

# TURBOTEC



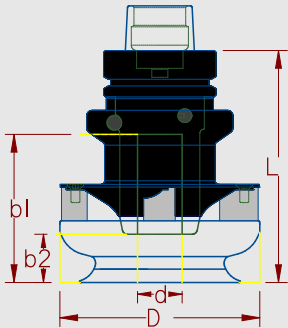
**ROYCE//AYR**  
CUTTING TOOLS

## TURBOTEC ASSEMBLY 112mm HSK63F

Dust extraction unit for CNC nested routers. Will assist existing dust collection system. For best results run system 2-3mm above the material



Max RPM = 18,000



### Imperial

PART #	D		b1	b2	L
PRC-TURBO112-3/8*	112mm	3/8"	57mm	17mm	103.5mm
PRC-TURBO112-1-1/2*	112mm	1/2"	57mm	17mm	103.5mm
PRC-TURBO112-1-5/8	112mm	5/8"	57mm	17mm	103.5mm
PRC-TURBO112-1-3/4*	112mm	3/4"	80mm	27.5mm	126mm
PRC-TURBO112-1-1	112mm	1"	83mm	27.5mm	130mm

### Metric

PART #	D	d	b1	b2	L
PRC-TURBO112-1-12*	112mm	12mm	57mm	17mm	103.5mm
PRC-TURBO112-1-16	112mm	16mm	57mm	17mm	103.5mm
PRC-TURBO112-1-20*	112mm	20mm	80mm	27.5mm	126mm
PRC-TURBO112-1-25	112mm	25mm	83mm	27.5mm	130mm

### Replacement Parts

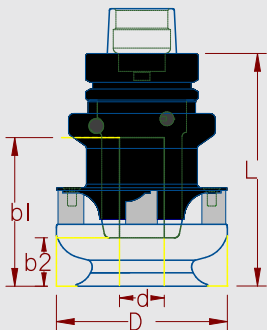
DESCRIPTION	PART #
Replacement Fan	PRC-TURBOTEC.112.FAN

## TURBOTEC ASSEMBLY 80mm HSK63F

Dust extraction unit for CNC nested routers. Will assist existing dust collection system. For best results run system 2-3mm above the material.



Max RPM = 20,000



### Imperial

PART #	D	d	b1	b2	L
PRC-TURBO80-1-3/8*	80mm	3/8"	57mm	17mm	103.5mm
PRC-TURBO80-1-1/2*	80mm	1/2"	57mm	17mm	103.5mm
PRC-TURBO80-1-5/8	80mm	5/8"	57mm	17mm	103.5mm

### Metric

PART #	D	d	b1	b2	L
PRC-TURBO80-1-10	80mm	10mm	57mm	17mm	103.5mm
PRC-TURBO80-1-12	80mm	12mm	57mm	17mm	103.5mm
PRC-TURBO80-1-16	80mm	16mm	57mm	17mm	103.5mm

### Replacement Parts

DESCRIPTION	PART #
Replacement Fan	PRC-TURBOTEC.80.FAN

## TURBOTEC ASSEMBLY 80mm BT30

Dust extraction unit for CNC nested routers. Will existing dust collection system. For best results run system 2-3mm above the material

### Imperial Sizes

PART #	D	d	b1	b2	L
PRC-TURB080-2-1/2	80mm	3/8"	57mm	17mm	98mm
PRC-TURB080-2-5/8	80mm	1/2"	57mm	17mm	98mm
PRC-TURB080-2-3/4	80mm	5/8"	57mm	17mm	98mm

### Metric Sizes

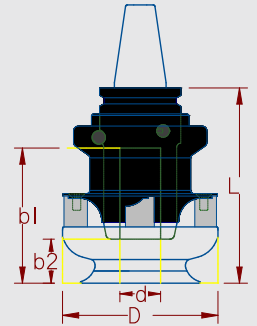
PART #	D	d	b1	b2	L
PRC-TURB080-2-10	80mm	10mm	57mm	17mm	98mm
PRC-TURB080-2-12	80mm	12mm	57mm	17mm	98mm
PRC-TURB080-2-16	80mm	16mm	57mm	17mm	98mm

### Replacement Parts

DESCRIPTION	PART #
Replacement Fan	PRC-TURBOTEC.80.FAN



Max RPM = 20,000



## TOOL LENGTH SELECTION GUIDE

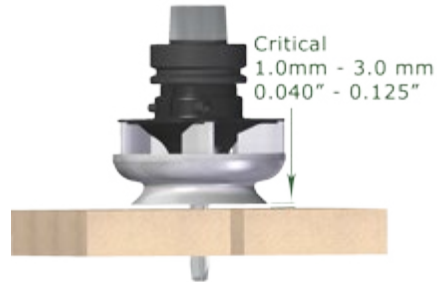
Used to determine the minimum and maximum length of tool that can be used while maintaining 2-3mm distance from fan to material.

		5/8" (16mm) shank and lower		3/4" (20mm) shank and higher	
Depth of Cut		Tool Overall Length		Tool Overall Length	
mm	inch	Min	Max	Min	Max
6.35	1/4"	2"	2-1/2"	2-3/8"	3-1/2"
9.50	3/8"	2"	2-5/8"	2-1/2"	3-1/2"
12.70	1/2"	2-1/8"	2-3/4"	2-5/8"	3-3/4"
15.88	5/8"	2-3/8"	3"	2-3/4"	3-7/8"
19.05	3/4"	2-1/2"	3"	2-7/8"	4"
22.23	7/8"	2-1/2"	3-1/8"	3"	4-1/8"
25.40	1"	2-5/8"	3-1/4"	3"	4-1/4"

# Considerations Before Running TurboTec



Due to large diameter of unit special care must be taken to ensure that collisions won't occur in tool carisol.



For maximum results TurboTec must be run 1-3mm above material being cut



Large amounts of air are moved with the TurboTec, this creates excess noise.



Small or inadequately held parts may be picked up by the TurboTec causing damage to the unit.

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