

# Recommended Parameters:

## Routing laminates with fillers & Halogen Free

**Tool Recommendations: 1700 & 1200**

IS400 / IS420 /R-1566/ R-1755 Tg <185° C

Cutting Speed: 600 Feet/ Minute

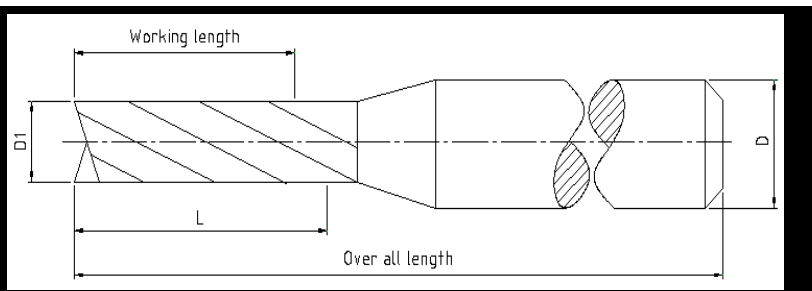
| Router Size |          | Spindle Speed | Chip Load |       | X/Y Feed Rate |        | Plunge Rate |        | Rout Depth |      | Backup Penetration |      |
|-------------|----------|---------------|-----------|-------|---------------|--------|-------------|--------|------------|------|--------------------|------|
| mm          | Diameter |               | um        | inch  | m/min         | in/min | m/min       | in/min | mm         | inch | mm                 | inch |
| .50         | .0197    | 115,000       | 2         | .0001 | .23           | 9      | 0.6         | 24     | 1.2        | .047 | .40                | .016 |
| .60         | .0236    | 96,000        | 3         | .0001 | 0.3           | 12     | 0.6         | 24     | 1.5        | .059 | .40                | .016 |
| .80         | .0315    | 71,000        | 6         | .0002 | 0.4           | 16     | 1.0         | 39     | 3.2        | .126 | .60                | .024 |
| 1.00        | .0394    | 57,000        | 8         | .0003 | 0.5           | 20     | 1.5         | 59     | 3.2        | .126 | .80                | .032 |
| 1.20        | .0472    | 48,000        | 11        | .0004 | 0.5           | 20     | 1.5         | 59     | 3.2        | .126 | 1.1                | .043 |
| 1.50        | .0591    | 38,000        | 16        | .0006 | 0.6           | 24     | 2.0         | 79     | 4.8        | .189 | 1.1                | .043 |
| 1.60        | .0630    | 36,000        | 20        | .0008 | 0.7           | 28     | 2.0         | 79     | 4.8        | .189 | 1.1                | .043 |
| 1.80        | .0709    | 32,000        | 26        | .0010 | 0.8           | 32     | 2.0         | 79     | 4.8        | .189 | 1.1                | .043 |
| 2.00        | .0787    | 29,000        | 35        | .0014 | 1.0           | 39     | 2.0         | 79     | 4.8        | .189 | 1.5                | .059 |
| 2.40        | .0945    | 24,000        | 45        | .0018 | 1.1           | 43     | 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
- Follow the GCT checklist for mechanical routing of PCB's.

### Router Specifications:

|                  |                                |
|------------------|--------------------------------|
| Over-All-Length  | 1.503" -.012"                  |
| Flute Length     | Specified Length (L) +/- 0.2mm |
| Working Length   | <.85 X Specified Length (L)    |
| Nominal Diameter | D1 +.0004"/-.0008"             |
| Shank Diameter   | .1250" -.00005"/-.0003"        |



we are diamond

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