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catalogue!

EXPERT TOOLS  
**COMPOSITE**



## EXPERT cutting tools in solid carbide recommended for machining composite materials

Tool material : **SOLID CARBIDE**  
Recommended Coating: **NEO**

Operation	Ref.	Picture	Page
<b>Drilling</b>	<b>300</b>		<b>5</b>
<b>CFRP / GRFP* Milling</b>	<b>9020</b>		<b>6</b>
<b>CFRP / GRFP* Milling</b>	<b>9120</b>		<b>7</b>
<b>Honeycomb Milling</b>	<b>9530</b>		<b>8</b>
<b>CFRP / GRFP* Milling</b>	<b>9630</b>		<b>9</b>



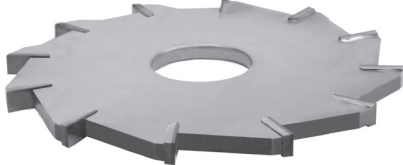



\***CFRP**: Carbon Fiber Reinforced Polymer

\***GRFP**: Glass Fiber Reinforced Polymer

This table presents only one optimal tool for each operation. You will find other tools suitable for composite machining in our full catalogue.

## EXPERT cutting tools in PCD recommended for machining composite materials

Tool material : **POLYCRISTALLINE DIAMOND (PCD)**

Operation	Ref.	Picture	Page
<b>Drilling</b>	4500		11
<b>Milling</b>	4010		13
<b>Saw blades</b>	PCD Slitting saws		Upon request
<b>Threading</b>	45200		14
<b>Engraving</b>	4119-3		15
<b>Custom cutters</b>	Laser sharpening		Upon request

This table presents only one optimal tool for each operation. You will find other tools suitable for composite machining in our full catalogue.

# Index - Composite materials

	Gr.
CFRP + Thermoplastics	b
GFRP + Thermoplastics	c
Honeycomb + Thermoplastics	a
CFRP + Duroplast	c
GFRP + Duroplast	b
Honeycomb + Duroplast	a

**CFRP:** Carbon Fiber Reinforced Polymer

**GFRP:** Glass Fiber Reinforced Polymer

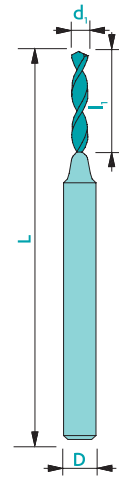
# EXPERT drill for composite materials



300

Material group (see page 4)	a	b	c
Recommended coating	NEO	NEO	NEO
$V_c$ uncoated [m/min]	150	120	100
$V_c$ coated [m/min]	200	150	120
F [mm]	Ø/50	Ø/50	Ø/50

Tolerances  $d_1$ : -0.002/-0.004  
D: h5



Available uncoated or coated

Art. n°	$d_1$	$l_1$	D	L
300d0.50FC	0.50	8	3	38
300d1.00FC	1.00	10	3	38
300d1.50FC	1.50	10	3	38
300d2.00FC	2.00	10	3	38
300d3.00FC	3.00	12	3	38
300d6.00FC	6.00	18	6	51

Other dimensions available upon request



90°

Z2



CARB

## Formulas

$$F = F_z \cdot Z$$

$$V_f = F_z \cdot Z \cdot n$$

$$n = \frac{V_c \cdot 1000}{\pi \cdot d_1}$$

$$V_c = \frac{\pi \cdot d_1 \cdot n}{1000}$$

$$f_z = \frac{V_f}{Z \cdot n}$$

## Caption

F [mm]: Feed per rotation

$F_z$  [mm]: Feed per tooth

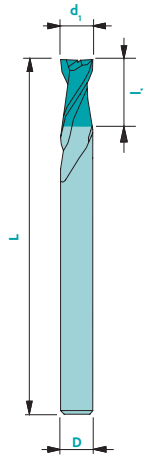
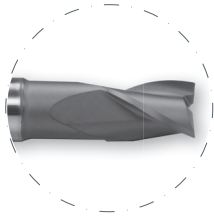
Z: Number of teeth

$V_f$  [mm/min]: Feed speed

n: Spindle speed

# 9020

# EXPERT end mill for composite materials



### Material group (see page 4)

	a	b	c
Recommended coating	NEO	NEO	NEO
$V_c$ uncoated [m/min]	250	150	120
$V_c$ coated [m/min]	300	200	150
$F_z \leq \emptyset 0.50$ [mm]	$\emptyset/100$	$\emptyset/100$	$\emptyset/100$
$F_z > \emptyset 0.50$ [mm]	$\emptyset/70$	$\emptyset/70$	$\emptyset/70$

Available uncoated or coated

Tolerances  $d_1 \leq 1$  mm ▶ +0/-0.01 D: h5  
 $d_1 > 1$  mm ▶ +0/-0.02  
 $d_1 = D$  ▶  $d_1; e8$



Z2-3



CARB



$$ap = 0.25 \cdot d_1$$



$$ae = 0.5 \cdot d_1$$
  
$$ap = 0.5 \cdot d_1$$

Art. n°	$d_1$	$l_1$	D	L	Z
9020d0.50FC	0.5	1	3	38	2
9020d1.00FC	1.0	2	3	38	2
9020d2.00FC	2.0	4	3	38	2
9020d3.00FC	3.0	6	3	38	2
9020d6.00FC	6.0	12	6	51	3

### Formulas

$$F = F_z \cdot Z$$

$$V_f = F_z \cdot Z \cdot n$$

$$n = \frac{V_c \cdot 1000}{\pi \cdot d_1}$$

$$V_c = \frac{\pi \cdot d_1 \cdot n}{1000}$$

$$f_z = \frac{V_f}{Z \cdot n}$$

### Caption

F [mm]: Feed per rotation

$F_z$  [mm]: Feed per tooth

Z: Number of teeth

$V_f$  [mm/min]: Feed speed

n: Spindle speed

# EXPERT end mill with ball end for composite materials

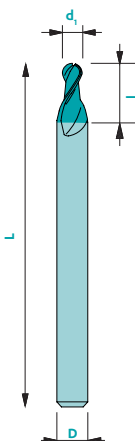


9120

Material group (see page 4)	a	b	c
Recommended coating	NEO	NEO	NEO
$V_c$ uncoated [m/min]	250	150	120
$V_c$ coated [m/min]	300	200	150
$F_z \leq \varnothing 0.50$ [mm]	$\varnothing/100$	$\varnothing/100$	$\varnothing/100$
$F_z > \varnothing 0.50$ [mm]	$\varnothing/70$	$\varnothing/70$	$\varnothing/70$

Tolerance  $d_1 \leq 1$  mm ▶ +0/-0.01  
 $d_1 > 1$  mm ▶ +0/-0.02  
 $d_1 = D$  ▶  $d_1: e8$

$\text{D: h5}$



Available uncoated or coated

Art. n°	$d_1$	$l_1$	D	L	Z
9120d0.50FC	0.5	1	3	38	2
9120d1.00FC	1.0	2	3	38	2
9120d2.00FC	2.0	4	3	38	2
9120d3.00FC	3.0	6	3	38	2
9120d6.00FC	6.0	12	6	51	3



Z2-3



CARB



$$ap = 0.25 \cdot d_1$$



$$ae = 0.5 \cdot d_1$$

## Formulas

$$F = F_z \cdot Z$$

$$V_f = F_z \cdot Z \cdot n$$

$$n = \frac{V_c \cdot 1000}{\pi \cdot d_1}$$

$$V_c = \frac{\pi \cdot d_1 \cdot n}{1000}$$

$$f_z = \frac{V_f}{Z \cdot n}$$

## Caption

F [mm]: Feed per rotation

$F_z$  [mm]: Feed per tooth

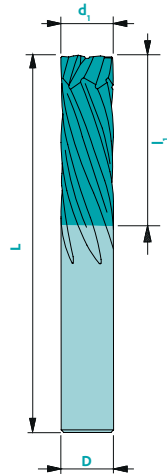
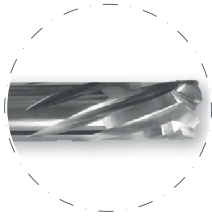
Z: Number of teeth

$V_f$  [mm/min]: Feed speed

n: Spindle speed

9530

# EXPERT end mill with double helix for composite materials



**Material group (see page 4)**

	a	b	c
Recommended coating	NEO	NEO	NEO
$V_c$ uncoated [m/min]	250	150	120
$V_c$ coated [m/min]	300	200	150
$F_z \leq \varnothing 0.50$ [mm]	$\varnothing/100$	$\varnothing/100$	$\varnothing/100$
$F_z > \varnothing 0.50$ [mm]	$\varnothing/70$	$\varnothing/70$	$\varnothing/70$

Available uncoated or coated

Tolerances  $d_1 \leq 1$  mm ▶ +0/-0.01 D: h5  
 $d_1 > 1$  mm ▶ +0/-0.02  
 $d_1 = D$  ▶  $d_1: e8$



Z6



CARB



$$ap = 0.25 \cdot d_1$$



$$ae = 0.5 \cdot d_1$$

$$ap = 0.5 \cdot d_1$$

Art. n°	$d_1$	$l_1$	D	L	Z
9530d6.00FC	6.0	18	6	51	6
9530d8.00FC	8.0	24	8	61	6
9530d10.00FC	10.0	30	10	72	6
9530d12.00FC	12.0	36	12	83	6

**Formulas**

$$F = F_z \cdot Z$$

$$V_f = F_z \cdot Z \cdot n$$

$$n = \frac{V_c \cdot 1000}{\pi \cdot d_1}$$

$$V_c = \frac{\pi \cdot d_1 \cdot n}{1000}$$

$$f_z = \frac{V_f}{Z \cdot n}$$

**Caption**

F [mm]: Feed per rotation

$F_z$  [mm]: Feed per tooth

Z : Number of teeth

$V_f$  [mm/min]: Feed speed

n : Spindle speed

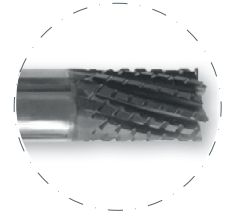
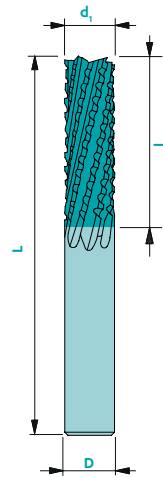


# EXPERT end mill with crossed teeth for composite materials



9630

Material group (see page 4)	a	b	c
Recommended coating	NEO	NEO	NEO
$V_c$ uncoated [m/min]	200	120	100
$V_c$ coated [m/min]	250	150	120
$F_z > \varnothing 0.50$ [mm]	$\varnothing/300$	$\varnothing/300$	$\varnothing/300$



### Tolerances

$d_1 \leq 1 \text{ mm}$  ▶ +0/-0.01  
 $d_1 > 1 \text{ mm}$  ▶ +0/-0.02  
 $d_1$ : e8  
 D: h5

Available uncoated or coated

Art. n°	$d_1$	$L_1$	D	L	Z
9630d3.00FC	3.0	12	3	38	7
9630d4.00FC	4.0	16	4	38	7
9630d6.00FC	6.0	18	6	51	8
9630d8.00FC	8.0	24	8	61	10
9630d10.00FC	10.0	30	10	72	12
9630d12.00FC	12.0	36	12	83	14



Z7-14



CARB



$ap=0.25d_1$



$ae=0.5d_1$   
 $ap=0.5d_1$

### Formulas

$$F = F_z \cdot Z$$

$$V_f = F_z \cdot Z \cdot n$$

$$n = \frac{V_c \cdot 1000}{\pi \cdot d_1}$$

$$V_c = \frac{\pi \cdot d_1 \cdot n}{1000}$$

$$f_z = \frac{V_f}{Z \cdot n}$$

### Caption

F [mm]: Feed per rotation

$F_z$  [mm]: Feed per tooth

Z: Number of teeth

$V_f$  [mm/min]: Feed speed

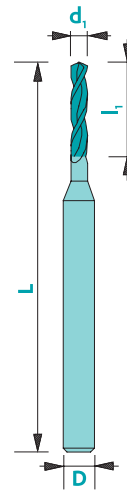
n: Spindle speed



# PCD twist drill - 2 teeth

4500

Material group (see page 4)	a	b	c
V <sub>c</sub> [m/min]	400	400	400
F [mm]	∅/50	∅/50	∅/50



Tolerances  
 $d_1 = +0/-0.013$   
 D: h6

Art. n°	d <sub>1</sub>	l <sub>1</sub>	D	L
4500d0.48	0.48	4.0	3	38
4500d0.49	0.49	4.0	3	38
4500d0.50	0.50	4.0	3	38
4500d0.51	0.51	4.0	3	38
4500d0.52	0.52	4.0	3	38
4500d0.53	0.53	4.0	3	38
4500d0.54	0.54	4.0	3	38
4500d0.55	0.55	4.0	3	38
4500d0.56	0.56	4.0	3	38
4500d0.57	0.57	4.0	3	38
4500d0.58	0.58	4.0	3	38
4500d0.59	0.59	4.0	3	38
4500d0.60	0.60	5.0	3	38
4500d0.61	0.61	5.0	3	38
4500d0.62	0.62	5.0	3	38
4500d0.63	0.63	5.0	3	38
4500d0.64	0.64	5.0	3	38
4500d0.65	0.65	5.0	3	38
4500d0.66	0.66	5.0	3	38
4500d0.67	0.67	5.0	3	38
4500d0.68	0.68	5.0	3	38
4500d0.69	0.69	5.0	3	38
4500d0.70	0.70	5.0	3	38
4500d0.71	0.71	5.0	3	38
4500d0.72	0.72	5.0	3	38
4500d0.73	0.73	5.0	3	38
4500d0.74	0.74	5.0	3	38
4500d0.75	0.75	5.0	3	38
4500d0.76	0.76	5.0	3	38

Art. n°	d <sub>1</sub>	l <sub>1</sub>	D	L
4500d0.77	0.77	5.0	3	38
4500d0.78	0.78	5.0	3	38
4500d0.79	0.79	5.0	3	38
4500d0.80	0.80	6.0	3	38
4500d0.81	0.81	6.0	3	38
4500d0.82	0.82	6.0	3	38
4500d0.83	0.83	6.0	3	38
4500d0.84	0.84	6.0	3	38
4500d0.85	0.85	6.0	3	38
4500d0.86	0.86	6.0	3	38
4500d0.87	0.87	6.0	3	38
4500d0.88	0.88	6.0	3	38
4500d0.89	0.89	6.0	3	38
4500d0.90	0.90	7.0	3	38
4500d0.91	0.91	7.0	3	38
4500d0.92	0.92	7.0	3	38
4500d0.93	0.93	7.0	3	38
4500d0.94	0.94	7.0	3	38
4500d0.95	0.95	7.0	3	38
4500d0.96	0.96	7.0	3	38
4500d0.97	0.97	7.0	3	38
4500d0.98	0.98	7.0	3	38
4500d0.99	0.99	7.0	3	38
4500d1.00	1.00	8.0	3	38
4500d1.01	1.01	8.0	3	38
4500d1.02	1.02	8.0	3	38
4500d1.03	1.03	8.0	3	38
4500d1.04	1.04	8.0	3	38
4500d1.05	1.05	8.0	3	38



Z2



λ  
30°

PCD

## Formulas

$$F = F_z \cdot Z$$

$$V_f = F_z \cdot Z \cdot n$$

$$n = \frac{V_c \cdot 1000}{\pi \cdot d_1}$$

$$V_c = \frac{\pi \cdot d_1 \cdot n}{1000}$$

$$f_z = \frac{V_f}{Z \cdot n}$$

## Caption

F [mm]: Feed per rotation

F<sub>z</sub> [mm]: Feed per tooth

Z: Number of teeth

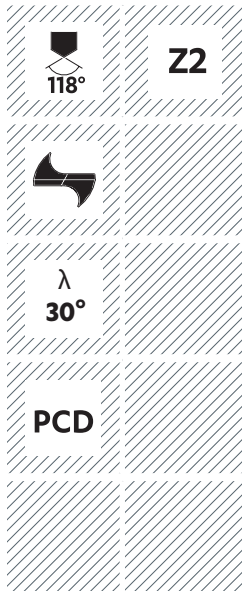
V<sub>f</sub> [mm/min]: Feed speed

n: Spindle speed

**4500**

Continuation

# PCD twist drill - 2 teeth



Art. n°	d <sub>1</sub>	l <sub>1</sub>	D	L
4500d1.06	1.06	8.0	3	38
4500d1.07	1.07	8.0	3	38
4500d1.08	1.08	8.0	3	38
4500d1.09	1.09	8.0	3	38
4500d1.10	1.10	9.0	3	38
4500d1.11	1.11	9.0	3	38
4500d1.12	1.12	9.0	3	38
4500d1.13	1.13	9.0	3	38
4500d1.14	1.14	9.0	3	38
4500d1.15	1.15	9.0	3	38
4500d1.16	1.16	9.0	3	38
4500d1.17	1.17	9.0	3	38
4500d1.18	1.18	9.0	3	38
4500d1.19	1.19	9.0	3	38
4500d1.20	1.20	9.0	3	38
4500d1.21	1.21	9.0	3	38
4500d1.22	1.22	9.0	3	38
4500d1.23	1.23	9.0	3	38
4500d1.24	1.24	9.0	3	38
4500d1.25	1.25	9.0	3	38
4500d1.26	1.26	9.0	3	38
4500d1.27	1.27	9.0	3	38
4500d1.28	1.28	9.0	3	38
4500d1.29	1.29	9.0	3	38
4500d1.30	1.30	9.0	3	38
4500d1.31	1.31	9.0	3	38
4500d1.32	1.32	9.0	3	38
4500d1.33	1.33	9.0	3	38
4500d1.34	1.34	9.0	3	38
4500d1.35	1.35	9.0	3	38
4500d1.36	1.36	9.0	3	38
4500d1.37	1.37	9.0	3	38
4500d1.38	1.38	9.0	3	38
4500d1.39	1.39	9.0	3	38
4500d1.40	1.40	9.0	3	38
4500d1.41	1.41	9.0	3	38
4500d1.42	1.42	9.0	3	38
4500d1.43	1.43	9.0	3	38
4500d1.44	1.44	9.0	3	38
4500d1.45	1.45	9.0	3	38
4500d1.46	1.46	9.0	3	38
4500d1.47	1.47	9.0	3	38
4500d1.48	1.48	9.0	3	38
4500d1.49	1.49	9.0	3	38
4500d1.50	1.50	9.0	3	38

Art. n°	d <sub>1</sub>	l <sub>1</sub>	D	L
4500d1.55	1.55	9.0	3	38
4500d1.60	1.60	9.0	3	38
4500d1.65	1.65	9.0	3	38
4500d1.70	1.70	9.0	3	38
4500d1.75	1.75	9.0	3	38
4500d1.80	1.80	9.0	3	38
4500d1.85	1.85	9.0	3	38
4500d1.90	1.90	9.0	3	38
4500d1.95	1.95	9.0	3	38
4500d2.00	2.00	9.0	3	38
4500d2.05	2.05	9.0	3	38
4500d2.10	2.10	9.0	3	38
4500d2.15	2.15	9.0	3	38
4500d2.20	2.20	9.0	3	38
4500d2.25	2.25	9.0	3	38
4500d2.29	2.29	9.0	3	38
4500d2.30	2.30	9.0	3	38
4500d2.40	2.40	9.0	3	38
4500d2.50	2.50	9.0	3	38

Other dimensions, CVD/CBN available upon request.

# PCD end mill $l_1=1xd_1$

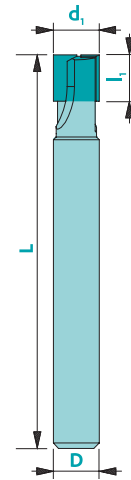
4010

## Material group (see page 4)

	a	b	c
$V_c$ [m/min]	500	500	500
$F_z \leq 0.50$ [mm]	$\varnothing/100$	$\varnothing/100$	$\varnothing/100$
$F_z > 0.50$ [mm]	$\varnothing/70$	$\varnothing/70$	$\varnothing/70$

## Tolerances

$d_1 < 1\text{ mm}$  ▶  $+0/-0.01$      $l_1: +0.2/-0$   
 $d_1 > 1\text{ mm}$  ▶  $+0/-0.02$      $D: h5$



Art. n°	$d_1$	$l_1$	D	L	Z
4010d0.50L38Z1	0.5	0.5	6	38	1
4010d1.00L38Z1	1.0	1.0	6	38	1
4010d1.50L38Z1	1.5	1.5	6	38	1
4010d2.00L38Z1	2.0	2.0	6	38	1
4010d2.50L38Z1	2.5	2.5	6	38	1
4010d3.00L38Z1	3.0	3.0	6	38	1
4010d3.50L38Z1	3.5	3.5	6	38	1
4010d4.00L51Z1	4.0	4.0	6	51	1
4010d4.00L51Z2	4.0	4.0	6	51	2
4010d5.00L51Z2	5.0	5.0	6	51	2
4010d6.00L51Z2	6.0	6.0	6	51	2
4010d7.00L61Z2	7.0	7.0	8	61	2
4010d8.00L61Z2	8.0	8.0	8	61	2
4010d8.00L120Z2	8.0	8.0	8	120	2
4010d10.00L72Z2	10.0	10.0	10	72	2
4010d10.00L120Z2	10.0	10.0	10	120	2
4010d12.00L83Z2	12.0	12.0	12	83	2
4010d12.00L150Z2	12.0	12.0	12	150	2
4010d14.00L83Z2	14.0	14.0	14	83	2
4010d14.00L150Z2	14.0	14.0	14	150	2
4010d16.00L92Z2	16.0	16.0	16	92	2
4010d16.00L180Z2	16.0	16.0	16	180	2
4010d20.00L104Z2	20.0	20.0	20	104	2
4010d20.00L180Z2	20.0	20.0	20	180	2



Z1-2



PCD



$ap=0.15xd_1$



$ae=0.03xd_1$   
 $ap=1xd_1$

## Formulas

$$F = F_z \cdot Z$$

$$V_f = F_z \cdot Z \cdot n$$

$$n = \frac{V_c \cdot 1000}{\pi \cdot d_1}$$

$$V_c = \frac{\pi \cdot d_1 \cdot n}{1000}$$

$$f_z = \frac{V_f}{Z \cdot n}$$

## Caption

F [mm]: Feed per rotation

FZ [mm]: Feed per tooth

Z : Number of teeth

Vf [mm/min]: Feed speed

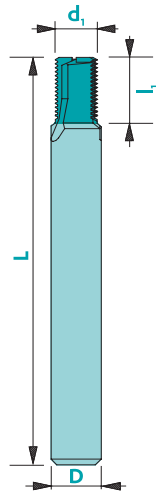
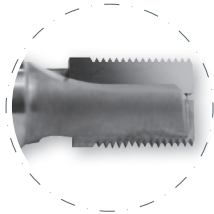
n : Spindle speed

Other dimensions, CVD/CBN available upon request.

# 45200

## PCD thread mill

Internal and external threading



Material group (see page 4)	a	b	c
V <sub>c</sub> [m/min]	400	400	400
F <sub>z</sub>	Ø/300	Ø/300	Ø/300

Tolerances  
 d<sub>1</sub>: +0/-0.1  
 D: h5

### Z1-2



### PCD

Art. n°	Ø nominal	Pitch	d <sub>1</sub>	l <sub>1</sub>	D	L	Z
45200M2.00	M2.00	0.40	1.40	4.0	3	38	1
45200M2.50	M2.50	0.45	1.80	5.0	6	57	1
45200M3.00	M3.00	0.50	2.30	6.0	6	57	1
45200M4.00	M4.00	0.70	3.00	8.0	6	57	2
45200M5.00	M5.00	0.80	3.80	10.0	6	57	2
45200M6.00	M6.00	1.00	4.50	12.0	6	57	2
45200M8.00	M8.00	1.25	5.00	16.0	6	57	2

### Formulas

$$F = F_z \cdot Z$$

$$V_f = F_z \cdot Z \cdot n$$

$$n = \frac{V_c \cdot 1000}{\pi \cdot d_1}$$

$$V_c = \frac{\pi \cdot d_1 \cdot n}{1000}$$

$$f_z = \frac{V_f}{Z \cdot n}$$

### Caption

F [mm]: Feed per rotation

FZ [mm]: Feed per tooth

Z : Number of teeth

Vf [mm/min]: Feed speed

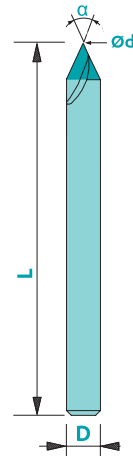
n : Spindle speed

Other dimensions, CVD/CBN available upon request.

# Engraving mill in PCD - 3/4 - flat tip

4119-3

Material group (see page 4)	a	b	c
n [rpm]	40'000	40'000	40'000
Fz↓ [mm]	0.003	0.003	0.003
Fz→ [mm]	∅d <sub>1</sub> /10	∅d <sub>1</sub> /10	∅d <sub>1</sub> /10



Tolerances d<sub>1</sub>: +/- 0.01  
D: h5

Art. n°	α	d <sub>1</sub>	D	L	Art. n°	α	d <sub>1</sub>	D	L
4119-3a40d0.05	40°	0.05	3	33	4119-3a60d0.10	60°	0.10	3	33
4119-3a40d0.08	40°	0.08	3	33	4119-3a70d0.05	70°	0.05	3	33
4119-3a40d0.10	40°	0.10	3	33	4119-3a70d0.08	70°	0.08	3	33
4119-3a50d0.05	50°	0.05	3	33	4119-3a70d0.10	70°	0.10	3	33
4119-3a50d0.10	50°	0.08	3	33	4119-3a90d0.05	90°	0.05	3	33
4119-3a50d0.15	50°	0.10	3	33	4119-3a90d0.08	90°	0.08	3	33
4119-3a60d0.05	60°	0.05	3	33	4119-3a90d0.10	90°	0.10	3	33
4119-3a60d0.08	60°	0.08	3	33					



Z1



PCD

Order  Quotation request

<b>Angle (α):</b> <input type="checkbox"/> By default : 60° <input type="checkbox"/> 30° <input type="checkbox"/> 35° <input type="checkbox"/> 45° <input type="checkbox"/> Other : _____ <input type="checkbox"/> 50° <input type="checkbox"/> 55° <input type="checkbox"/> 90°		<b>Shank Ø :</b> <input type="checkbox"/> By default : D=3 <input type="checkbox"/> Other : D= _____		<b>Order No :</b> _____	
<b>Machined material :</b> _____		<b>Quantity :</b> _____		<b>d<sub>1</sub> (from 0.02 mm) :</b> _____	
<b>Contact person :</b> _____			<b>Company's stamp &amp; date :</b> _____		

## Formulas

$$F = F_z \cdot Z$$

$$V_f = F_z \cdot Z \cdot n$$

$$n = \frac{V_c \cdot 1000}{\pi \cdot d_1}$$

$$V_c = \frac{\pi \cdot d_1 \cdot n}{1000}$$

$$f_z = \frac{V_f}{Z \cdot n}$$

## Caption

F [mm]: Feed per rotation

F<sub>z</sub> [mm]: Feed per tooth

Z: Number of teeth

V<sub>f</sub> [mm/min]: Feed speed

n: Spindle speed

Standard dimensions of the bars : ∅ 3x L 38, ∅ 4x L 38, ∅ 6x L 38, ∅ 6x L 51, ∅ 8x L 61, ∅ 10x L 72, ∅ 12x L 83, ∅ 16x L 92, ∅ 20x L 104

Other dimensions, CVD/CBN available upon request.

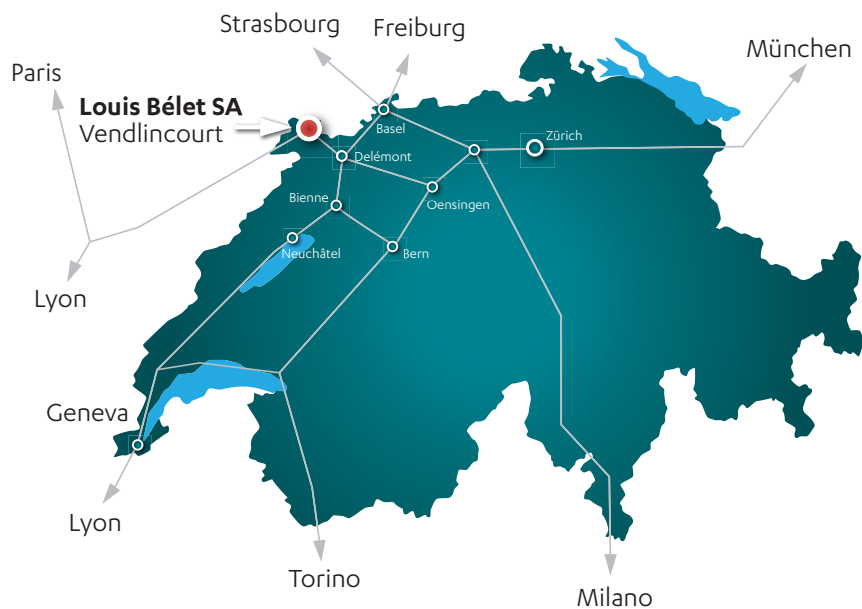


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