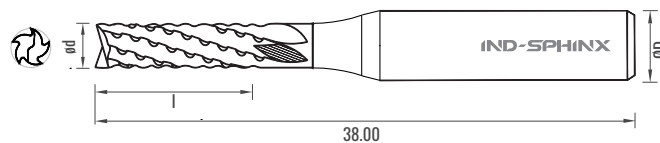


FR4



**APPLICATION**

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

Routing of inner slotting in the PCBs

Ø d DIAMETER	l FLUTE LENGTH		mm
1.10	6.50	-	
1.20	6.00 *	7.00	
1.30	7.00	-	
1.40	7.00	8.50	
1.50	7.50	8.50	
1.60	7.50 *	8.50	
1.70	7.50	8.50	
1.80	7.50 *	8.50	
1.90	7.50	8.50	
2.00	7.50	9.00	10.00 *
2.10	9.00	-	
2.20	9.00	-	
2.30	9.00	-	
2.40	9.00	10.50	
2.50	9.00	10.50	
3.00	10.00	-	
3.175	10.00	-	

\* : Non stock items / Articles

On request : Inch / Special dimensions / Shank 3.00mm

**FEATURES & BENEFITS**

Smooth edge finish

Good dimensional control because of robust design

Long tool life

High feed

RECOMMENDED PARAMETERS FOR ROUTING HIGH Tg WITH CERAMIC FILLERS ( Tg ≥ 170° C )			
Ød	N	F x-y	Fz (Pre Drilled)
mm	RPM	m/min	m/min
0.40	115000	< 0.1	0.6
0.50	115000	< 0.2	0.6
0.60	96000	< 0.3	0.6
0.80	70000	< 0.4	1.0
1.00	57000	0.4 - 0.6	1.0
1.10	48000	0.50	1.5
1.20	48000	0.50	1.5
1.30	48000	0.50	1.5
1.40	40000	0.50	1.5
1.50	38000	0.60	2.0
1.60	36000	0.70	2.0
1.70	36000	0.70	2.0
1.80	32000	0.80	2.0
1.90	32000	0.80	2.0
2.00	29000	1.00	2.0
2.10	29000	1.00	2.0
2.20	29000	1.00	2.0
2.30	24000	1.10	2.0
2.40	24000	1.10	2.0
2.50	22900	1.10	2.0
3.00	19000	1.00	2.0
3.175	18000	1.00	2.0
Ød Tool Diameter	N Spindle Speed	f Chip Load	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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