

# Routing Parameter Overview:

Material Type	Cutting Speed in Feet Per Min	Feed rate % Comparison to FR 4	Router Type	GCT Recommendations
FR 4 Profiling	Please refer to Parameters_FR 4_60K & Parameters_FR 4_80K		1180 1200 1700	GCT's Diamond Coated Chip Breaker and Diamond Cut router designs.
FR 4 Internal Cut	590 - 720	60	1800 1200 1700	
FR 4 Depth Control Routing	590 - 720	60	1322 1328	
FR 4 Halogen Free FR 4 Tg 150° - 180° C IS 400 / 420 /1755C	Please Refer to Parameters Routing Laminates with Fillers & Halogen Free		1700	GCT Diamond Coated fine cut chip breaker router design
Laminates with ceramic fillers high TgHF Laminates RO 4350 / 4004 / 4403 Arlon 25N 25 FR	Please refer to Parameters Routing Laminates w/ Ceramic Fillers		1750	GCT diamond coated router with extra fine spiral cut and MicroSpeed X coating
IMS PCB (aluminum & copper& brass)	Please to refer Parameters Routing IMS		1322 1328 5422	2 flute end mill with Diamond Coating and flat end cut and CC ALUSPEED® coated
Scoring of PCB	Please refer to "Parameter Scoring"		138x	GCT's Diamond Coated Chamfering Cutter
Depanelizing of PCB's	Please refer to Parameters_Depanelizing		1700 1180 1200 1760	GCT's Diamond Coated Chip Breaker and Diamond Cut router designs.



we are diamond

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