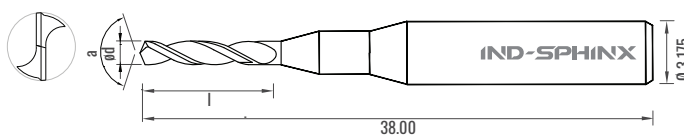




FR4 PTFE Polyimide



Point Angle α
 $d \leq \text{Ø}0.25\text{mm}$



Point Angle α
 $d \geq \text{Ø}0.30\text{mm}$

APPLICATION

Drilling of small holes with high positional accuracy

Drilling of small through holes

FEATURES & BENEFITS

Excellent hole wall quality

High positional accuracy

Efficient chip removal

Better vibration damping

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	3.50	5.50	7.00
0.35	3.50	5.50	7.00
0.40	5.50	7.00	8.50
0.45	5.50	7.00	8.50
0.50	7.00	8.50	-
0.55	7.00	8.50	-
0.60	7.00	8.50	-
0.65	7.00	8.50	-

On request Inch / Special dimensions / Shank 3.00mm

RECOMMENDED PARAMETERS								
Ød	f	125,000 Max.		150,000 Max.		180,000 Max.		B
		N	F	N	F	N	F	
mm	µm/rev	RPM	m/min	RPM	m/min	RPM	m/min	m/min
0.20	11	125000	1.4	150000	1.7	180000	2.0	4
0.25	15	125000	1.9	150000	2.3	180000	2.7	5
0.30	18	125000	2.3	150000	2.7	160000	2.9	6
0.35	21	125000	2.6	137000	2.9	137000	2.9	7
0.40	23	120000	2.8	120000	2.8	120000	2.8	8
0.45	26	107000	2.8	107000	2.8	107000	2.8	9
0.50	30	96000	2.9	96000	2.9	96000	2.9	10
0.55	42	87000	3.7	87000	3.7	87000	3.7	15
0.60	46	80000	3.7	80000	3.7	80000	3.7	20
0.65	50	73000	3.7	73000	3.7	73000	3.7	25

Ød Tool Diameter f Chip Load N Spindle Speed F Feed Rate 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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