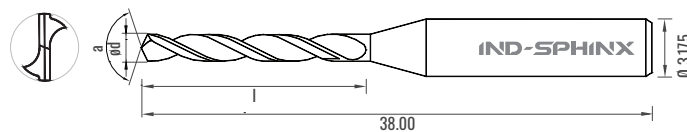




FR4 PTFE Polymide



Point Angle α

APPLICATION

For all standard PCBs

$\varnothing d$ DIAMETER	I FLUTE LENGTH 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 / Special dimensions / Shank 3.00mm

FEATURES & BENEFITS

- Excellent hole wall quality
- High positional accuracy
- Efficient chip removal
- Better vibration damping

RECOMMENDED PARAMETERS				
Material : FR4 MLB 8-20 layers Spindle Type : Air Bearing				
$\varnothing d$	N	F	f	B
mm	RPM	m/min	$\mu\text{m}/\text{rev}$	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
$\varnothing d$ Tool Diameter	N Spindle Speed	F Feed Rate	f Chip Load	B Retraction

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

PACKING

10 tools per pack
50 tools per pack



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