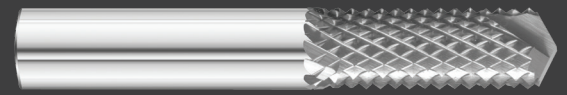


5600 COMPOSITE BURR / ROUTER



FULLERTON S P E E D S / F E E D S

5600 Series Fiberglass Routers produce clean shearing of material's fibers and allows for aggressive removal rates.

Flute Diameter	Carbon, Carbon Graphite, Unfilled Plastics		Composites		Fiber Reinforced Plastics		Green Ceramics, Green Carbide	
	Speed SFM	Feed IPR	Speed SFM	Feed IPR	Speed SFM	Feed IPR	Speed SFM	Feed IPR
1/8"	400-800	.0008-.0025	400-800	.0004-.0008	400-800	.0004-.0008	400-800	.0004-.0008
3/16"	600-1500	.0015-.0030	400-800	.0005-.0010	400-800	.0005-.0010	600-1500	.0008-.0020
1/4"	600-1500	.0025-.0040	400-800	.0008-.0020	400-800	.0008-.0020	600-1500	.0015-.0030
5/16"	600-1500	.0030-.0050	400-800	.0025-.0040	400-800	.0025-.0040	600-1500	.0025-.0040
3/8"	600-1500	.0040-.0065	400-800	.0030-.0055	400-800	.0030-.0055	600-1500	.0030-.0055
1/2"	600-1500	.0065-.0080	400-800	.0050-.0070	400-800	.0050-.0070	600-1500	.0050-.0070

The parameters listed for tool series that are stocked uncoated are based on running an uncoated tool. If a coating is applied to the tools, the SFM can be increased by approximately 25%. All speed and feed recommendations should be considered only as a starting point. Start with conservative speeds and feeds while analyzing the rigidity of the process. Then cautiously progress incrementally to achieve optimum performance.