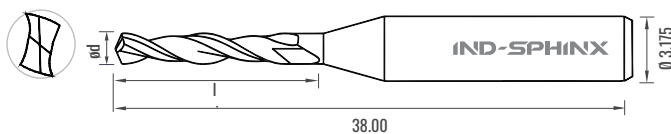




IMS



DLC  
COAT

**APPLICATION**  
Routing of Aluminium  
Routing of IMS / Metal PCB / Heat sink PCBs

Ø d DIAMETER	l FLUTE LENGTH	mm
1.60	8.00	-
2.00	9.00	-
2.40	9.00	-
3.00	10.00	-

On request Inch / Special dimensions / Shank 3.00mm

**FEATURES & BENEFITS**  
Longer tool life  
Better finish  
No pre drilling

RECOMMENDED PARAMETERS FOR ROUTING HIGH Tg WITH CERAMIC FILLERS ( Tg ≥ 170° C )						
Ød	N	f	F x-y	Fz	Routing Depth	Depth in to Backup
mm	RPM	µm/rev	m/min	m/min	m/min	
1.60	40000	5.0 - 7.0	0.2 - 0.3	1.2	2.00	1.0
2.00	32000	9.0 - 15.0	0.3 - 0.5	1.2	2.50	1.0
2.40	28000	14.0 - 21.0	0.4 - 0.6	1.2	3.00	1.0
3.00	23000	26.0 - 35.0	0.6 - 0.8	1.2	3.00	1.0
Ød Tool Diameter	N Spindle Speed	f Chip Load	F x-y Table Feed	Fz Z-Feed Rate		

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



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