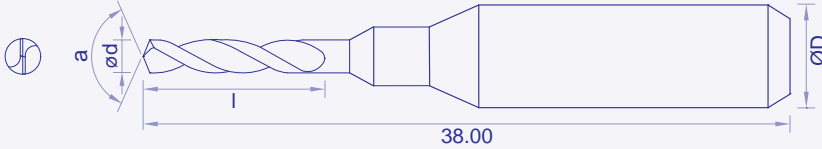




D : Ø 1/8" (3.175 mm) Common Shank

On Request Shank Dia 3mm



d mm	l mm
0.050	0.60
0.060	0.70
0.075	1.00
0.080	1.00
0.090	1.00

On request : Inch sizes / Special dimensions

* : Non stock items / Articles



RECOMMENDED PARAMETERS FOR ROUTING FR4

MATERIAL : FR4 MLB 8-20 layers SPINDLE TYPE : AIR BEARING

DIAMETER mm	CHIP LOAD µm/rev	110,000 MAX.		125,000 MAX.		150,000 MAX.		180,000 MAX.		RETRACT FEED m/min
		SPINDLE SPEED RPM	INFEEED m/min	SPINDLE SPEED RPM	INFEEED m/min	SPINDLE SPEED RPM	INFEEED m/min	SPINDLE SPEED RPM	INFEEED m/min	
0.050	3	110000	0.3	125000	0.4	150000	0.5	180000	0.5	2.0
0.060	3	110000	0.3	125000	0.4	150000	0.5	180000	0.5	2.0
0.075	3	110000	0.3	125000	0.4	150000	0.5	180000	0.5	2.0
0.080	4	110000	0.4	125000	0.5	150000	0.6	180000	0.7	2.0
0.090	4	110000	0.4	125000	0.5	150000	0.6	180000	0.7	2.0

Tabulated parameters provide guidelines which acts as starting points for optimising speeds and feeds at the user's end.

APPLICATION

Drilling of small through holes in multilayer boards.

ADVANTAGES

- Efficient chip removal by optimized geometry.
- Excellent hole wall quality
- High positional accuracy.

PACKING

10 tools per pack.
50 tools per pack.

SCAN TO ORDER



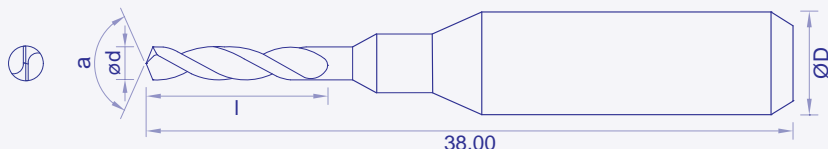
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D : Ø 1/8" (3.175 mm) Common Shank

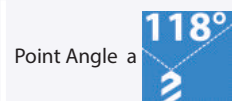
On Request Shank Dia 3mm



d	mm	l	mm
0.100		1.50	
0.110		1.50	
0.120		1.50	
0.130		1.50	
0.140		2.00	
0.150		2.00	
0.160		2.00	
0.170		2.00	
0.175		2.00	
0.180		2.00	
0.190		2.00	

On request : Inch sizes / Special dimensions

* : Non stock items / Articles



RECOMMENDED PARAMETERS FOR ROUTING FR4

MATERIAL : FR4 MLB 8-20 layers SPINDLE TYPE : AIR BEARING

DIAMETER	CHIP LOAD	110,000 MAX.		125,000 MAX.		150,000 MAX.		180,000 MAX.		RETRACT FEED
		SPINDLE SPEED	INFEEED	SPINDLE SPEED	INFEEED	SPINDLE SPEED	INFEEED	SPINDLE SPEED	INFEEED	
mm	µm/rev	RPM	m/min	RPM	m/min	RPM	m/min	RPM	m/min	m/min
0.100	4	110000	0.4	125000	0.5	150000	0.7	180000	0.7	2.0
0.110	5	110000	0.6	125000	0.6	150000	0.8	180000	0.9	2.0
0.120	6	110000	0.7	125000	0.8	150000	0.9	180000	1.1	2.3
0.125	6	110000	0.7	125000	0.8	150000	0.9	180000	1.1	2.5
0.130	7	110000	0.8	125000	0.9	150000	1.1	180000	1.3	2.8
0.140	7	110000	0.8	125000	1.0	150000	1.2	180000	1.3	2.8
0.150	7	110000	0.8	125000	1.0	150000	1.2	180000	1.3	3.0
0.160	8	110000	0.9	125000	1.0	150000	1.2	180000	1.4	3.2
0.170	8	110000	0.9	125000	1.0	150000	1.2	180000	1.4	3.5
0.175	9	110000	1.0	125000	1.1	150000	1.4	180000	1.6	3.5
0.180	9	110000	1.0	125000	1.1	150000	1.4	180000	1.6	3.8
0.190	10	110000	1.1	125000	1.3	150000	1.5	180000	1.8	4.0

Tabulated parameters provide guidelines which acts as starting points for optimising speeds and feeds at the user's end.

APPLICATION

Drilling of small through holes in multilayer boards.

ADVANTAGES

- Efficient chip removal by optimized geometry.
- Excellent hole wall quality.
- High positional accuracy.

PACKING

10 tools per pack.
50 tools per pack.

SCAN TO ORDER



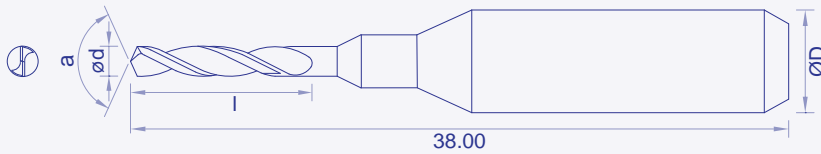
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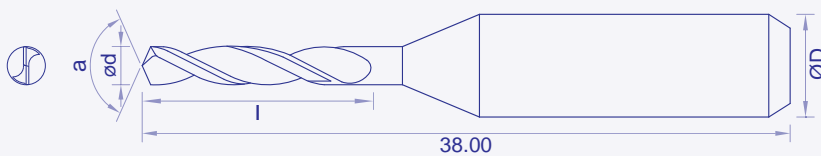


D : Ø 1/8" (3.175 mm) Common Shank

On Request Shank Dia 3mm



Ø 0.20 - Ø 0.50 mm



Ø 0.55 - Ø 1.15mm

d	mm	l	mm
0.20		2.50	3.50
0.25		3.50	4.00
0.30		5.50	6.50
0.35		5.50	7.00
0.40		5.50	7.00
0.45		7.00	-
0.50		7.00	-
0.55		8.50	-
0.60		8.50	-
0.65		8.50	-
0.70		9.50	-
0.75		9.50	-
0.80		9.50	-
0.85		9.50	-
0.90		10.50	-
0.95		10.50	-
1.00 - 1.15		10.50	-

On request : Inch sizes / Special dimensions

* : Non stock items / Articles

Point Angle a
d ≤ Ø 0.25mm

Point Angle a
d ≥ Ø 0.30mm

RECOMMENDED PARAMETERS

MATERIAL : FR4 MLB 8-20 layers SPINDLE TYPE : AIR BEARING

DIAMETER	CHIP LOAD	110,000 MAX.		125,000 MAX.		150,000 MAX.		180,000 MAX.		RETRACT FEED
		SPINDLE SPEED	INFEEED	SPINDLE SPEED	INFEEED	SPINDLE SPEED	INFEEED	SPINDLE SPEED	INFEEED	
mm	µm/rev	RPM	m/min	RPM	m/min	RPM	m/min	RPM	m/min	m/min
0.200	11	110000	1.2	125000	1.3	150000	1.6	180000	2.0	3.0
0.250	13	110000	1.4	125000	1.6	150000	1.9	180000	2.3	3.8
0.300	16	110000	1.8	125000	2.0	150000	2.4	159000	2.5	4.5
0.350	18	110000	2.0	125000	2.2	136000	2.4	136000	2.4	5.3
0.400	20	110000	2.2	119000	2.3	119000	2.3	119000	2.4	6.0
0.450	23	106000	2.4	106000	2.4	106000	2.4	106000	2.4	6.8
0.500	26	95000	2.5	95000	2.4	95000	2.4	95000	2.5	7.5
0.550	32	87000	2.8	87000	2.7	87000	2.7	87000	2.8	11.3
0.600	35	80000	2.8	80000	2.8	80000	2.8	80000	2.8	18.8
0.650	38	73000	2.8	73000	2.7	73000	2.7	73000	2.8	18.8
0.700	41	68000	2.8	68000	2.7	68000	2.7	68000	2.8	18.8
0.750	45	64000	2.9	64000	2.8	64000	2.8	64000	2.9	18.8
0.800	49	60000	2.9	60000	2.9	60000	2.9	60000	2.9	18.8
0.850	53	56000	3.0	56000	2.9	56000	2.9	56000	3.0	18.8
0.900	56	53000	3.0	53000	2.9	53000	2.9	53000	3.0	18.8
1.000	64	48000	3.1	48000	3.0	48000	3.0	48000	3.1	18.8
1.150	68	42000	2.9	42000	2.8	42000	2.8	42000	2.9	18.8

Tabulated parameters provide guidelines which acts as starting points for optimising speeds and feeds at the user's end.

APPLICATION

Drilling of small through holes in multilayer boards.

ADVANTAGES

- Efficient chip removal by optimized geometry.
- Excellent hole wall quality.
- High positional accuracy.

PACKING

10 tools per pack.
50 tools per pack.

SCAN TO ORDER



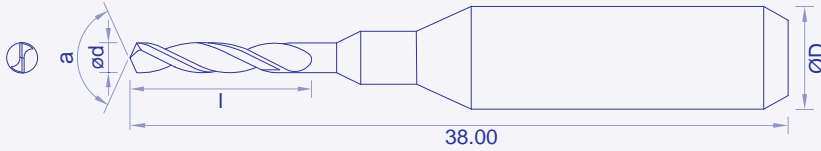
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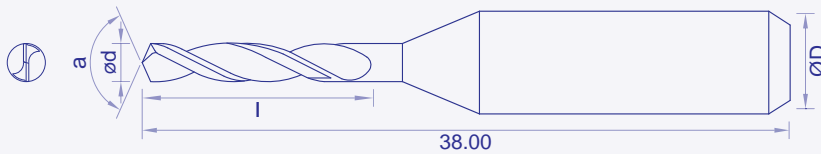


D : Ø 1/8" (3.175 mm) Common Shank

On Request Shank Dia 3mm



Ø 0.20 - Ø 0.50 mm



Ø 0.55 - Ø 0.65mm

d	mm	l			mm
0.20		3.50	-	-	
0.25		3.50	-	-	
0.30		3.50	5.50	7.00	
0.35		3.50	5.50	7.00	
0.40		5.50	7.00	8.50	
0.45		5.50	7.00	8.50	
0.50		7.00	8.50	-	
0.55		7.00	8.50	-	
0.60		7.00	8.50	-	
0.65		7.00	8.50	-	

On request : Inch sizes / Special dimensions

* : Non stock items / Articles

Point Angle a
d ≤ Ø 0.25mm



Point Angle a
d ≥ Ø 0.30mm



RECOMMENDED PARAMETERS

DIAMETER	CHIP LOAD	125,000 MAX.		150,000 MAX.		180,000 MAX.		RETRACT FEED
		SPINDLE SPEED	FEED RATE	SPINDLE SPEED	FEED RATE	SPINDLE SPEED	FEED RATE	
mm	µm/rev	RPM	m/min	RPM	m/min	RPM	m/min	m/min
0.20	11	125000	1.4	150000	1.7	180000	2.0	4
0.25	15	125000	1.9	150000	2.3	180000	2.7	5
0.30	18	125000	2.3	150000	2.7	160000	2.9	6
0.35	21	125000	2.6	137000	2.9	137000	2.9	7
0.40	23	120000	2.8	120000	2.8	120000	2.8	8
0.45	26	107000	2.8	107000	2.8	107000	2.8	9
0.50	30	96000	2.9	96000	2.9	96000	2.9	10
0.55	42	87000	3.7	87000	3.7	87000	3.7	15
0.60	46	80000	3.7	80000	3.7	80000	3.7	20
0.65	50	73000	3.7	73000	3.7	73000	3.7	25

Tabulated parameters provide guidelines which acts as starting points for optimising speeds and feeds at the user's end.

APPLICATION

Drilling of small holes with high positional accuracy.
Drilling of small through holes and via holes.

ADVANTAGES

Excellent hole wall quality.
High Positional accuracy.
Efficient chip removal.

PACKING

10 tools per pack.
50 tools per pack.

SCAN TO ORDER



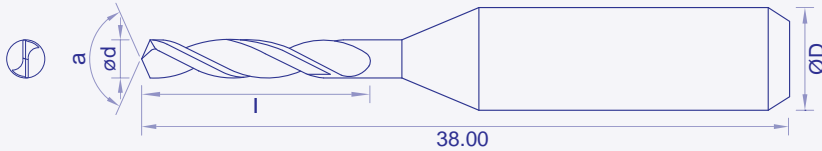
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D : Ø 1/8" (3.175 mm) Common Shank

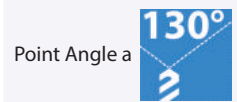
On Request Shank Dia 3mm



d	mm	l	mm
0.70		10.50	
0.75		10.50	
0.80		10.50	
0.85		10.50	
0.90		10.50	
0.95		10.50	
1.00		10.50	
1.05		10.50	
1.10		10.50	
1.15		10.50	
1.20		10.50	
1.25		10.50	
1.30		10.50	
1.35		10.50	
1.40		10.50	
1.45 - 2.30		10.50	
2.35 - 3.175		10.50	

On request : Inch sizes / Special dimensions

* : Non stock items / Articles



RECOMMENDED PARAMETERS

MATERIAL : FR4 MLB 8-20 layers SPINDLE TYPE : AIR BEARING

DIAMETER	SPINDLE SPEED	FEED RATE	CHIP LOAD	RETRACTION
mm	RPM	m/min	µm /rev	m/min
0.70	68000	3.40	50	20
0.75	64000	3.50	54	20
0.80	60000	3.50	59	20
0.85	56000	3.50	63	20
0.90	53000	3.60	68	20
0.95	50000	3.60	72	20
1.00	48000	3.70	77	20
1.10	43000	3.50	81	20
1.20	40000	3.20	81	20
1.30	37000	3.00	81	20
1.40	34000	2.80	81	20
1.45 - 1.80	33000	2.70	81	20
1.85 - 1.90	25000	2.10	81	20
1.95 - 2.00	24000	1.90	81	20
2.05 - 2.10	23000	1.90	81	20
2.15 - 2.20	22000	1.80	81	20
2.25 - 3.175	21000	1.70	81	20

Tabulated parameters provide guidelines which acts as starting points for optimising speeds and feeds at the user's end.

APPLICATION

For all standard PCBs.

ADVANTAGES

- Excellent hole wall quality.
- High positional accuracy.
- Efficient chip removal.

PACKING

10 tools per pack.
50 tools per pack.

SCAN TO ORDER



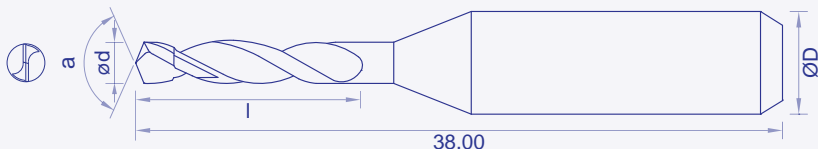
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D : Ø 1/8" (3.175 mm) Common Shank




On Request Shank Dia 3mm



d	mm	l	mm
0.15		2.00	2.50*
0.20		3.50	4.00*
0.25		3.50	4.00*
0.30		5.50	7.00*
0.35		5.50	7.00*
0.40		5.50	7.00*
0.45		7.00	8.50*
0.50 - 0.65		7.00	8.50

On request : Inch sizes / Special dimensions

* : Non stock items / Articles

Undercut  PointAngle a 118° Ø0.15 - Ø0.20  Point Angle a 130° Ø0.25 - Ø0.65 

RECOMMENDED PARAMETERS

MATERIAL : FR4 MLB 8-20 layers SPINDLE TYPE : AIR BEARING

DIAMETER	CHIP LOAD	110,000 MAX.		125,000 MAX.		150,000 MAX.		RETRACT FEED
		SPINDLE SPEED	INFEEED	SPINDLE SPEED	INFEEED	SPINDLE SPEED	INFEEED	
mm	µm/rev	RPM	m/min	RPM	m/min	RPM	m/min	m/min
0.15	6	110000	0.7	125000	0.8	150000	0.9	2.3
0.20	9	110000	1.0	125000	1.1	150000	1.4	3.0
0.25	13	110000	1.4	125000	1.6	150000	2.0	3.8
0.30	16	110000	1.8	125000	2.0	150000	2.4	4.5
0.35	18	110000	2.0	125000	2.3	136000	2.4	5.3
0.40	20	110000	2.2	119000	2.4	119000	2.4	6.0
0.45	23	106000	2.4	106000	2.4	106000	2.4	6.8
0.50	26	95000	2.5	95000	2.5	95000	2.5	7.5
0.55	32	87000	2.8	87000	2.8	87000	2.8	11.3
0.60	35	80000	2.8	80000	2.8	80000	2.8	15.0
0.65	38	73000	2.8	73000	2.8	73000	2.8	18.8

Tabulated parameters provide guidelines which acts as starting points for optimising speeds and feeds at the user's end.

APPLICATION

Drilling of high layer boards / thick panels.

ADVANTAGES

Efficient chip removal by optimized geometry.
Excellent hole wall quality.
High positional accuracy.
Better vibration damping.
Better heat dissipation.

PACKING

10 tools per pack.
50 tools per pack.

SCAN TO ORDER



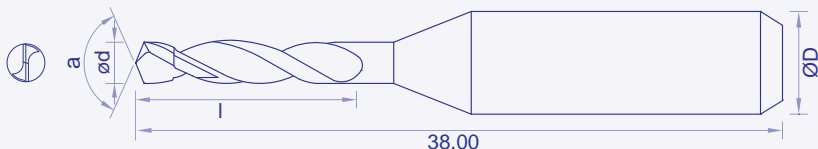
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D : Ø 1/8" (3.175 mm) Common Shank

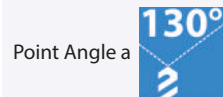
On Request Shank Dia 3mm



d	mm	l	mm
0.15		2.50	3.50
0.20		3.50	4.00
0.25		4.00	4.50
0.30		6.00	7.00
0.35		6.00	7.00
0.40		7.00	8.50
0.45		8.50	-
0.50		8.50	-

On request : Inch sizes / Special dimensions

* : Non stock items / Articles



RECOMMENDED PARAMETERS

MATERIAL : FR4 MLB 8-20 layers SPINDLE TYPE : AIR BEARING

DIAMETER	CHIP LOAD	110,000 MAX.		125,000 MAX.		150,000 MAX.		RETRACT FEED
		SPINDLE SPEED	INFEEED	SPINDLE SPEED	INFEEED	SPINDLE SPEED	INFEEED	
mm	µm/rev	RPM	m/min	RPM	m/min	RPM	m/min	m/min
0.15	6	110000	0.7	125000	0.8	150000	0.9	2.3
0.20	9	110000	1.0	125000	1.1	150000	1.4	3.0
0.25	13	110000	1.4	125000	1.6	150000	2.0	3.8
0.30	16	110000	1.8	125000	2.0	150000	2.4	4.5
0.35	18	110000	2.0	125000	2.3	136000	2.4	5.3
0.40	20	110000	2.2	119000	2.4	119000	2.4	6.0
0.45	23	106000	2.4	106000	2.4	106000	2.4	6.8
0.50	26	95000	2.5	95000	2.5	95000	2.5	7.5

Tabulated parameters provide guidelines which acts as starting points for optimising speeds and feeds at the user's end.

APPLICATION

High performance drilling of multilayer boards.
High demand on tool deviation.
High stack.
BT material / BGA material.

ADVANTAGES

Efficient chip removal by optimized geometry.
Excellent hole wall quality.
High positional accuracy.
Better vibration damping
Better heat dissipation.

PACKING

10 tools per pack.
50 tools per pack.

SCAN TO ORDER



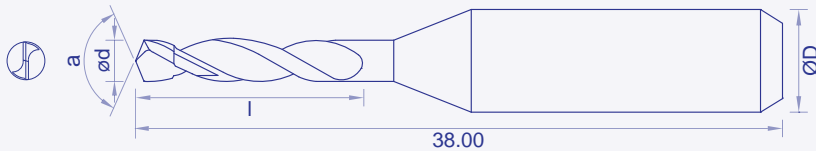
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D : Ø 1/8" (3.175 mm) Common Shank

On Request Shank Dia 3mm



d	mm	l	mm
0.30	4.00	-	
0.35*	4.00	-	
0.40	4.00	-	
0.45	4.00	-	
0.50 - 0.65	5.50	7.00	
0.70 - 1.25	7.00	8.50	
1.30 - 3.175	8.50	-	

On request : Inch sizes / Special dimensions

* : Non stock items / Articles

Undercut



Point Angle a



RECOMMENDED PARAMETERS

MATERIAL : FR4 MLB 8-20 layers SPINDLE TYPE : AIR BEARING CUTTING SPEED : 150 m/min

DIAMETER	CHIP LOAD	125,000 MAX.		RETRACT FEED	DIAMETER	CHIP LOAD	125,000 MAX.		RETRACT FEED
		SPINDLE SPEED	INFEED				SPINDLE SPEED	INFEED	
mm	µm/rev	RPM	m/min	m/min	mm	µm/rev	RPM	m/min	m/min
0.30	5	125000	0.6	5	1.15	55	42000	2.3	25
0.35	7	125000	0.9	5	1.20	56	40000	2.2	25
0.40	8	125000	1.0	7	1.25	58	38000	2.2	25
0.45	9	125000	1.1	7	1.30	59	37000	2.2	25
0.50	10	115000	1.2	10	1.35	61	35000	2.1	25
0.55	17	104000	1.8	10	1.40	62	34000	2.1	25
0.60	20	88000	1.8	15	1.45	63	33000	2.1	25
0.65	27	80000	2.2	25	1.50	64	32000	2.0	25
0.70	33	75000	2.5	25	1.55	66	31000	2.0	25
0.75	35	70000	2.5	25	1.60	67	30000	2.0	25
0.80	38	66000	2.5	25	1.80	72	27000	1.9	25
0.85	40	62000	2.5	25	2.00	80	24000	1.9	25
0.90	43	58000	2.5	25	2.40	80	20000	1.6	25
0.95	47	55000	2.6	25	2.50	80	20000	1.6	25
1.00	50	52000	2.6	25	2.80	70	20000	1.4	25
1.05	52	45000	2.3	25	3.00	60	20000	1.2	25
1.10	53	43000	2.3	25	3.175	60	20000	1.2	25

Tabulated parameters provide guidelines which acts as starting points for optimising speeds and feeds at the user's end.

APPLICATION

For making slots in PCBs.

ADVANTAGES

Better dimensional control.
Reduced deviation.
Reduced breakages.
Improved slot finish.

PACKING

10 tools per pack.
50 tools per pack.

SCAN TO ORDER



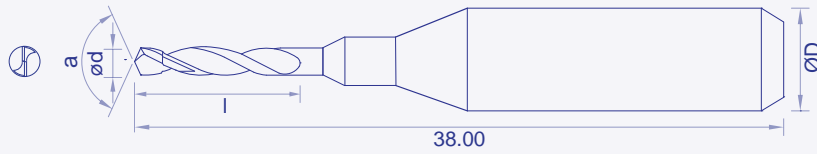
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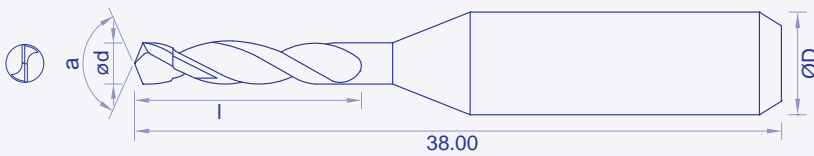


D : Ø 1/8" (3.175 mm) Common Shank

On Request Shank Dia 3mm



Ø 0.20 - Ø 0.65 mm



Ø 0.70 - Ø 2.50 mm

d	mm	l	mm
0.20	3.50	-	-
0.25	3.50	-	-
0.30	5.00*	5.50	7.00*
0.35 - 0.45	5.50	7.00	-
0.50 - 0.65	7.00	8.50	-
0.70 - 2.50	10.00	-	-

On request : Inch sizes / Special dimensions

* : Non stock items / Articles

Undercut



Point Angle a
d ≤ Ø 0.25mm



Point Angle a
d ≥ Ø 0.30mm



RECOMMENDED PARAMETERS

MATERIAL : FR4 MLB 6-20 layers SPINDLE TYPE : AIR BEARING

DIAMETER	CHIP LOAD	110,000 MAX.		125,000 MAX.		150,000 MAX.		RETRACT FEED
		SPINDLE SPEED	INFEEED	SPINDLE SPEED	INFEEED	SPINDLE SPEED	INFEEED	
mm	µm/rev	RPM	m/min	RPM	m/min	RPM	m/min	m/min
0.20	9	110000	1.0	125000	1.1	150000	1.4	3.0
0.25	13	110000	1.4	125000	1.6	150000	2.0	3.8
0.30	16	110000	1.8	125000	2.0	150000	2.4	4.5
0.35	18	110000	2.0	125000	2.3	136000	2.4	5.3
0.40	20	110000	2.2	119000	2.4	119000	2.4	6.0
0.45	23	106000	2.4	106000	2.4	106000	2.4	6.8
0.50	26	95000	2.5	95000	2.5	95000	2.5	7.5
0.55	32	87000	2.8	87000	2.8	87000	2.8	11.3
0.60	35	80000	2.8	80000	2.8	80000	2.8	15.0
0.65	38	73000	2.8	73000	2.8	73000	2.8	18.8
0.70	41	68000	2.8	68000	2.8	68000	2.8	18.8
1.00	64	48000	3.1	48000	3.1	48000	3.1	18.8
1.30 - 1.40	68	37000	2.5	37000	2.5	37000	2.5	18.8
1.45 - 1.60	68	33000	2.2	33000	2.2	33000	2.2	18.8
1.65 - 1.80	68	28000	1.9	28000	1.9	28000	1.9	18.8
1.80 - 2.20	68	25000	1.7	25000	1.7	25000	1.7	18.8
2.25 - 3.175	68	20000	1.4	20000	1.4	20000	1.4	18.8

Tabulated parameters provide guidelines which acts as starting points for optimising speeds and feeds at the user's end.

APPLICATION

Drilling of high quality multilayer boards.

ADVANTAGES

Efficient chip removal by optimized geometry.
Excellent hole wall quality.
High positional accuracy.
Better vibration damping.
Better heat dissipation.

PACKING

10 tools per pack.
50 tools per pack.

SCAN TO ORDER



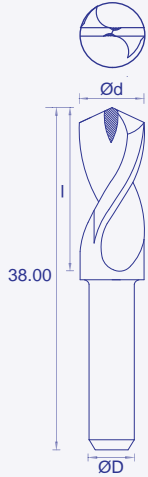
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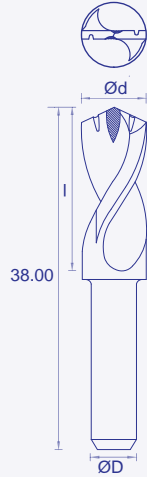


D : Ø 1/8" (3.175 mm) Common Shank

On Request Shank Dia 3mm



High Performance C.B Inverse Drill D532



High Performance Inverse Drill D534



Standard Inverse Drill D835

d	mm	l	mm
3.20 - 3.50		12.00	
3.55 - 4.00		12.00	
4.05 - 4.50		12.00	
4.55 - 5.00		12.00	
5.05 - 5.50		12.00	
5.55 - 6.00		12.00	
6.05 - 6.50		12.00	
6.55 - 7.00		12.00	
7.05 - 7.50		12.00	

On request : Inch sizes / Special dimensions

* : Non stock items / Articles

ADVANTAGES

Prevent bird nesting and copper coiling.
Efficient chip removal.
High positional accuracy.
Higher productivity.

Efficient chip removal.
Higher positional accuracy.
Higher process assurance.
Higher productivity.

Less deviation.
Larger chip removal area.
Higher productivity.



RECOMMENDED PARAMETERS

DIAMETER	SPINDLE SPEED	INFEED		CHIP LOAD		RETRACT FEED			
		mm	RPM	m/min	IPM	µm/rev	mil	m/min	IPM
3.20 - 3.95	20000			0.84	33	35	1.38	20	787
4.00 - 5.35	20000			0.84	33	35	1.38	20	787
5.50 - 6.00	20000			0.92	36	40	1.38	20	787
6.00 - 6.50	20000			0.92	36	40	1.57	20	787
6.55 - 7.50	20000			0.92	36	40	1.57	20	787

Tabulated parameters provide guidelines which acts as starting points for optimising speeds and feeds at the user's end.

APPLICATION

Drilling of mounting and supporting holes in all standard PCBs.
Especially suitable for drilling high Tg boards.

ALSO AVAILABLE

D5341D Diamond coated drill for IMS, Copper, Aluminium, Glass, Ceramic, Quartz & high Tg materials ≥ 200°C.

PACKING

25 tools per pack.
50 tools per pack.

SCAN TO ORDER



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