Stainless Steel

83-300 Series

Cutting stainless steel on a router can be a challenging task due to the high spindle RPM's. Onsrud solved this problem by developing a line of tools which are capable of running at high speeds and providing good tool life. Our cutting geometry also provides an excellent side and bottom finish in a wide variety of stainless grades.

Solid Carbide Double Edge Upcut Spiral

Part Number	CED	CEL	Shank	OAL	List Price
83-305AlTiN	1/8	1/4	1/8	2	$25.50
83-310AlTiN	3/16	3/8	3/16	2 1/2	$35.40
83-315AlTiN	1/4	3/8	1/4	2 1/2	$36.90
83-320AlTiN	3/8	1/2	3/8	3	$52.10

Cutting Parameters

Part Number	RPM	Feedrate	Depth of Cut
83-305AlTiN	18,000	18 IPM	.012
83-310AlTiN	12,000	20 IPM	.020
83-315AlTiN	9,000	25 IPM	.030
83-320AlTiN	6,010	27 IPM	.045

Notes

- Different grades of stainless steel may dramatically affect the performance of the tool.
- Your depth of cut is critical to ensure proper tool performance; too heavy of a depth of cut can cause immediate tool failure.
- Coolant or a mister is required for proper tool performance.
- Do **not** use your dust collector when cutting stainless steel, as it may cause a fire.

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