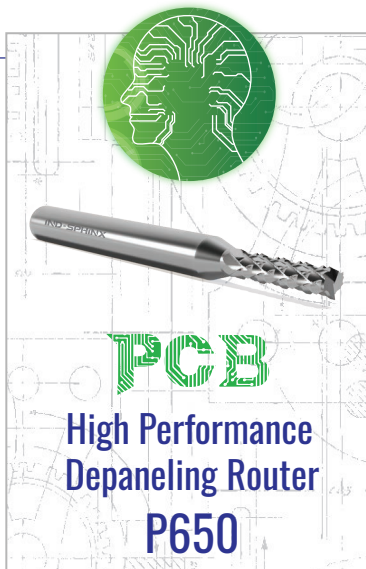
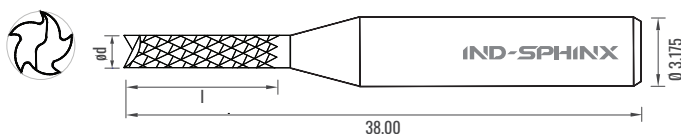




FR4



APPLICATION

For routing / depaneling PCBs in EMS industries

FEATURES & BENEFITS

- For smooth finish
- No loose burr on routed edge
- Close dimensional control
- Run with high feed rates and long tool life
- Good for impact loading

PACKING

- 10 tools per pack
- 50 tools per pack

Ø d DIAMETER	I FLUTE LENGTH
1.40	7.00
1.50	8.00
1.60	8.00
1.80	8.00
2.00	8.00
2.40	10.50
2.50	10.50

On request Inch / Special dimensions / Shank 3.00mm

RECOMMENDED PARAMETERS FOR ROUTING FR4						
Ød mm	N RPM	f		F x-y		
		mm/rev	inch/rev	mm/sec	m/min	in/min
1.40	38000	0.032	1.26	20	1.2	47
1.60	32000	0.050	1.56	26	1.6	62
1.80	30000	0.059	1.56	32	1.9	75
2.00	30000	0.059	1.56	32	1.9	75
2.40	25000	0.059	1.56	32	1.9	75
2.50	24000	0.059	1.56	32	1.9	75
Ød Tool Diameter	N Spindle Speed	f Chip Load		F x-y Table Feed		

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



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