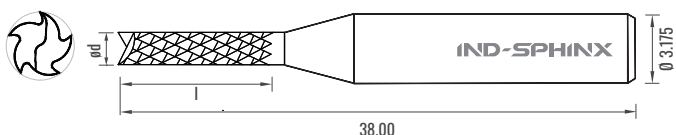


FR4



APPLICATION

For routing of all Standard PCBs with aggressive feed rates on rigid spindles

Ø d DIAMETER	l FLUTE LENGTH		mm
0.50	3.00	-	
0.60	3.00	-	
0.80	3.00	5.00	
0.90	5.00	-	
1.00	5.00	-	
1.10	5.00	7.00	
1.20	5.00	7.00	
1.30	5.00	7.00	
1.40	5.00	-	
1.50	8.00	-	
1.60	8.00	-	
1.70	8.00	-	
1.80	8.00	9.50	
2.00	8.00	9.50	
2.40	8.00	10.50	
2.50	8.00	10.50	

On request Inch / Special dimensions / Shank 3.00mm

FEATURES & BENEFITS

Long life and excellent performance under good vacuum conditions

RECOMMENDED PARAMETERS FOR ROUTING FR4			
Ød	N	F x-y	Fz
mm	RPM	m/min	(Pre Drilled) m/min
0.60	70000	< 0.2	0.2
0.80	70000	< 0.4	0.2
0.90	70000	< 0.4	0.2
1.00	50000	0.4 - 0.6	0.4
1.20	50000	0.5 - 0.7	0.4
1.30	47000	0.5 - 0.7	0.5
1.40	43000	0.5 - 0.7	0.5
1.50	40000	0.6 - 0.8	0.5
1.60	38000	0.6 - 0.8	0.5
1.70	36000	0.7 - 1.0	0.5
1.80	34000	0.7 - 1.0	0.5
2.00	30000	1.0 - 1.4	0.5
2.40	35000	1.4 - 1.6	0.5
Ød Tool Diameter	N Spindle Speed	Fx-y Table Feed	Fz Z-Feed Rate

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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