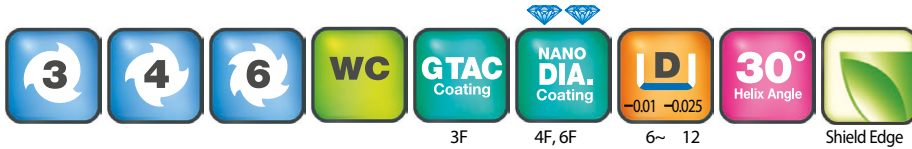
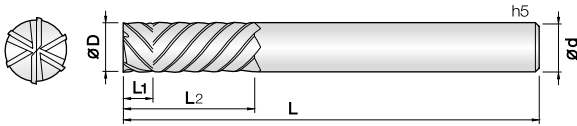


3&4&6CPR

3~6 Flutes Compression Router for Composite



D Size	D Tolerance
Ø6 ~ 12	-0.01 ~ -0.025 mm

3CPR

G-TAC Coating

• RPM : rev./min • Feed : mm/min

Material	CFRP			
Outside Diameter	RPM	FEED	Ap Axial Depth	Ae Radial Depth
Ø6	8,000	600	6	2.4
Ø8	6,000	600	8	3.2
Ø10	4,800	540	10	4.0
Ø12	4,000	540	12	4.8

4 & 6CPR

DIA Coating

• RPM : rev./min • Feed : mm/min

Material	4 C P R								6 C P R							
	CFRP				GFRP				CFRP				GFRP			
Outside Diameter	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth
Ø6	7,900	1,100	6	2.4	4,200	430	6	2.4	10,500	1,950	1.8	0.12	5,300	7,400	1.8	0.12
Ø8	5,960	1,600	8	3.2	3,200	590	8	3.2	7,970	2,950	2.4	0.16	3,900	950	2.4	0.16
Ø10	4,750	1,500	10	4.0	2,550	560	10	4.0	6,350	2,930	3	0.20	3,120	850	3	0.20
Ø12	3,950	2,060	12	4.8	2,120	725	12	4.8	5,300	3,900	3.6	0.24	2,600	1,050	3.6	0.24
Depth of Cut																

- In case of long effective length, reduce the RPM and feed by 20% or less.
- The edge of the flute precisely grinded. If you want to measure the tool, and to avoid damaging on the flutes, use non-contact measuring method.
- Use this table for your reference. Adjust the parameters depending on your machining geometry, machining purpose and CNC.
- If the table over the maximum RPM and feed of your machine, or found red heat on the material, adjust RPM and feed in the same proportion.
- Air blow or mist coolants are recommended and note for chip emission, heat, or ignition.