

## 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
<b>1700</b> <b>1760</b>	extra fine spiral cut <i>DIAMOND COATED</i>	XX	XXX	XXX	XX	-	XXX
<b>1750</b>	extra fine spiral cut <i>THICKER DIAMOND COATING</i>	-	X	XX	XXX	-	X
<b>1200</b>	diamond cut <i>DIAMOND COATED</i>	X	XX	XX	XX	-	XX
<b>1250</b>	diamond cut <i>THICKER DIAMOND COATING</i>	-	-	XX	XX	-	-
<b>1322</b> <b>1328</b>	2 flute end mill <i>DIAMOND COATED</i>	X	X	XX	XX	XXX (for aluminium)	XXX (on IMS)
<b>1312</b> <b>1318</b>	single flute end mill <i>DIAMOND COATED</i>	X	X	XX	XX	XXX (for copper)	XXX (on IMS)
<b>1940</b>	thread mill <i>DIAMOND COATED</i>	-	-	X	X	XXX	-
<b>138x</b>	Chamfering cutter <i>DIAMOND COATED</i>	XX	XX	XXX	XXX	XXX	-
<b>5422</b>	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%