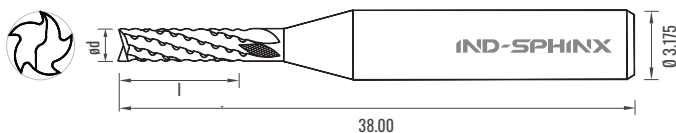


FR4



Ø d DIAMETER	l FLUTE LENGTH		
	mm		
0.40	2.00	-	-
0.50 - 0.60	3.00	4.00	-
0.70	4.00	5.00	-
0.80	5.00	6.00	7.00
0.90	5.00	6.00	7.00
1.00	5.00	7.00	8.50
1.10	5.00	7.00	8.50
1.20	5.00	7.00	8.50
1.30 - 1.40	5.00	7.00	8.50
1.50	8.50	-	-
1.60	8.50	-	-
1.70 - 1.90	8.50	-	-
2.00	9.00	-	-
2.10	9.00	-	-
2.40	9.00	-	-
2.50 - 2.90	9.00	-	-
3.00	9.00	-	-
3.175	9.00	-	-

On request Inch / Special dimensions / Shank 3.00mm

**APPLICATION**

Spiral patterned standard router used for routing outer contours and inner contours of PCBs

Routing of inner slotting in the PCBs

**FEATURES & BENEFITS**

Smooth edge finish

Good dimensional control because of efficient chip evacuation

**RECOMMENDED PARAMETERS FOR ROUTING FR4**

Ød mm	N RPM	F x-y m/min	Fz m/min
0.40	70000	< 0.1	0.2
0.50	70000	< 0.2	0.2
0.60	70000	< 0.3	0.2
0.80	70000	< 0.4	0.2
1.00	70000	0.4 - 0.6	0.4
1.20	58000	0.5 - 0.7	0.4
1.30	54000	0.5 - 0.7	0.5
1.40	50000	0.5 - 0.7	0.5
1.50	46000	0.6 - 0.8	0.5
1.60	43000	0.6 - 0.8	0.5
1.70	41000	0.7 - 1.0	0.5
1.80	39000	0.7 - 1.0	0.5
2.00	35000	1.0 - 1.4	0.5
2.40	29000	1.0 - 1.4	0.5
2.50	28000	1.0 - 1.4	0.5
3.00	23000	1.0 - 1.3	0.5
3.175	22000	1.0 - 1.3	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



QUALITY • PRECISION • CONSISTENCY



PEOPLE

[www.indspinx.com](http://www.indspinx.com)  
[customerfocus@indspinx.com](mailto:customerfocus@indspinx.com)