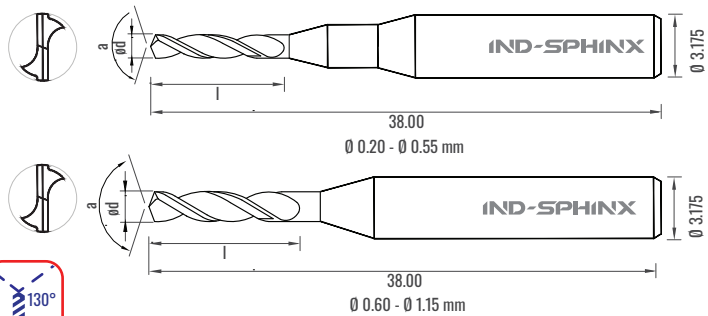


FR4 PTFE Polyimide



Point Angle a  
d ≤ 0.25mm 118°  
Point Angle a  
d ≥ 0.30mm 130°

**APPLICATION**  
Drilling of small through holes in multilayer boards

Ø d DIAMETER	I FLUTE LENGTH	
	mm	
0.20	2.50	3.50
0.25	3.50	4.00
0.30	5.50	6.50
0.35	5.50	7.00
0.40	5.50	7.00
0.45	7.00	-
0.50	7.00	-
0.55	8.50	-
0.60	8.50	-
0.65	8.50	-
0.70	8.50	9.50
0.75	8.50	9.50
0.80	8.50	9.50
0.85	9.50	-
0.90	10.50	-
0.95	10.50	-
1.00 - 1.15	10.50	-

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

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

Ød	f	110,000 Max.		125,000 Max.		150,000 Max.		180,000 Max.		B
		N	F	N	F	N	F	N	F	
mm	µm/rev	RPM	m/min	RPM	m/min	RPM	m/min	RPM	m/min	m/min
0.20	11	110000	1.2	125000	1.3	150000	1.6	180000	2.0	3.0
0.25	13	110000	1.4	125000	1.6	150000	1.9	180000	2.3	3.8
0.30	16	110000	1.8	125000	2.0	150000	2.4	159000	2.5	4.5
0.35	18	110000	2.0	125000	2.2	136000	2.4	136000	2.4	5.3
0.40	20	110000	2.2	119000	2.3	119000	2.3	119000	2.4	6.0
0.45	23	106000	2.4	106000	2.4	106000	2.4	106000	2.4	6.8
0.50	26	95000	2.5	95000	2.4	95000	2.4	95000	2.5	7.5
0.55	32	87000	2.8	87000	2.7	87000	2.7	87000	2.8	11.3
0.60	35	80000	2.8	80000	2.8	80000	2.8	80000	2.8	18.8
0.65	38	73000	2.8	73000	2.7	73000	2.7	73000	2.8	18.8
0.70	41	68000	2.8	68000	2.7	68000	2.7	68000	2.8	18.8
0.75	45	64000	2.9	64000	2.8	64000	2.8	64000	2.9	18.8
0.80	49	60000	2.9	60000	2.9	60000	2.9	60000	2.9	18.8
0.85	53	56000	3.0	56000	2.9	56000	2.9	56000	3.0	18.8
0.90	56	53000	3.0	53000	2.9	53000	2.9	53000	3.0	18.8
1.00	64	48000	3.1	48000	3.0	48000	3.0	48000	3.1	18.8
1.15	68	42000	2.9	42000	2.8	42000	2.8	42000	2.9	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.

**PACKING**  
10 tools per pack  
50 tools per pack



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