

Recommended Parameters - Routing IMS, Aluminum/Copper/Brass

Tool Recommendations: 1322/ 1328 / 5422

Cutting Speed 650 - 825 Feet/Minute

125,000 RPM Spindles

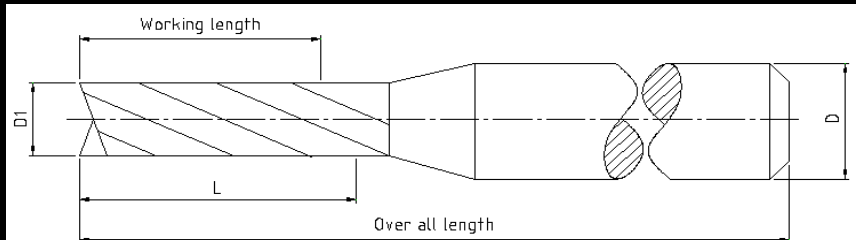
Router Size		Spindle Speed	Chip Load		X/Y Feed Rate		Z Plunge Rate				Routing Depth		Backup Penetration	
mm	Diam.		um/1	inch	m/min.	in/min	mm/min	in/min	1328 mm/min	1328 in/min	mm	inch	mm	inch
0.6	.0236	106000	2	.00008	0.2	8	0.5	.020	-	-	0.6	.024	.30	.011
0.8	.0315	84000	3	.00012	0.25	10	0.8	.031	-	-	0.8	.031	.30	.012
1.00	.0394	66000	5	.0002	0.3	12	0.8	.031	-	-	1.0	.040	.40	.015
1.20	.0472	56000	9	.0004	0.5	20	0.8	.031	-	-	1.2	.047	.40	.015
1.50	.0591	44000	15	.0006	0.6	23	1.0	.039	0.3	.011	1.5	.059	.40	.015
1.60	.0630	42000	17	.0007	0.7	28	1.0	.039	0.3	.011	1.6	.063	.40	.015
1.80	.0709	38000	22	.0009	0.8	31	1.0	.039	0.4	.015	1.8	.071	.40	.015
2.00	.0787	33000	30	.0012	1.0	39	1.2	.047	0.5	.020	2.0	.079	.50	.020
2.40	.0945	28000	43	.0017	1.0	39	1.2	.047	0.5	.020	2.4	.095	.50	.020
3.00	.1181	22000	55	.0022	1.0	39	1.2	.047	0.5	.020	3.0	.118	.50	.020

General recommendations:

- Predrilling the entry positions with the same drill diameter is required.
- Use an entry material (e.g. phenolic paper/melamine, approx. .020" thick)
- For depth routing reduce the feed rate by approximately 25%.
- If ceramic dielectric, reduce speed and feed rate by approximately 20%.
- For router type 5422 reduce feed rate to approximately 30%.
- Maximum pressure with drill style pressure foot is recommended
- Use lubrication when possible
- Routing in 2 passes with diameter compensation improves edge quality and dimension
- Follow the GCT check list for mechanical routing of PCB's

Router Specifications:

Over-All-Length	1.503" -.012"
Flute Length	Specified Length (L) +/- .008"
Working Length	<.80 X Specified Length (L)
Nominal Diameter	D1 +.0006"/-.0006"
	.1250" -.0016"
Shank Diameter	.1250" -.00005"/-.0003"



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