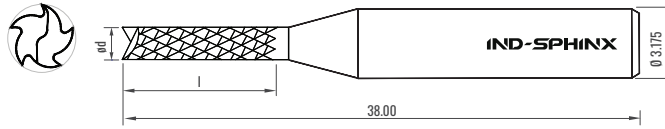


- IMS
PCB
Ceramic
Layer
- FR4
High Tg
≥170
- FR4
Ceramic
Fillers
- Halogen
Free
Laminates
- FR4
Normal Tg



- Up
Cut
- Fishtail
- Diamond
Cut



APPLICATION

Routing of inner and outer contours

Depaneling of assembled PCBs

Suitable for Halogen free,
High Tg material ≥ 170°C
and laminates with fillers

ød DIAMETER	I FLUTE LENGTH		mm
1.20	5.00	7.00	
1.30	5.00	7.00	
1.40	5.00	7.00	
1.50	7.50	-	
1.60	7.50	8.50 *	
1.80	8.50	-	
2.00	9.00	-	
2.30	9.00	-	
2.40	9.00	-	
2.50	9.00	-	
2.55	10.00	-	
3.00	10.00	-	
3.175	10.00	-	

* : Non stock items / Articles

On request Inch / Special dimensions / Shank 3.00mm

FEATURES & BENEFITS

High hardness - 10000 HV

Extreme wear resistance

High heat conductance

Reduce friction - smooth chip flow

High dimensional accuracy-
improved process capability

RECOMMENDED PARAMETERS FOR ROUTING HIGH Tg WITH CERAMIC FILLERS (Tg ≥ 170° C)						
Ød	N	f	F x-y	Fz	Routing Depth	Depth
mm	RPM	µm/rev	m/min	(Pre Drilled) m/min	m/min	in to Backup
1.20	48000	11.0	0.50	1.5	3.20	1.1
1.30	48000	11.0	0.50	1.5	3.20	1.1
1.40	38000	16.0	0.60	2.0	4.80	1.1
1.50	38000	16.0	0.60	2.0	4.80	1.1
1.60	36000	20.0	0.70	2.0	4.80	1.1
1.80	32000	26.0	0.80	2.0	4.80	1.1
2.00	29000	35.0	1.00	2.0	4.80	1.5
2.30	24000	45.0	1.10	2.0	4.80	1.5
2.40	24000	45.0	1.10	2.0	4.80	1.5
2.50	22900	48.0	1.10	2.0	4.80	1.5
2.55	22900	48.0	1.10	2.0	4.80	1.5
3.00	19000	52.0	1.00	2.0	4.80	1.5
3.175	18000	55.0	1.00	2.0	4.80	1.5

ød Tool Diameter N Spindle Speed f Chip Load F x-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

Single tool per pack
10 tools per pack
50 tools per pack

REMARKS

- Entry point should be pre drilled.
- Backup board should be pre routed.
- Ensure vacuum pressure ≥ 80 mbar.



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