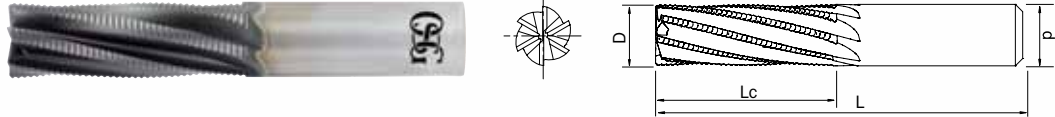


EXOPRO®-AERO-REC

List 2680 **NEW!**

Roughing Router - Diamond Coated



EDP Number	Mill Diameter	Length of Cut	OAL	Shank Diameter	No. of Flutes
	D	Lc	L	d	
26809316	15/64	3/4	2 1/2	1/4	4
26805316	1/4	1/2	2 1/2	1/4	4
26800316	1/4	3/4	2 1/2	1/4	4
26809416	5/16	15/16	3	3/8	6
26809516	23/64	1 1/8	3	3/8	6
26805516	3/8	3/4	3	3/8	6
26800516	3/8	1 1/8	3	3/8	6
26809616	7/16	1 15/16	3	1/2	8
26809716	31/64	1 1/2	3	1/2	8
26805716	1/2	1	3	1/2	8
26800716	1/2	1 1/2	3	1/2	8

Packed: 1 pc. Available Diamond coating only.



Recommended Cutting Conditions

SFM	Side Milling				Slotting			
	400		800		300		600	
Depth of Cut	Aa: Up to 1.5D / Ar: Up to 1D				Aa: 1D			
Dia.	RPM	Feed	RPM	Feed	RPM	Feed	RPM	Feed
1/4	6000	60	12000	180	5000	45	9000	90
3/8	4000	120	8000	240	3000	60	6000	120
1/2	3000	150	6000	300	2000	75	5000	150

Note: This table's parameters are based on common material thickness of approximately 0.250" under excellent workholding conditions and less than 20% x D depth of cut (side milling). Please adjust your parameters properly for your application or call OSG for assistance. Conventional milling is recommended for better surface finishes. Higher feed rates are possible but quality of part and surface should be considered.

Feed Reduction by Thickness of Part: Recommended feed adjustments based on thickness of part. (Above table is based on approximately 1xD thickness.)

≤0.5D	x 150%
0.5D-1D	x 120%
1D-2D	x 80%
3D-4D	x 50%






The EXOPRO®-AERO-REC is a diamond coated roughing router for roughing and semi-finishing of composites. The AERO-REC uses extremely low cutting forces for low rigid fixtures and weak spindles.

Performance Highlights

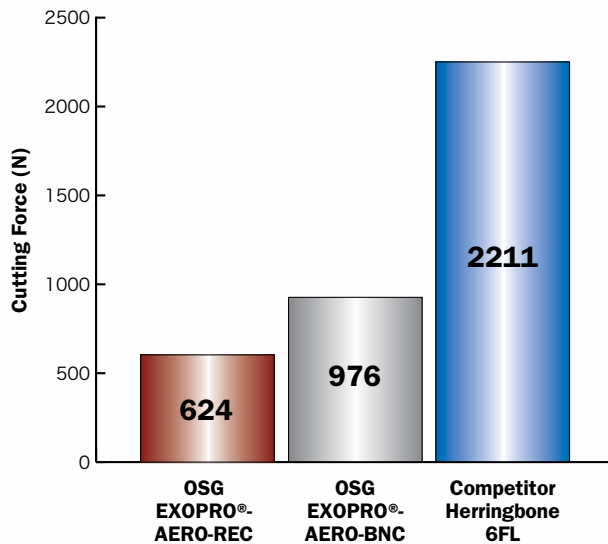
Due to the roughing nick profile AERO-REC can reduce cutting force over competitor herringbone 6-flute and our AERO-BNC.

Comparison of Surface Finish

Router size: 0.3937"	Aa: 1" Ar: 0.3937"
Coolant: Dry	Cutting Speed: 656 SFM
Material: CFRP	Cutting Feed: 15.7 IPM

		
OSG EXOPRO®- AERO-REC	OSG EXOPRO®- AERO-BNC	Competitor Herringbone 6FL

Cutting Force Comparison



Applications

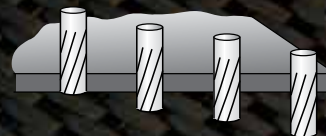
- ◆ Low rigid fixtures & setups and weak spindles
- ◆ Can be used in combination with AERO-MFR for finishing

Features

- ◆ Roughing nicks for efficient milling providing extremely low cutting forces

Flute Management

- ◆ By utilizing Flute Position Management*, tool life can be increased.



*To change the milling position at the flute