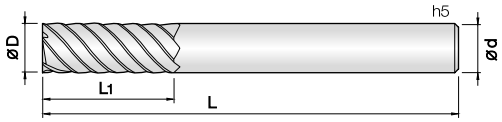
6~16CPO

6~16 Flutes Router for Composite

A Type

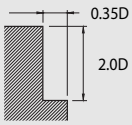
B Type



D Size	D Tolerance
Ø4 ~ 5	+0 ~ −0.01 mm
Ø6 ~ 12	−0.01 ~ −0.025 mm

6~16CPO Cutting Condition

• RPM : rev./min • Feed : mm/min

Material	CFRP				GFRP			
Outside Diameter	RPM	FEED	Ap Axial Depth	Ae Radial Depth	RPM	FEED	Ap Axial Depth	Ae Radial Depth
Ø4	15,900	1,400	8	1.4	15,900	1,400	8	1.4
Ø5	13,000	1,900	10	1.8	13,000	1,900	10	1.8
Ø6	10,600	2,200	12	2.1	10,600	2,200	12	2.1
Ø8	7,950	2,600	16	2.8	7,950	2,600	16	2.8
Ø10	6300	3050	20	3.5	6300	3050	20	3.5
Ø12	5300	3300	24	4.2	5300	3300	24	4.2
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.
- Above the value of the table is based on 8 flutes. If you use more than 8 flutes of endmill, raise up the RPM and Feed in a sam e proportion compared to the same diameter.
- 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.

TRUCUT TOOLS
ENGINEERING TOOLING