

# Spiral O Flute Router Bits

For Hard & Soft

Plastics MACHINING



## 63-700 Series Solid Carbide SINGLE EDGE UPCUT SPIRAL O FLUTE

These single edge spiral O flute tools provide a smooth finish in HARD plastics with upward chip removal.

Usage: Acrylic, Nylon, PVC, Polycarbonate

PART #	CED	CEL	SHK DIA	OAL
63-700	1/16	1/4	1/4	2
63-701	1/16	1/4	1/8	2
63-710	1/8	1/4	1/4	2
63-711	1/8	1/4	1/8	2
63-712	1/8	1/2	1/4	2
63-713	1/8	1/2	1/8	2
63-715	5/32	9/16	1/4	2
63-716	3/16	3/8	3/16	2
63-717	3/16	3/8	1/4	2
63-718	3/16	5/8	1/4	2
63-719	3/16	5/8	3/16	2
63-720	7/32	3/4	1/4	2 1/2
63-724	1/4	3/8	1/4	2
63-725	1/4	3/4	1/4	2 1/2
63-726	1/4	1 1/4	1/4	3
63-733	3/8	1 1/8	3/8	3

CED TOLERANCE + .000 -.004

## 63-800 Series Solid Carbide SINGLE EDGE UPCUT SPIRAL O FLUTE

See Series 63-700 for description and usage

METRIC

PART #	CED	CEL	SHK DIA	OAL
63-802	2 mm	8 mm	2 mm	50 mm
63-804	2 mm	8 mm	6 mm	64 mm
63-806	2.5 mm	8 mm	2.5 mm	50 mm
63-808	2.5 mm	8 mm	6 mm	64 mm
63-810	3 mm	8 mm	3 mm	50 mm
63-812	3 mm	8 mm	6 mm	64 mm
63-814	3 mm	12 mm	3 mm	64 mm
63-816	3 mm	12 mm	6 mm	64 mm
63-818	4 mm	8 mm	4 mm	64 mm
63-820	4 mm	12 mm	4 mm	64 mm
63-822	4 mm	20 mm	4 mm	64 mm
63-824	4 mm	20 mm	6 mm	64 mm
63-826	4 mm	30 mm	4 mm	64 mm
63-828	5 mm	16 mm	5 mm	64 mm
63-830	5 mm	16 mm	6 mm	64 mm
63-832	5 mm	30 mm	5 mm	64 mm
63-834	6 mm	8 mm	6 mm	64 mm
63-836	6 mm	12 mm	6 mm	64 mm
63-838	6 mm	20 mm	6 mm	64 mm
63-840	6 mm	30 mm	6 mm	76 mm
63-842	6 mm	38 mm	6 mm	76 mm
63-844	8 mm	25 mm	8 mm	64 mm
63-846	8 mm	38 mm	8 mm	76 mm
63-848	10 mm	30 mm	10 mm	76 mm
63-849	10 mm	35 mm	10 mm	76 mm

## 62-700 Series Solid Carbide SINGLE EDGE DOWNCUT SPIRAL O FLUTE

These single edge spiral O flute tools provide a smooth finish in HARD plastics with downward chip removal

Usage: Acrylic, Nylon, PVC, Polycarbonate

PART #	CED	CEL	SHK DIA	OAL
62-712	1/8	1/2	1/4	2
62-713	1/8	1/2	1/8	2
62-715	5/32	9/16	1/4	2
62-718	3/16	5/8	1/4	2
62-719	3/16	5/8	3/16	2
62-720	7/32	3/4	1/4	2 1/2
62-725	1/4	3/4	1/4	2 1/2
62-726	1/4	1 1/4	1/4	3
62-733	3/8	1 1/8	3/8	3

CED TOLERANCE + .000 -.004

## 62-800 Series Solid Carbide SINGLE EDGE DOWNCUT SPIRAL O FLUTE

See Series 62-700 for description and usage

METRIC

PART #	CED	CEL	SHK DIA	OAL
62-802	2 mm	8 mm	2 mm	50 mm
62-804	2 mm	8 mm	6 mm	64 mm
62-806	2.5 mm	8 mm	2.5 mm	50 mm
62-808	2.5 mm	8 mm	6 mm	64 mm
62-810	3 mm	8 mm	3 mm	50 mm
62-812	3 mm	8 mm	6 mm	64 mm
62-814	3 mm	12 mm	3 mm	64 mm
62-816	3 mm	12 mm	6 mm	64 mm
62-818	4 mm	8 mm	4 mm	64 mm
62-820	4 mm	12 mm	4 mm	64 mm
62-822	4 mm	20 mm	4 mm	64 mm
62-824	4 mm	20 mm	6 mm	64 mm
62-826	4 mm	30 mm	4 mm	64 mm
62-828	5 mm	16 mm	5 mm	64 mm
62-830	5 mm	16 mm	6 mm	64 mm
62-832	5 mm	30 mm	5 mm	64 mm
62-834	6 mm	8 mm	6 mm	64 mm
62-836	6 mm	12 mm	6 mm	64 mm
62-838	6 mm	20 mm	6 mm	64 mm
62-840	6 mm	30 mm	6 mm	76 mm
62-842	6 mm	38 mm	6 mm	76 mm
62-844	8 mm	25 mm	8 mm	64 mm
62-846	8 mm	38 mm	8 mm	76 mm
62-848	10 mm	30 mm	10 mm	76 mm
62-849	10 mm	35 mm	10 mm	76 mm



# Spiral Flute Router Bits

**For Hard & Soft Plastics Machining**



## 63-750 Series Solid Carbide SINGLE EDGE UPCUT SPIRAL O FLUTE

These single edge spiral O flute tools provide a smooth finish in plastics with upward chip removal.

**Usage:** HDPE, HIPS, UHMW, ABS, Polycarbonate, PE, Polystyrene, Polypropylene, Acetal, Acrylic, PET

PART #	CED	CEL	SHK DIA	OAL
63-750	1/16	1/4	1/4	2
63-751	1/16	1/4	1/8	2
63-760	1/8	1/4	1/4	2
63-761	1/8	1/4	1/8	2
63-762	1/8	1/2	1/4	2
63-763	1/8	1/2	1/8	2
63-766	3/16	3/8	3/16	2
63-767	3/16	3/8	1/4	2
63-768	3/16	5/8	1/4	2
63-769	3/16	5/8	3/16	2
63-774	1/4	3/8	1/4	2
63-775	1/4	3/4	1/4	2 1/2
63-776	1/4	1 1/4	1/4	3
63-783	3/8	1 1/8	3/8	3

CED TOLERANCE + .000 -.004

## 62-750 Series Solid Carbide SINGLE EDGE DOWNCUT SPIRAL O FLUTE

These single edge spiral O flute tools provide a smooth finish in plastics with downward chip removal

**Usage:** HDPE, HIPS, UHMW, ABS, Polycarbonate, PE, Polystyrene, Polypropylene, Acetal, Acrylic, PET

PART #	CED	CEL	SHK DIA	OAL
62-762	1/8	1/2	1/4	2
62-763	1/8	1/2	1/8	2
62-768	3/16	5/8	1/4	2
62-769	3/16	5/8	3/16	2
62-775	1/4	3/4	1/4	2 1/2
62-776	1/4	1 1/4	1/4	3
62-783	3/8	1 1/8	3/8	3

CED TOLERANCE + .000 -.004

## 63-850 Series Solid Carbide SINGLE EDGE UPCUT SPIRAL O FLUTE METRIC

See Series 63-750 for description and usage

PART #	CED	CEL	SHK DIA	OAL
63-852	2 mm	8 mm	2 mm	50 mm
63-854	2 mm	8 mm	6 mm	64 mm
63-856	2.5 mm	8 mm	2.5 mm	50 mm
63-858	2.5 mm	8 mm	6 mm	64 mm
63-860	3 mm	8 mm	3 mm	50 mm
63-862	3 mm	8 mm	6 mm	64 mm
63-864	3 mm	12 mm	3 mm	64 mm
63-866	3 mm	12 mm	6 mm	64 mm
63-868	4 mm	8 mm	4 mm	64 mm
63-870	4 mm	12 mm	4 mm	64 mm
63-872	4 mm	20 mm	4 mm	64 mm
63-874	4 mm	20 mm	6 mm	64 mm
63-876	4 mm	30 mm	4 mm	64 mm
63-878	5 mm	16 mm	5 mm	64 mm
63-880	5 mm	16 mm	6 mm	64 mm
63-882	5 mm	30 mm	5 mm	64 mm
63-884	6 mm	8 mm	6 mm	64 mm
63-886	6 mm	12 mm	6 mm	64 mm
63-888	6 mm	20 mm	6 mm	64 mm
63-890	6 mm	30 mm	6 mm	76 mm
63-892	6 mm	38 mm	6 mm	76 mm
63-894	8 mm	25 mm	8 mm	64 mm
63-896	8 mm	38 mm	8 mm	76 mm
63-898	10 mm	30 mm	10 mm	76 mm
63-899	10 mm	35 mm	10 mm	76 mm

CED TOLERANCE + .000 -.004

## 62-850 Series Solid Carbide SINGLE EDGE DOWNCUT SPIRAL O FLUTE METRIC

See Series 62-750 for description and usage

PART #	CED	CEL	SHK DIA	OAL
62-852	2 mm	8 mm	2 mm	50 mm
62-854	2 mm	8 mm	6 mm	64 mm
62-856	2.5 mm	8 mm	2.5 mm	50 mm
62-858	2.5 mm	8 mm	6 mm	64 mm
62-860	3 mm	8 mm	3 mm	50 mm
62-862	3 mm	8 mm	6 mm	64 mm
62-864	3 mm	12 mm	3 mm	64 mm
62-866	3 mm	12 mm	6 mm	64 mm
62-868	4 mm	8 mm	4 mm	64 mm
62-870	4 mm	12 mm	4 mm	64 mm
62-872	4 mm	20 mm	4 mm	64 mm
62-874	4 mm	20 mm	6 mm	64 mm
62-876	4 mm	30 mm	4 mm	64 mm
62-878	5 mm	16 mm	5 mm	64 mm
62-880	5 mm	16 mm	6 mm	64 mm
62-882	5 mm	30 mm	5 mm	64 mm
62-884	6 mm	8 mm	6 mm	64 mm
62-886	6 mm	12 mm	6 mm	64 mm
62-888	6 mm	20 mm	6 mm	64 mm
62-890	6 mm	30 mm	6 mm	76 mm
62-892	6 mm	38 mm	6 mm	76 mm
62-894	8 mm	25 mm	8 mm	64 mm
62-896	8 mm	38 mm	8 mm	76 mm
62-898	10 mm	30 mm	10 mm	76 mm
62-899	10 mm	35 mm	10 mm	76 mm

CED TOLERANCE + .000 -.004

ONSRUD CUTTER  
**Spiral**  **Flute Router Bits**

**For Hard & Soft Plastics Machining**



**52-600 Series Solid Carbide**  
**DOUBLE EDGE UPCUT SPIRAL**

These tools are designed to cut acrylic with a smooth finish and upward chip flow.

**Usage:** Acrylic, Nylon, ABS, PE, Acetal, PET, HDPE, UHMW, Polycarbonate

PART #	CED	CEL	SHK DIA	OAL
52-622	1/4	3/8	1/4	2 1/2
52-624	1/4	3/4	1/4	2 1/2
52-626	6 mm	25 mm	6 mm	64 mm
52-638	3/8	1	3/8	3
52-640	8 mm	25 mm	8 mm	76 mm
52-650	1/2	1 1/8	1/2	3 1/2

CED TOLERANCE +.000 - .004



**57-600 Series Solid Carbide**  
**DOUBLE EDGE DOWNCUT SPIRAL**

These tools are designed to cut acrylic with a smooth finish and downward chip flow.

**Usage:** Acrylic, Nylon, ABS, PE, Acetal, PET, HDPE, UHMW, Polycarbonate

PART #	CED	CEL	SHK DIA	OAL
57-623	1/4	3/8	1/4	2 1/2
57-625	1/4	3/4	1/4	2 1/2
57-627	6 mm	25 mm	6 mm	64 mm
57-637	3/8	1	3/8	3
57-639	8 mm	25 mm	8 mm	76 mm
57-651	1/2	1 1/8	1/2	3 1/2

CED TOLERANCE +.000 - .004

ONSRUD CUTTER  
**Straight**  **Flute Router Bits**

**For Hard & Soft Plastics Machining**



**SINGLE EDGE O**

**66-000 Series Solid Carbide**  
**EDGE ROUNDRING**

These tools are designed for rounding the edge of plastic sheets or parts. They come in both single edge and double edge.

**Usage:** Decorative and Specialty



**SINGLE EDGE SPIRAL O**

**SINGLE EDGE O**

PART #	CED	CEL	SHK DIA	OAL	OPENING	RADIUS	SM CED	TIP TO RAD	PLASTIC SIZE
66-082	1/4	3/8	1/4	2 1/2	5/32	1/8	.195	1/16	1/8
66-083	1/4	3/8	1/4	2 1/2	7/32	3/16	.180	1/16	3/16
66-084	1/4	3/8	1/4	2 1/2	9/32	1/4	.163	1/16	1/4

**SINGLE EDGE SPIRAL O**

66-085	1/4	3/8	1/4	2 1/2	5/32	1/8	.195	1/16	1/8
66-086	1/4	3/8	1/4	2 1/2	7/32	3/16	.180	1/16	3/16
66-087	1/4	3/8	1/4	2 1/2	9/32	1/4	.163	1/16	1/4

**DOUBLE EDGE O**

66-074	6mm	10mm	6mm	64mm	5mm	4mm	4.24mm	1.5mm	4mm
66-076	6mm	10mm	6mm	64mm	7mm	6mm	3.73mm	1.5mm	6mm
66-092	1/4	3/8	1/4	2 1/2	5/32	1/8	.195	1/16	1/8
66-093	1/4	3/8	1/4	2 1/2	7/32	3/16	.180	1/16	3/16
66-094	1/4	3/8	1/4	2 1/2	9/32	1/4	.163	1/16	1/4

**DOUBLE EDGE V**

66-120	3/8	3/8	3/8	2 1/2	5/32	1/8	.320	1/16	1/8
66-121	3/8	3/8	3/8	2 1/2	7/32	3/16	.305	1/16	3/16
66-122	3/8	3/8	3/8	2 1/2	9/32	1/4	.288	1/16	1/4
66-123	3/8	1/2	3/8	2 1/2	13/32	3/8	.255	1/16	3/8
66-160	1/2	3/8	1/2	3	5/32	1/8	.445	1/16	1/8
66-161	1/2	3/8	1/2	3	7/32	3/16	.430	1/16	3/16
66-162	1/2	3/8	1/2	3	9/32	1/4	.413	1/16	1/4
66-163	1/2	5/8	1/2	3	11/32	1/2	.347	1/16	1/2

CED TOLERANCE +.000 -.004



**DOUBLE EDGE O**



**DOUBLE EDGE V**



ONSRUD CUTTER

# Straight Flute Router Bits

For Hard & Soft

# Plastics MACHINING



## 56-600 Series Solid Carbide DOUBLE EDGE O FLUTE STRAIGHT

These tools are designed with free cutting O flute geometry along with a double flute design for smooth finish in soft flexible plastics.

**Usage:** Polycarbonate, ABS, HIPS, PET, PE, Polystyrene, Polypropylene, PVC, Acetal, Acrylic, HDPE, UHMW

PART #	CED	CEL	SHK DIA	OAL
56-610	1/8	5/16	1/4	2
56-612	1/8	1/2	1/4	2
56-614	1/8	5/8	1/4	4
56-616	3/16	3/8	1/4	2
56-618	3/16	5/8	1/4	2
56-620	3/16	1	1/4	4
56-624	1/4	3/8	1/4	2 1/2
56-625	1/4	1	1/4	2 1/2
56-625L	1/4	1	1/4	2 1/2
56-626	1/4	1	1/4	3 1/4
56-628	1/4	1 1/4	1/4	4
56-638	3/8	7/8	3/8	2 1/2
56-639	3/8	1	3/8	4
56-650	1/2	1	1/2	3
56-652	1/2	1	1/2	4
56-654	1/2	1 3/4	1/2	4
56-655	1/2	2 1/8	1/2	6

CED TOLERANCE + .000 -.004

L = Left Rotation Tool

## 61-000 Series Solid Carbide SINGLE EDGE STRAIGHT

These tools are designed to combine the fast free cutting of O flute geometry with the tool life available from solid carbide particularly in small diameters.

**Usage:** ABS, HDPE, PE, PET, Polystyrene, Polypropylene, PVC, Acetal, Acrylic, UHMW, Polycarbonate

PART #	CED	CEL	SHK DIA	OAL
61-041	1/8	5/16	1/4	2
61-042	1/8	1/2	1/4	2
61-042L	1/8	1/2	1/4	2
61-043	1/8	3/8	1/4	4
61-044	1/8	1/2	1/8	2
61-045	1/8	3/8	1/8	3
61-052	5/32	9/16	1/4	2
61-061	3/16	3/8	1/4	2
61-062	3/16	5/8	1/4	2
61-062L	3/16	5/8	1/4	2
61-063*	3/16	1	1/4	4
61-064	3/16	5/8	3/16	2 1/2
61-072	7/32	5/8	1/4	2 1/2
61-081	1/4	3/8	1/4	2 1/2
61-082	1/4	3/4	1/4	2 1/2
61-082L	1/4	3/4	1/4	2 1/2
61-083*	1/4	3/4	1/4	3 1/4
61-083L*	1/4	3/4	1/4	3 1/4
61-085*	1/4	1	1/4	3 1/4
61-084*	1/4	1 1/4	1/4	4
61-121	3/8	5/8	3/8	2 1/2
61-122	3/8	7/8	3/8	2 1/2
61-123*	3/8	1 5/8	3/8	6
61-162	1/2	1	1/2	3
61-164	1/2	1 5/8	1/2	4
61-166	1/2	2 1/8	1/2	6

CED TOLERANCE +.000 - .004

\*THESE TOOLS ARE DESIGNED AND TOLERANCED FOR AIR ROUTERS WITH GUIDE BUSHINGS

## 61-400 Series Solid Carbide SINGLE EDGE STRAIGHT METRIC

See Series 61-000 for description and usage

PART #	CED	CEL	SHK DIA	OAL
61-410	4 mm	16 mm	6 mm	64 mm
61-411	5 mm	20 mm	6 mm	64 mm
61-412	6 mm	25 mm	6 mm	64 mm
61-414	8 mm	25 mm	8 mm	64 mm
61-416	10 mm	35 mm	10 mm	88 mm
61-418	12 mm	35 mm	12 mm	88 mm



**Onsrud  
Cutter<sub>ip</sub>**

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