


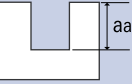


## List 641R: HFR, Hand Router

### 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
3/16	8,100 - 16,300	0.0015 - 0.0027
1/4	6,100 - 12,200	0.0033 - 0.0067
3/8	4,100 - 8,100	0.0067 - 0.0117
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
3/16	6,100 - 12,200	0.0010 - 0.0020
1/4	4,600 - 9,200	0.0021 - 0.0043
3/8	3,100 - 6,100	0.0044 - 0.0078
1/2	2,300 - 4,600	0.0071 - 0.0143

