

Recommended Parameters: Drilling laminates with ceramic filler

Tool Recommendations: 1638, 1640, 1835,1534

RO 4xxx / 4003, Arlon 25x, Isola IS620

Cutting Speed: 400 Feet/Minute

200,000 RPM Spindles

Router Size		Spindle Speed	Chip Load		Feed Rate		Retract Rate	
mm	Diameter		um	inch	m/min	in/min	m/min	in/min
.30	.0118	125,000	10	.0004	1.3	51	6.0	250
.35	.0138	109,000	15	.0006	1.6	63	7.0	300
.40	.0157	96,000	18	.0007	1.7	67	8.0	300
.45	.0177	85,000	20	.0008	1.7	67	9.0	350
.50	.0197	76,000	22	.0009	1.7	67	10.0	400
.55	.0217	69,000	25	.0010	1.7	67	12.0	500
.60	.0236	64,000	28	.0011	1.8	71	15.0	600
.65	.0256	59,000	31	.0012	1.8	71	15.0	600
.70	.0276	54,000	34	.0013	1.8	71	15.0	600
.75	.0295	51,000	37	.0015	1.9	75	15.0	600
.80	.0315	48,000	40	.0016	1.9	75	15.0	600
.85	.0335	45,000	43	.0017	1.9	75	15.0	600
.90	.0354	42,000	46	.0018	1.9	75	15.0	600
.95	.0374	40,000	49	.0019	1.9	75	15.0	600
1.00	.0394	38,000	51	.0020	1.9	75	15.0	600
1.05	.0413	36,000	53	.0021	1.9	75	15.0	600
1.10	.0433	34,000	56	.0022	1.9	75	15.0	600
1.15	.0453	33,000	56	.0022	1.9	75	15.0	600
1.20	.0472	32,000	56	.0022	1.8	71	15.0	600
1.25	.0492	31,000	56	.0022	1.7	71	15.0	600
1.30	.0512	29,000	56	.0022	1.6	63	15.0	600
1.35	.0531	28,000	56	.0022	1.6	63	15.0	600
1.40	.0551	27,000	56	.0022	1.5	59	15.0	600
1.45 - 1.60	.0571 - .0630	25,000	56	.0022	1.4	55	15.0	600
1.65 - 1.80	.0650 - .0709	23,000	56	.0022	1.3	51	15.0	600
1.85 - 2.00	.0728 - .0787	20,000	56	.0022	1.1	43	15.0	600
2.05 - 2.30	.0807 - .0906	20,000	50	.0020	1.0	39	15.0	600
2.35 - 2.60	.0925 - .1024	20,000	50	.0020	1.0	39	15.0	600
2.65 - 2.90	.1043 - .1142	20,000	50	.0020	1.0	39	15.0	600
2.95 - 3.15	.1161 - .1240	20,000	50	.0020	1.0	39	15.0	600
3.175 - 3.95	.1250 - .1555	20,000	35	.0014	0.7	28	10.0	400
4.00 - 4.95	.1575 - .1949	20,000	30	.0012	0.6	24	10.0	400
5.00 - 5.95	.1969 - .2343	20,000	25	.0010	0.5	20	10.0	400
6.00 - 6.40	.2362 - .2520	20,000	20	.0008	0.4	16	10.0	400

General Recommendations:

- Use an entry material
- Melamine coated back-up material is preferred.
- For drill diameter >4.50mm, pilot 15% of the final diameter
- Maximum pressure foot pressure recommended



we are diamond

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