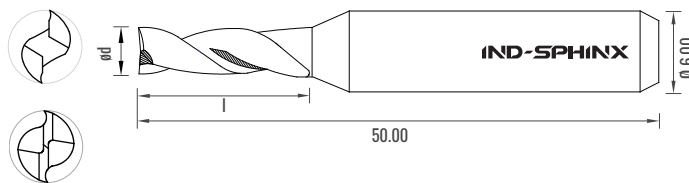


IMS



Safe End
≥ø0.40 - 3.00 mm

Flat End
>ø3.00 - 6.00 mm

APPLICATION

Routing of inner and outer contours of Aluminium and Copper based IMS PCBs

ød DIAMETER	l FLUTE LENGTH	
	mm	
0.40	2.00	-
0.60	2.00	-
0.80	2.00	-
1.00	3.00	-
1.20	3.00	-
1.50	3.00	5.00
1.60	3.00	5.00
1.80	5.00	-
2.00	4.00	6.00
2.40	6.00	-
3.00	6.00	-
4.00	6.00	-
5.00	7.00	-
6.00	8.00	10.00

On request Inch / Special dimensions

FEATURES & BENEFITS

Sharp cutting edge geometry leads to excellent surface finish on components

Wider flute space ease of chip evacuation ensuring tighter dimension control of routed PCBs

Unique shank design leads to less vibration in the routing process and enhances tool life

RECOMMENDED PARAMETERS FOR ROUTING ALUMINIUM and COPPER BASE PCB						
Ød	N	f	F _{x-y}	F _z	Routing Depth	Depth in to Backup
mm	RPM	µm/rev	m/min	m/min	m/min	
0.40	60000 - 80000	2.0	0.20	0.10	0.40	0.20
0.60	60000 - 80000	2.0	0.20	0.10	0.60	0.20
0.80	60000 - 80000	3.0	0.25	0.10	0.80	0.30
1.00	48000 - 58000	5.0	0.30	0.10	1.00	0.40
1.20	40000 - 48000	9.0	0.50	0.20	1.20	0.40
1.50	32000 - 38000	14.0	0.60	0.30	1.50	0.40
1.60	30000 - 36000	18.0	0.70	0.30	1.60	0.40
1.80	26000 - 32000	21.0	0.70	0.30	1.80	0.40
2.00	24000 - 28000	30.0	0.80	0.50	2.00	0.50
2.40	20000 - 24000	36.0	0.90	0.50	2.40	0.50
3.00	18000 - 20000	45.0	0.90	0.50	3.00	0.50
4.00	12000 - 14000	60.0	1.00	0.80	4.00	1.00
5.00	10000 - 12000	75.0	1.00	0.80	5.00	1.00
6.00	8000 - 12000	100.0	1.20	1.00	6.00	1.00

Ød Tool Diameter N Spindle Speed f Chip Load F_{x-y} Table Feed F_z Z-Feed Rate

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

PACKING

Single tool per pack



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