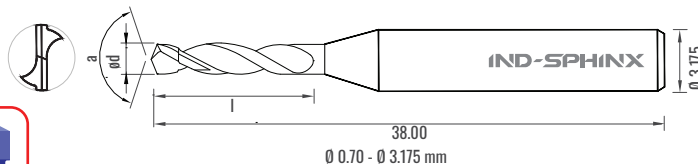
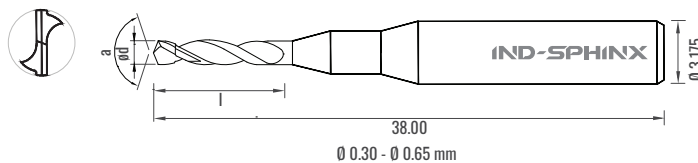


FR4 PTFE Polyimide



Point Angle a



Undercut

APPLICATION

For making slots in PCBs

FEATURES & BENEFITS

- Better dimensional control
- Reduced deviation
- Reduced breakages
- Improved slot finish
- Good slot alignment
- Better vibration damping

PACKING

- 10 tools per pack
- 50 tools per pack

Ø d DIAMETER	I FLUTE LENGTH	
	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 / Special dimensions / Shank 3.00mm

RECOMMENDED PARAMETERS															
Material : FR4 MLB 6-20 layers Spindle Type : Air Bearing Cutting Speed : 150 m/min															
Ød	125,000 Max.			B	Ød	125,000 Max.			B						
	f	N	F			f	N	F							
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						
Ød	Tool Diameter			f	Chip Load		N	Spindle Speed		F	Infeed		B	Retract Feed	

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



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