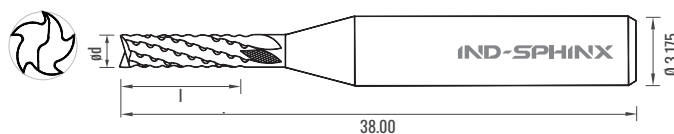


FR4



APPLICATION

Spiral patterned special router used for routing outer contours and inner contours PCBs

Routing of inner slotting in the PCBs

FEATURES & BENEFITS

Smooth edge finish

Good dimensional control because of efficient chip evacuation

PACKING

10 tools per pack
50 tools per pack

Ø d DIAMETER	l FLUTE LENGTH	mm
0.40	2.50	-
0.50	3.00	-
0.60	3.00	-
0.80	5.00	-
0.90	5.00	-
1.00	5.00	-
1.10	5.00	-
1.20	5.00	7.00
1.30 / 1.40	5.00	-
1.50	6.00	-
1.60	7.50	-
1.80	7.50	-
2.00	7.50	-
2.40	8.50	-
2.50	8.50	-
3.00	8.50	-
3.175	8.50	-

On request Inch / Special dimensions / Shank 3.00mm

RECOMMENDED PARAMETERS FOR ROUTING FR4				
Ød	N	F _{x-y}	F _z	
			Without Pre-Drilling	With Drilling
mm	RPM	m/min		
0.40	70000	< 0.2	0.2	0.4
0.50	70000	< 0.3	0.2	0.4
0.60	70000	< 0.3	0.2	0.4
0.70	70000	0.3 - 0.4	0.2	0.4
0.80	70000	0.3 - 0.4	0.2	0.4
0.90	70000	0.3 - 0.4	0.2	0.4
1.00	70000	0.4 - 0.6	0.2	0.4
1.20	58000	0.5 - 0.7	0.4	0.8
1.30	54000	0.5 - 0.7	0.4	0.8
1.40	50000	0.5 - 0.7	0.4	0.8
1.50	46000	0.6 - 0.8	0.5	1.0
1.60	43000	0.6 - 0.8	0.5	1.0
1.70	41000	0.7 - 1.0	0.5	1.0
1.80	39000	0.7 - 1.0	0.5	1.0
2.00	35000	1.0 - 1.4	0.5	1.2
2.40	29000	1.0 - 1.4	0.5	1.2
2.50	28000	1.0 - 1.4	0.5	1.4
3.00	24000	0.8 - 1.2	0.5	1.4
3.175	23000	0.8 - 1.2	0.5	1.4
Ød Tool Diameter	N Spindle Speed	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.



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www.indspinx.com
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