




## List 2061: BNC, Nick Router

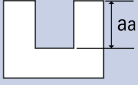
## List 2066: HBC, Compression Router, 30° Helix

## List 2064: HBC 45, Compression Router, 45° Helix

### Side Milling

Work Material	Carbon & Glass Fiber Reinforced Plastics	
Cutting Speed	400-800 SFM	
Depth of Cut	$aa < 1.5D$ $ar < 1D$ 	
Drill Diameter (Inch)	Speed RPM	Feed IPR
1/8	12,200 - 24,400	0.0011 - 0.0022
3/16	8,100 - 16,300	0.0021 - 0.0042
1/4	6,100 - 12,200	0.0033 - 0.0067
5/16	5,000 - 9,800	0.0047 - 0.0093
3/8	4,100 - 8,100	0.0067 - 0.0133
1/2	3,000 - 6,100	0.0111 - 0.0222

### Slotting

Work Material	Carbon & Glass Fiber Reinforced Plastics	
Cutting Speed	300-600 SFM	
Depth of Cut	$aa < 1D$ 	
Drill Diameter (Inch)	Speed RPM	Feed IPR
1/8	9,200 - 18,300	0.0016 - 0.0020
3/16	6,100 - 12,200	0.0020 - 0.0024
1/4	4,600 - 9,200	0.004 - 0.005
5/16	3,600 - 7,300	0.006 - 0.008
3/8	3,000 - 6,100	0.009 - 0.012
1/2	2,300 - 4,600	0.012 - 0.020

1. The conditions listed above are based on approximately 1xDc thickness of part with rigid work holding.
2. Conventional cut is recommended at part side for good surface finish.
3. Milling speed can be increased by 20-50% with the use of appropriate cutting oil.
4. Please provide appropriate measures against dust (Such as vacuum dust collection).
5. Depending on the workpiece thickness and form as well as work holding, vibration may occur. When it occurs, please adjust RPM and feed rate.

### Feed Reduction

Material Thickness	Feed Reduction
$\leq 0.25D$	x80%
0.25D ~ 0.5D	x150%
0.5D ~ 1D	x120%
1D ~ 2D	x80%
2D ~ 3D	x50%

