

# Special Offer on 54-775 Series

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of equal or lesser value

**Valid 04-01-2023 - 09-30-2023**

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**54775**



**PT**Solutions™

LMT Onsrud introduces a new rougher finisher to add to its extensive line of routing tools – the 54-775 series. The roughing profile reduces lateral pressure while the finishing geometry leaves a smooth edge as it shears the fiber reinforcement. This series is ideal for ramping and plunging. Results can also be achieved through trimming, slotting, or HEM profiling with the 54-775 series.

#### Features and Benefits

- Nanosphere coating for enhanced tool life.
- Center cutting end geometry provides the ability to plunge.
- Unique rough and finish geometry reduces the number of passes within the operation.

#### Applications

- Roughing
- Semi-finishing
- Finishing

#### Usage

- Fiber-reinforced Composite (FRC)



# 54-775 Series Promotion

Part #	Cutting Diameter	LOC	Shank Diameter	Overall Length	Flutes
54-790	1/8	1/4	1/8	2	4
54-792	3/16	9/16	3/16	2	4
54-776	1/4	1/2	1/4	3	4
54-778	1/4	3/4	1/4	3	4
54-780	3/8	3/4	3/8	3	6
54-782	3/8	1 1/8	3/8	3	6
54-783	1/2	1 1/8	1/2	3	6
54-784	1/2	1 1/8	1/2	3	8
54-785	1/2	1 5/8	1/2	4	6
54-786	1/2	1 5/8	1/2	4	8

## 54-775 Cutting Data Recommendations

ISO Grade	Material	Application	Recommended Starting Parameters							
			Rad DOC	Axial DOC	SFM Range	Chip Load Per Tooth				
						SFM Starting	1/8	1/4	3/8	1/2
O	CFRP	Full Slotting	1 x DIA	.5 x DIA	400-800	400	0.0005	0.0005	0.0006	0.0008
		Heavy Profile	.33 x DIA	1.25 x DIA		400	0.0005	0.0008	0.0010	0.0012
		HEM* Profile	.15 x DIA	2 x DIA		400	0.0007	0.0013	0.0014	0.0016
		Finishing	.05 x DIA	2 x DIA		400	0.0005	0.0011	0.0012	0.0014
	GFRP	Full Slotting	1 x DIA	.5 x DIA	275-1100	275	0.0005	0.0010	0.0011	0.0012
		Heavy Profile	.33 x DIA	1.25 x DIA		275	0.0008	0.0014	0.0019	0.0022
		HEM* Profile	.15 x DIA	2 x DIA		275	0.0011	0.0019	0.0023	0.0026
		Finishing	.05 x DIA	2 x DIA		275	0.0009	0.0015	0.0020	0.0024
	Phenolic	Full Slotting	1 x DIA	1 x DIA	325-1300	325	0.0005	0.0005	0.0006	0.0008
		Heavy Profile	.33 x DIA	1.25 x DIA		325	0.0005	0.0008	0.0010	0.0012
		HEM* Profile	.15 x DIA	2 x DIA		325	0.0007	0.0013	0.0014	0.0016
		Finishing	.05 x DIA	2 x DIA		325	0.0005	0.0011	0.0012	0.0014

\*No more than 6 flutes for slotting in G10

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