

Tools and applications (XXX ⇒ most suitable)

Router type	Description	FR4	Halogen-free materials	Laminates with fillers and Tg ≤ 185°C	Laminates with ceramic fillers and Tg ≥ 200°C	IMS and nonferrous metals	Depaneling
1700 1704 1760	extra fine spiral cut <i>DIAMOND COATED</i>	XX	XXX	XXX	XX	-	XXX
1750	extra fine spiral cut <i>THICKER DIAMOND COATING</i>	-	X	XX	XXX	-	X
1200 1204	diamond cut <i>DIAMOND COATED</i>	X	XX	XX	XX	-	XX
1250	diamond cut <i>THICKER DIAMOND COATING</i>	-	-	XX	XX	-	-
1322 1328	2 flute end mill <i>DIAMOND COATED</i>	X	X	XX	XX	XXX (for aluminium)	XXX (on IMS)
1312 1318	single flute end mill <i>DIAMOND COATED</i>	X	X	XX	XX	XXX (for copper)	XXX (on IMS)
1940	thread mill <i>DIAMOND COATED</i>	-	-	X	X	XXX	-
138x	Chamfering cutter <i>DIAMOND COATED</i>	XX	XX	XXX	XXX	XXX	-
5422	2 flute end mill <i>CC ALUSPEED® COATED</i>	-	-	-	-	X	X (on IMS)

General recommendations:

- ⇒ Follow the “**GCT check list**” for machining PCB’s and the “**GCT parameter recommendations**”
- ⇒ Reduce chip load to 60% if routing **inner contours, radii** and **depth routing**
- ⇒ Reduce chip load to 80% for **metals**
- ⇒ Use type 5422 for **depth routing with electrical contact**; reduce chip load to 30%