

Recommended Parameters - Depanelizing PCB's

Tool Recommendations: 1180, 1200, 1700, 1760

Cutting Speed: 650 - 985 Feet/Minute

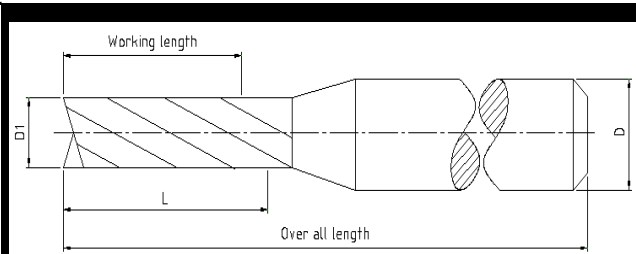
Router Size		Spindle Speed	Chip Load		X/Y Feed Rate		Plunge Rate		Backup Penetration	
mm	Diam.		um	inch	mm/s	in/min	m/min	inch/min	mm	inch
1.00	.0394	50,000	12	.0005	10	23	1.0	39	.40	.015
1.00	.0394	60,000	17	.0007	17	40	1.0	39	.40	.015
1.50	.0591	42,000	23	.001	16	37	1.5	59	.60	.024
1.50	.0591	60,000	30	.0012	30	70	1.5	59	.60	.024
2.00	.0787	32,000	48	.0019	25	59	2.0	78	.80	.031
2.00	.0787	48,000	62	.0025	50	118	2.0	78	.80	.031
2.40	.0945	27,000	55	.0022	25	59	2.0	78	.90	.035
2.40	.0945	40,000	75	.003	50	118	2.0	78	.90	.035

General Recommendations:

- Reflects panel thicknesses < .063"
- The router types and parameters printed in **bold** are preferred
- For Tg>200 degrees C or laminates with fillers, the parameters printed in **bold** have to be reduced:
 - Spindle Speed:10%, Feed Rate - 30%.
- GCT Router type 1760 is downcut is preferred when using conical pins as a tool holder without clamping
- For High Tg material or laminates with fillers, the parameters in bold have to be reduced:
- Vertical offset for "tool level check" function = min panel thickness + .008"
- Clean and maintain collet and vacuum system according to manufacturer's specifications

Router Specifications:

Over-All-Length	1.503" -.012"
Flute Length	Specified Length (L) +/- .008"
Working Length	<.85 X Specified Length (L)
Nominal Diameter	D1 +.0004"/-.0008"
Shank Diameter	.1250" -.00005"/-.0003"



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