

# Recommended Parameters:

## Routing laminates with fillers & Halogen Free

**Tool Recommendations: 1700 & 1200**

**IS400 / IS420 /R-1566/ R-1755 Tg <185° C**

Cutting Speed: 600 Feet / Minute

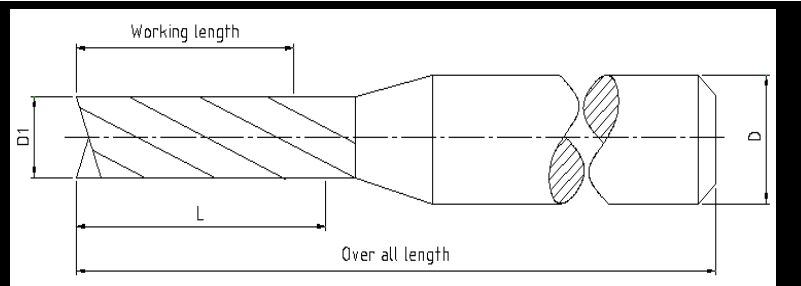
Router Size		Spindle Speed	Chip Load		X/Y Feed Rate		Plunge Rate		Rout Depth		Backup Penetration	
mm	Diameter		um	inch	m/min	in/min	m/min	in/min	mm	inch	mm	inch
.50	.0197	115,000	2	.0001	.23	9	0.6	24	1.2	.047	.40	.016
.60	.0236	96,000	3	.0001	0.3	12	0.6	24	1.5	.059	.40	.016
.80	.0315	71,000	6	.0002	0.4	16	1.0	39	3.2	.126	.60	.024
1.00	.0394	57,000	8	.0003	0.5	20	1.5	59	3.2	.126	.80	.032
1.20	.0472	48,000	11	.0004	0.5	20	1.5	59	3.2	.126	1.1	.043
1.50	.0591	38,000	16	.0006	0.6	24	2.0	79	4.8	.189	1.1	.043
1.60	.0630	36,000	20	.0008	0.7	28	2.0	79	4.8	.189	1.1	.043
1.80	.0709	32,000	26	.0011	0.8	32	2.0	79	4.8	.189	1.1	.043
2.00	.0787	29,000	35	.0014	1.0	39	2.0	79	4.8	.189	1.5	.059
2.40	.0945	24,000	45	.0018	1.1	43	2.0	79	4.8	.189	1.5	.059

### General Recommendations:

- Pre-drilling of plunge points
- Pre-rout back up material
- Clean and maintain collet and vacuum system according to manufacturer's specifications
- Follow the GCT checklist for mechanical routing of PCB's.

### Router Specifications:

Over-All-Length	1.503" $\pm$ .012"
Flute Length	Specified Length (L) $\pm$ 0.2mm
Working Length	<.85 X Specified Length (L)
Nominal Diameter	D1 $\pm$ .0004"/ $\pm$ .0008"
Shank Diameter	.1250" $\pm$ .00005/ $\pm$ .0003"



we are diamond

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**Subject to technical changes**



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