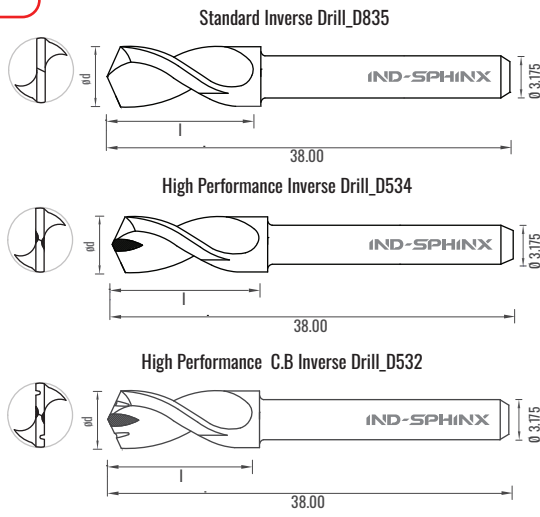


FR4 PTFE Polyimide



**APPLICATION**  
Drilling of high quality multilayer boards

Ø d DIAMETER	l FLUTE LENGTH	PRE DRILLING SIZE mm
3.20 - 3.50	12.00	1.00
3.55 - 4.00	12.00	1.20
4.05 - 4.50	12.00	1.35
4.55 - 5.00	12.00	1.50
5.05 - 5.50	12.00	1.65
5.55 - 6.00	12.00	1.80
6.05 - 6.50	12.00	1.95
6.55 - 7.00	12.00	2.10
7.05 - 7.50	12.00	2.25

On request Inch / Special dimensions / Shank 3.00mm

**FEATURES & BENEFITS**  
Efficient chip removal by optimized geometry  
Excellent hole wall quality  
High positional accuracy  
Better vibration damping  
Better heat dissipation

RECOMMENDED PARAMETERS							
Ød	N	F		f		B	
mm	RPM	m/min	IPM	µm/rev	mil	m/min	IPM
3.20 - 3.95	24000	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
Ød Tool Diameter		N Spindle Speed		F Infeed	f Chip Load	B Retract Feed	

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

**PACKING**  
10 tools per pack  
25 tools per pack



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