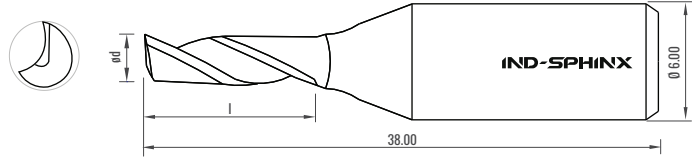


- IMS
PCB
Ceramic
Layer
- FR4
Normal Tg
- FR4
High Tg
≥170
- FR4
Ceramic
Fillers
- Halogen
Free
Laminates



APPLICATION

Routing of inner and outer contours of IMS PCB's e.g Aluminium, Copper.

ød DIAMETER	l FLUTE LENGTH	
	mm	
2.00	5.00	7.00
2.40	5.00	-
3.00	5.00	8.00
4.00	6.00	-
5.00	7.00	-
6.00	8.00	-

On request : Inch / Special dimensions / Shank 3.00mm

FEATURES & BENEFITS

High dimensional accuracy and process capabilities can be achieved to high resistance to wear

High feed rate 3-4 times than uncoated router are possible

Longer life upto 10-12 times

RECOMMENDED PARAMETERS FOR ROUTING ALUMINIUM IMS PCB						
ød	N	f	F _{x-y}	F _z (Pre Drilled)	Routing Depth	Depth in to Backup
mm	RPM	µm/rev	m/min	m/min	m/min	
2.00	24000 - 28000	30.0	0.80	0.5	2.00	0.5
2.40	20000 - 24000	36.0	0.80	0.5	2.40	0.5
3.00	18000 - 20000	45.0	0.90	0.5	3.00	0.5
4.00	12000 - 14000	60.0	1.00	0.8	4.00	1.0
5.00	10000 - 12000	75.0	1.00	0.8	5.00	1.0
6.00	9000 - 11000	100.0	1.20	1.0	6.00	1.0
ød Tool Diameter	N Spindle Speed	f Chip Load	F _{x-y} Table Feed	F _z 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

REMARKS

- For Copper IMS PCB reduce RPM by ~ 15% and reduce feed rate by ~ 25%.
- Reduce feed rate 25% in case of depth routing.
- 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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