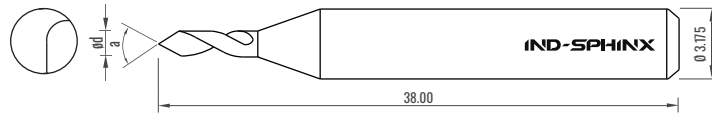


- IMS
PCB
Ceramic
Layer
- FR4
High Tg
≥170
- FR4
Ceramic
Fillers
- Halogen
Free
Laminates
- FR4
Normal Tg



APPLICATION

Suitable for scoring and chamfering in IMS PCB's, High Tg material and laminate with fillers

Ø d DIAMETER	a POINT ANGLE	mm
2.00	30°	
2.00	45°	
2.00	60°	
2.00	82°	
2.00	90°	
2.40	60°	
2.40	90°	
3.175	90°	

On request Inch / Special dimensions / Shank 3.00mm / Other point angles

FEATURES & BENEFITS

- Improved tool life
- High dimensional accuracy
- High Hardness

PARAMETER RECOMMENDED FOR SCORING OF IMS, HALOGEN-FREE MATERIAL AND LAMINATES WITH FILLERS					
a	Routing Depth	Groove Width	N	F x-y	
[°]	mm	mm	RPM	m/min	
30°	0.30	0.20	40-50000	0.8-1.2	0.3
30°	0.80	0.50	50-60000	0.4-0.8	0.2
45°	0.40	0.35	40-50000	1.0-1.5	0.5
45°	1.00	0.85	50-60000	0.5-1.0	0.3
60°	0.40	0.45	40-50000	1.2-1.8	0.5
60°	1.00	1.15	50-60000	0.8-1.3	0.3
90°	0.40	0.80	40-50000	1.5-2.0	0.5
90°	1.00	2.00	50-60000	1.0-1.5	0.3
a Point Angle		N Spindle Speed		F x-y Table Feed	

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

- For Copper IMS PCB reduce RPM by 15% and reduce feed rate by 25%.
- Use entry material ≥ 0.80mm thickness.
- Recommended to use MQL with coolants like Ethanol or oil emulsion for improved performance and dimensional control.
- Control collet runout and vibration.



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