

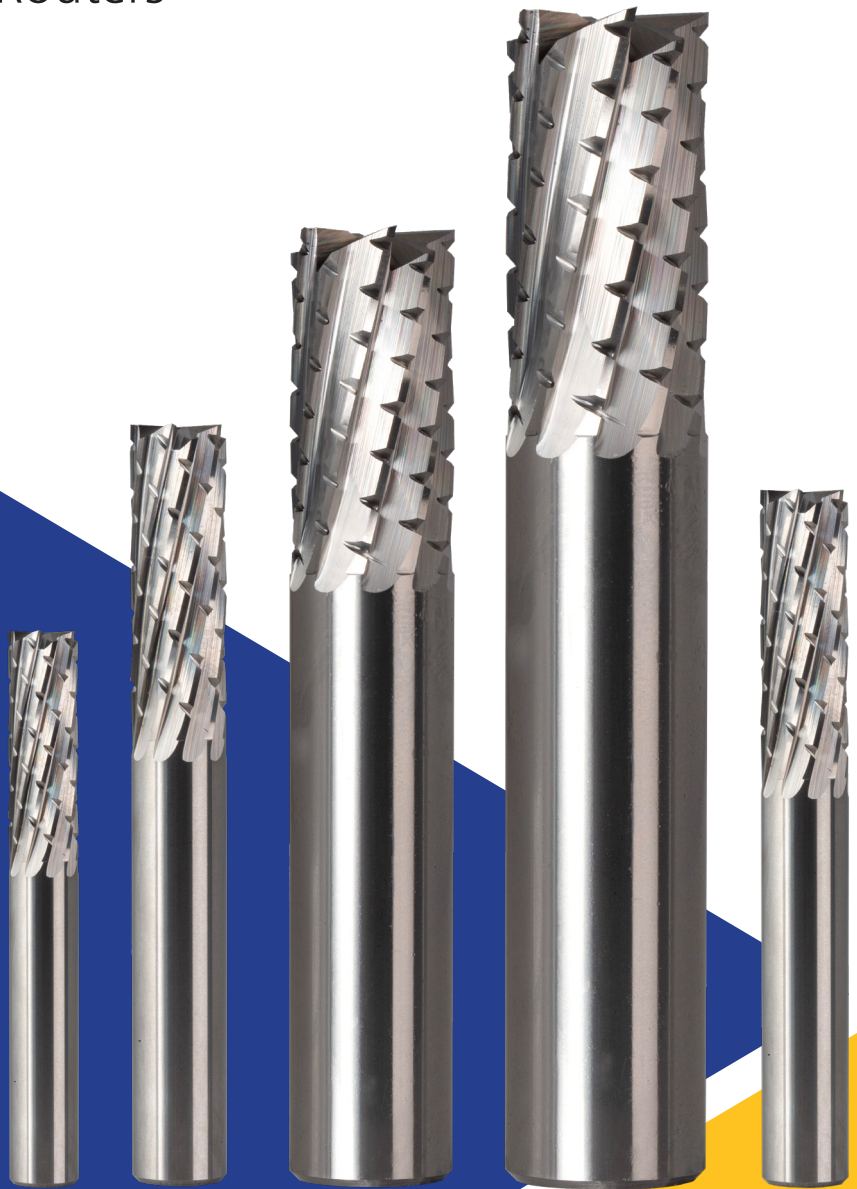


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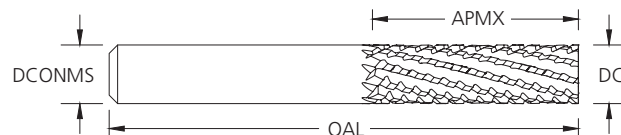
Series CGFR

Carbon & Glass Fibre Routers



www.mafordeurope.com

Series CGFR



Tool No.	DC	DCONMS	OAL	APMX	NOF
CGFR 0400	4.0	6.0	50.0	6.0	8
CGFR 0600	6.0	6.0	57.0	16.0	8
CGFR 0800	8.0	8.0	64.0	25.0	10
CGFR 1000	10.0	10.0	64.0	25.0	10
CGFR 1200	12.0	12.0	64.0	25.0	10
CGFR 1600	16.0	16.0	92.0	32.0	10
CGFR 2000	20.0	20.0	105.0	41.0	10

MA FORDMAX Series CGFR - Slotting with 2xD APMX

Recommended Cutting Data · Conditions de coupe recommandées · Empfohlene Schnittdaten · Dati di taglio Raccomandati · Zalecane Parametry

Workpiece Material Group	I S O	Coolant			ADOC (Ap) 			End Mill Diameter (mm)						
								4	6	8	10	12	16	20
		Emulsion	Air	MQL	25%	50%	100%	 Multiply fz by this factor based on ae. When finishing, use the standard fz per chart below. Only add chip thinning when roughing or semi-finishing.						
					Vc - M/Min									
GFRP Soft	N	●	●	x	100	80	60	0.016	0.024	0.032	0.040	0.048	0.064	0.080
GFRP Hard		●	●	x	90	70	50	0.010	0.015	0.020	0.025	0.030	0.040	0.050
CFRP		●	●	x	140	120	100	0.016	0.024	0.032	0.040	0.048	0.064	0.080

• Preferred ○ Possible x Not Possible

MA FORDMAX Series CGFR - Profile Milling with 2xD APMX

Recommended Cutting Data · Conditions de coupe recommandées · Empfohlene Schnittdaten · Dati di taglio Raccomandati · Zalecane Parametry

Workpiece Material Group	ISO	Coolant			RWOC (Ae)			End Mill Diameter (mm)						
		Emulsion	Air	MQL	10%	20%	30%	4	6	8	10	12	16	20
								Multiply fz by this factor based on ae. When finishing, use the standard fz per chart below. Only add chip thinning when roughing or semi-finishing.						
					1.67	1.2	1.1							
GFRP Soft	N	•	•	x	100	80	60	0.016	0.024	0.032	0.040	0.048	0.064	0.080
GFRP Hard		•	•	x	90	70	50	0.010	0.015	0.020	0.025	0.030	0.040	0.050
CFRP		•	•	x	140	120	100	0.016	0.024	0.032	0.040	0.048	0.064	0.080

• Preferred ○ Possible x Not Possible

Notes

- Cutting data provided should be considered advisory only. Adjustments may be necessary depending on the application, workpiece rigidity, machine tool, etc.
- The GFRP tool should only be used in precision tool holders with sufficient gripping force.
- Ensure adequate dust extraction is in place when dry machining.

RWOC (ae)	Chip Thickness Compensation Factor
10%	1.67
15%	1.40
20%	1.2
30%	1.1

During profile milling with a radial width of less than 50% of the cutter diameter, the actual chip thickness at the cutting edge is less than the programmed feed per tooth (fz). The accompanying table shows the increase in fz by given radial width percentage to adjust for chip thinning. Multiply your recommended fz by the appropriate feed factor to establish the correct feed rate.



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