

Recommended Parameters:

Routing FR4

Tool Recommendations: 1180, 1200, 1700

Cutting Speed: 720 Feet/Minute 80K max

80,000 RPM Spindles

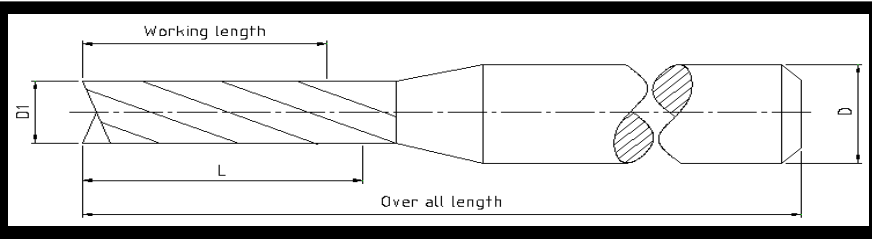
Router Size		Spindle Speed	Chip Load		X/Y Feed Rate		Predrilled Plunge		No Predrilled Plunge		Max Stack		Backup Penetration	
mm	Diam.		um	inch	m/m	in/min	m/min	in/min	m/min	in/min	mm	inch	mm	inch
.80	.0315	80,000	4	.0001	0.3	12	1.0	39	-	-	3.2	.126	0.6	.024
.90	.0354	78,000	5	.0002	0.4	16	1.0	39	-	-	3.2	.126	0.6	.024
1.00	.0394	70,000	6	.0002	0.4	16	2.0	79	0.5	20	4.8	.189	0.8	.032
1.10	.0433	64,000	7	.0002	0.4	16	2.0	79	0.5	20	4.8	.189	0.8	.032
1.20	.0472	58,000	8	.0003	0.5	20	2.0	79	0.6	24	4.8	.189	1.1	.043
1.30	.0512	54,000	9	.0004	0.5	20	2.0	79	0.6	24	4.8	.189	1.1	.043
1.40	.0551	50,000	12	.0005	0.6	24	2.0	79	0.7	28	4.8	.189	1.1	.043
1.50	.0591	47,000	13	.0005	0.6	24	2.0	79	0.8	32	4.8	.189	1.1	.043
1.60	.0630	44,000	16	.0008	0.7	28	2.0	79	0.9	35	4.8	.189	1.1	.043
1.70	.0669	41,000	20	.0009	0.8	32	2.0	79	1.0	39	4.8	.189	1.1	.043
1.80	.0709	39,000	23	.0009	0.9	35	2.0	79	1.0	39	4.8	.189	1.1	.043
1.90	.0748	37,000	27	.0011	1.0	39	2.0	79	1.0	39	4.8	.189	1.1	.043
2.00	.0787	35,000	34	.0014	1.2	47	2.0	79	1.0	39	6.4	.252	1.5	.059
2.40	.0945	29,000	44	.0017	1.3	51	4.0	158	1.0	39	6.4	.252	1.5	.059
2.50	.0984	28,000	46	.0018	1.3	51	4.0	158	1.0	39	6.4	.252	1.5	.059
3.00	.1181	23,000	52	.0020	1.2	47	4.0	158	1.0	39	6.4	.252	1.5	.059
3.175	.1250	22,000	54	.0021	1.2	47	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" -.012"
Flute Length	Specified Length (L) +/- .008"
Working Length	<.85 X Specified Length (L)
Nominal Diameter	D1 +.0004"/-.0008"
Shank Diameter	.1250" -.00005"/-.0003"



we are diamond

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