm grain size	1.5xd	1xd	350	0.04	0.06	0.08	0.1	0.12	0.15	0.18	
<b>Composites</b>	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%