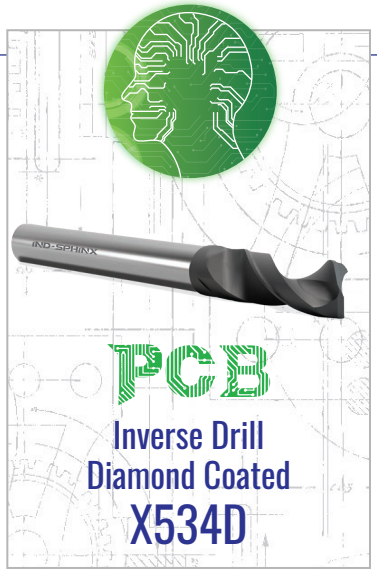
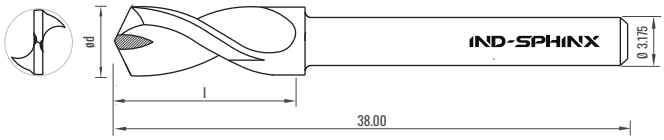


FR4 High Tg ≥170 | FR4 Ceramic Fillers | Ceramic Filled PTFE | IMS PCB Ceramic Layer | FR4 Normal Tg



Diamond Coated

APPLICATION

Drilling of IMS PCBs and laminates with ceramic fillers

High Tg material ≥ 170°C

Also Suitable for Drilling in
- Glass
- Quartz
- Green stage ceramics
  Al_2O_3, SiC, ZrO_2, AlN

ød DIAMETER	l FLUTE LENGTH mm
3.20	12.00
3.25	12.00
3.30	12.00
3.35 - 3.95	12.00
4.00 - 4.95	12.00
5.00 - 6.20	12.00
6.25 - 6.50	12.00

On request Inch / Special dimensions / Shank 3.00mm

FEATURES & BENEFITS

High feed drilling hence high productivity

Improved tool life ~ 5-20X

High dimensional accuracy

High Hardness ~ 10000 HV

RECOMMENDED PARAMETERS

Ød mm	High Tg with Ceramic Fillers (Tg ≥ 170° C) f µm/rev	N RPM	F m/min	B m/min	IMS PCBs Aluminium f µm/rev	N RPM	F m/min	B m/m
3.20 - 3.95	35	20000	0.7	15.0	40	25000	1.0	10.0
4.00 - 4.95	30	20000	0.6	15.0	32	25000	0.8	10.0
5.00 - 5.95	25	20000	0.5	15.0	24	25000	0.8	10.0
6.00 - 6.50	20	20000	0.4	15.0	20	25000	0.5	10.0

ød Tool Diameter f Chip Load N Spindle Speed F Infeed B Retract Feed

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

PACKING

25 tools per pack

50 tools per pack

REMARKS

- For laminate with ceramic dielectric, reduce RPM by 15% for IMS PCBs.
- For Copper IMS PCB reduce RPM by ~ 20% and feed rate by 25% from above IMS PCBs parameters.
- Recommended to use MQL with coolants like Ethanol or oil emulsion for improved performance and dimensional control.
- Control collet runout below 10 microns and vibration.
- Please visit our website for cutting parameter for other materials.

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