

Recommended Parameters: Scoring of IMS, hologen- free materal & laminates with fillers

Tool Recommendation:138x

Cutting Speed: Depending upon point angle and routing depth

Point Angle	Routing Depth		Goove Width		Spindle Speed	Feed Rate X/Y		Feed Rate Z	
	mm	inch	mm	inch		m	inch	m	inch
30	.30	.0118	.20	.008	40 - 50,000	0.8 - 1.2	32 - 47	0.3	12
	.80	.0315	.50	.020	50 - 60,000	0.4 - 0.8	16 - 31	0.2	8
45	.40	.0157	.35	.014	40 - 50,000	1.0 - 1.5	39 - 59	0.5	20
	1.0	.0394	.85	.034	50 - 60,000	.5 - 1.0	20 - 39	0.3	12
60	.40	.0157	.45	.018	40 - 50,000	1.2 - 1.8	47 - 70	0.5	20
	1.0	.0394	1.15	.045	50 - 60,000	.8 - 1.3	32 - 51	0.3	12
90	.40	.0157	.80	.031	40 - 50,000	1.3 - 2.0	51 - 79	0.5	20
	1.0	.0394	2.00	.079	50 - 60,000	1.0 - 1.5	39 - 59	0.3	12

General Recommendations:

For Halogen-Free material and laminates with fillers:

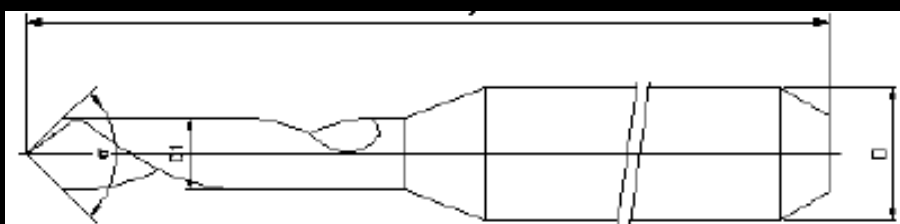
- The groove width is a recommended value only and relates to different conditions.
- The parameters depend on the routing spindle and application
- Maximum pressure foot pressure recommended.
- Cutting in 2 passes improves quality and dimension

For Aluminum and Copper:

- When scoring thru ceramic dielectric or copper, reduce the feed rate by approximately 30%
- Maximum pressure foot pressure recommended.
- Use lubrication
- Ball bearing spindles are preferred
- Follow the GCT Checklist for routing PCB's

Router Specifications:

Over-All-Length	1.503" -.012"
Point Angle	+/- 1 deg
Nominal Diameter	.0787" +/- .0008"
	.1250" -.0016"
Shank Diameter	.1250" -.00005/- .0003"



we are diamond

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