

Recommended Parameters:

Routing laminates with ceramic filler & high Tg materials $\geq 200^{\circ} \text{C}$

Tool Recommendations: 1750

RO4xxx, Aarlon 25x, Isola IS620

Cutting Speed: 590 Feet/Minute

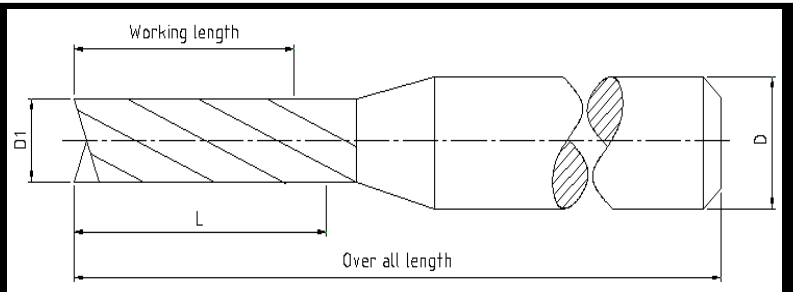
Router Size		Spindle Speed	Chip Load		X/Y Feed Rate		Plunge Rate		Rout Depth		Backup Penetration	
mm	Diameter		um	inch	m/m	inch/min	m/min	inch/min	mm	inch	mm	inch
.60	.0236	96000	2	.0001	0.2	8	0.6	24	1.5	.059	0.4	.016
.80	.0315	71000	4	.0015	0.3	12	1.0	39	3.2	.126	0.6	.024
1.00	.0394	57000	6	.0002	0.4	16	1.5	59	3.2	.126	0.8	.032
1.20	.0472	48000	8	.0003	0.4	16	1.5	59	3.2	.126	1.1	.043
1.50	.0591	38000	13	.0005	0.5	20	1.5	59	3.2	.126	1.1	.043
1.60	.0630	36000	16	.0006	0.6	24	2.0	79	3.2	.126	1.1	.043
1.80	.0709	32000	23	.0009	0.7	28	2.0	79	4.8	.189	1.1	.043
2.00	.0787	29000	30	.0012	0.9	35	2.0	79	4.8	.189	1.5	.059
2.40	.0945	24000	40	.0016	1.0	39	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 (>18 Inches of water)
- Max pressure at the pressure foot
- 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 .008"
Working Length	<.85 X Specified Length (L)
Nominal Diameter	D1 +.0004"/-.0008"
Shank Diameter	.1250" \pm .00005"/-.0003"



we are diamond

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