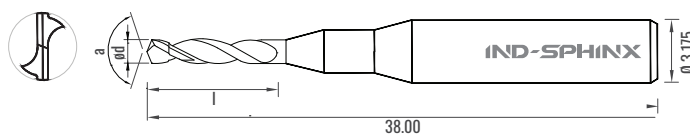




FR4 PTFE Polyimide



Point Angle α
00.15 - 00.20



Point Angle α
00.25 - 00.65



Undercut

APPLICATION

Drilling of multilayer boards

FEATURES & BENEFITS

- 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

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

RECOMMENDED PARAMETERS

Material : FR4 MLB 8-20 layers Spindle Type : Air Bearing

Ød	f	110,000 Max.		125,000 Max.		150,000 Max.		B
		N	F	N	F	N	F	
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

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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