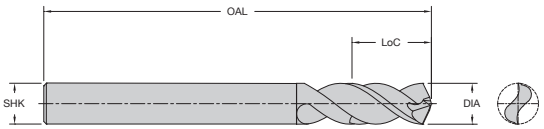
86-150 Series DFC Aerospace Composite Drill

SC | 0° | DFC | CP



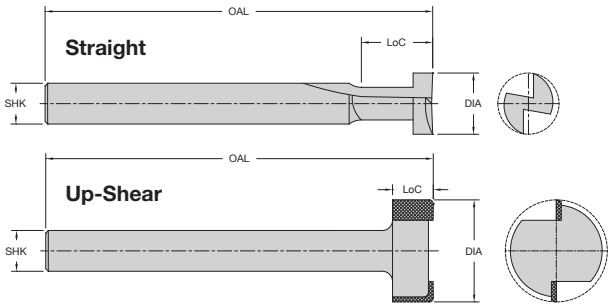
Carbon Fiber Reinforced (CFRP) drills produce a clean tight tolerance hole without fraying or delamination. Top-quality point grind ensures fiber shearing and prevents delamination on hole entry and exit. Enhanced diamond coating to protect cutting edges resulting in less tool changes.

86-150 Series DFC Aerospace Composite Drill (ACD) Product Offering

Part Number	Cutting DIA (inch)	Cutting DIA (mm)	LoC (inch)	Shank DIA (inch)	OAL (inch)	Flutes
86-152	0.1000	2.54	1	1/4	3	2
86-154	0.1295	3.29	1	1/4	3	2
86-156	0.1620	4.11	1	1/4	3	2
86-158	0.1920	4.88	1	1/4	3	2
86-160	0.2220	5.64	1	1/4	3	2
86-162	0.2510	6.38	1	1/4	3	2
86-164	0.3135	7.96	1	5/16	3	2
86-166	0.3760	9.55	1	3/8	3	2
86-168	0.4385	11.14	1	7/16	3	2
86-170	0.5010	12.73	1	1/2	3	2

91-000/91-100 Series Spoilboard Surfacing Cutters

SC | 0° | SP | HP | A | CW



Designed for surfacing MDF, particleboard and balsa core where "flow through" or "high flow" fixturing is employed using large capacity vacuum pumps. This method of surfacing spoilboards allows for much faster table planing.

91-000/91-100 Series Spoilboard Surfacing Cutters (**Straight**) Product Offering

Part Number	Cutting DIA (in)	LoC (in)	SHK DIA (in)	Flutes
91-000*	1-1/4	1/2	1-1/2	2
91-102	2-1/2	1/2	2	2
91-106	4	3/4	2-1/4	3

* = Carbide Tipped

91-000/91-100 Series Spoilboard Surfacing Cutters (**Up-Shear**) Product Offering

Part Number	Cutting DIA (in)	LoC (in)	SHK DIA (in)	Flutes
91-104	2-1/2	1/2	2	2
91-108	4	3/4	2-1/4	3
91-112[2]	2-1/2	1/2	2	3
91-114[2]	4	3/4	2-1/4	3

2 Radius edges excellent for plastic and aluminum surfacing.

Note: 91-102, 91-104, 91-106 & 91-108 use 91-125 insert and 91-133 screw
91-112 & 91-114 use 91-127 insert and 91-133 screw

• 2-1/2" diameter tools should be fed at 200-600 IPM at 12,000-16,000 RPM.
• 4" diameter tools should be fed at 200-600 IPM at 12,000-14,000 RPM.
** Do Not Exceed 1/8" Depth Per Pass*

Spare Parts

Part Number	Description
91-125	Insert 10/pk
91-127	Radius Insert 10/pk
91-130	Screw M4 (Old Version)
91-133	Screw M5
91-136	Wrench (T20)

These tools are dynamically balanced and approved for use on CNC routers.
Max RPM 18,000
1/8" Depth of cut MAX.