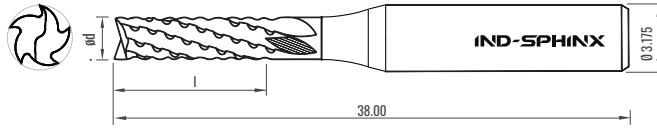


- IMS PCB Ceramic Layer
- FR4 High Tg >170
- FR4 Ceramic Fillers
- Halogen Free Laminates
- FR4 Normal Tg



- Up Cut
- Fishtail
- Chip Breaker



APPLICATION

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

Routing of inner slotting in the PCBs

Depaneling of assembled 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	8.50	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	-	

On request Inch / Special dimensions / Shank 3.00mm

* : Non stock items / Articles

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	F x-y	Fz (Pre Drilled)	Routing Depth	Depth in to Backup
mm	RPM	µm/rev	m/min	m/min	m/min	
1.10	48000	11.0	0.50	1.5	3.20	1.1
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	40000	11.0	0.50	1.5	3.20	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
1.70	36000	20.0	0.70	2.0	4.80	1.1
1.80	32000	26.0	0.80	2.0	4.80	1.1
1.90	32000	26.0	0.80	2.0	4.80	1.1
2.00	29000	35.0	1.00	2.0	4.80	1.5
2.10	29000	35.0	1.00	2.0	4.80	1.5
2.20	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
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

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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