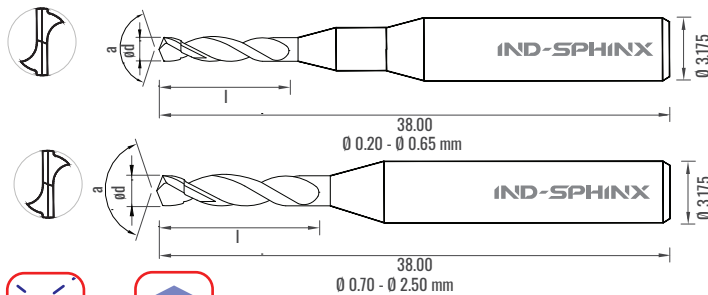


FR4 PTFE Polymide



Point Angle a  
d ≤ 0.025mm



Point Angle a  
d ≥ 0.030mm



Undercut

### APPLICATION

Drilling of high quality 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		
0.20	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 - 3.00	10.00	-	-

On request Inch / Special dimensions / Shank 3.00mm

RECOMMENDED PARAMETERS								
Material : FR4 MLB 6-20 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
0.20	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
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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