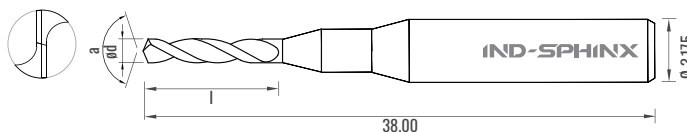




FR4 PTFE Polyimide



Point Angle a

APPLICATION

Drilling of small through holes in multilayer boards

Ø d DIAMETER	l FLUTE LENGTH
0.050	0.60
0.060	0.70
0.075	1.00
0.080	1.00
0.090	1.30

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
0.050	3	110000	0.3	125000	0.4	150000	0.5	180000	0.5	2.0
0.060	3	110000	0.3	125000	0.4	150000	0.5	180000	0.5	2.0
0.075	3	110000	0.3	125000	0.4	150000	0.5	180000	0.5	2.0
0.080	4	110000	0.4	125000	0.5	150000	0.6	180000	0.7	2.0
0.090	4	110000	0.4	125000	0.5	150000	0.6	180000	0.7	2.0

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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