

# Recommended Parameters:

## Routing FR4

**Tool Recommendations: 1180, 1200 & 1700**

Cutting Speed: 590-660 Feet/Minute 60K Max

**60,000 RPM Spindles**

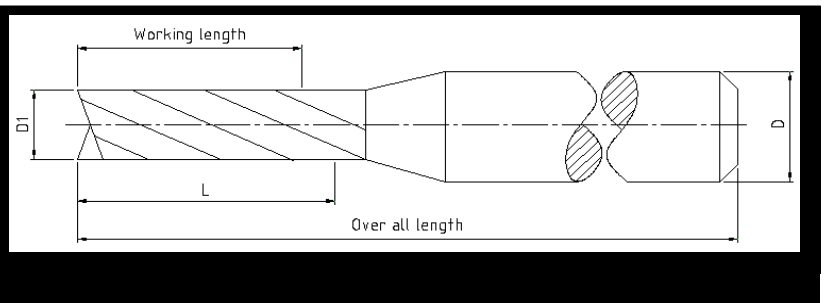
Router Size		Spindle Speed	Chip Load		X/Y Feed Rate		Pre Drilled Plunge Rate		No Predrilled Plunge		Max Stack		Backup Penetration	
mm	Diam.		um	inch	m/m	in/min	m/min	in/min	m/min	in/min	mm	inch	mm	inch
.80	.0315	60,000	5	.0002	0.3	12	1.0	39	0.3	12	3.2	.126	0.6	.024
.90	.0354	60,000	6	.0002	0.3	12	1.0	39	0.4	16	3.2	.126	0.6	.024
1.00	.0394	57,000	7	.0003	0.4	16	2.0	79	0.5	20	4.8	.189	0.8	.032
1.10	.0433	55,000	8	.0003	0.4	16	2.0	79	0.5	20	4.8	.189	0.8	.032
1.20	.0472	52,000	10	.0004	0.5	20	2.0	79	0.6	24	4.8	.189	1.1	.043
1.30	.0512	48,000	11	.0004	0.5	20	2.0	79	0.6	24	4.8	.189	1.1	.043
1.40	.0551	44,000	13	.0005	0.6	24	2.0	79	0.7	28	4.8	.189	1.1	.043
1.50	.0591	41,000	15	.0006	0.6	24	2.0	79	0.8	32	4.8	.189	1.1	.043
1.60	.0630	38,000	18	.0007	0.7	28	3.0	118	0.9	35	4.8	.189	1.1	.043
1.70	.0669	35,000	20	.0008	0.7	28	3.0	118	1.0	39	4.8	.189	1.1	.043
1.80	.0709	33,000	24	.0010	0.8	32	3.0	118	1.0	39	4.8	.189	1.1	.043
1.90	.0748	31,000	29	.0011	0.9	35	3.0	118	1.0	39	4.8	.189	1.1	.043
2.00	.0787	29,000	35	.0014	1.0	39	3.0	118	1.0	39	6.4	.252	1.5	.059
2.40	.0945	24,000	41	.0016	1.0	39	4.0	158	1.0	39	6.4	.252	1.5	.059
2.50	.0984	23,000	43	.0017	1.0	39	4.0	158	1.0	39	6.4	.252	1.5	.059
3.00	.1181	19,000	44	.0017	0.8	32	4.0	158	1.0	39	6.4	.252	1.5	.059
3.175	.1250	18,000	45	.0018	0.8	32	4.0	158	1.0	39	6.4	.252	1.5	.059

### General Recommendations:

- Pre-drilled plunge points are recommended
- Clean and maintain collet and vacuum system according to manufacturer's specifications

### Router Specifications:

Over-All-Length	1.503" $\pm$ .012"
Flute Length	Specified Length (L) $\pm$ .008"
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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