

Routing parameter overview

Kind of material / resin system	Cutting speed in m / min	Feed rate in % compared to FR 4	GCT router types	⇒ GCT's tool recommendation
FR 4 routing outer contours	Please refer to „Parameter routing FR4 60K“ and „Parameter routing FR4 80K“		1200 / 1204 1700 / 1704	⇒ GCT diamond coated router with spiral (chip breaker) or diamond patterned geometry
FR 4 routing inner contours or radii	(180 -) 220	60	1200 / 1204 1700 / 1704	
FR 4 depth routing	(180 -) 220	60	1328	⇒ 2-flute end mill with diamond coating and centre cutting
halogen-free materials high Tg up to 185°C laminates with fillers IS 400 / IS 420 / G 200 / 1755C	Please refer to „Parameter routing laminates with fillers and halogen free“		1700 / 1704	⇒ GCT diamond coated router with extra fine spiral cut
laminates with ceramic fillers high Tg ≥ 200°C RO 4350 / 4003 / 4403 Arlon 25N / 25FR CE Tg 240°C Polyimide resin Tg 260°C (G30 / P97)	Please refer to „Parameter routing laminates with ceramic fillers“		1750	⇒ GCT diamond coated router with extra fine spiral cut and thicker diamond coating
IMS aluminium copper brass	Please refer to „Parameter routing IMS and nonferrous metals“		1312 / 1318 1322 / 1328 5422	⇒ single- and 2-flute end mill with diamond coating or with CC ALUSPEED® coating
Scoring of pcb	Please refer to „Parameter scoring“		138x	⇒ GCT diamond coating chamfering cutter
Internal screw thread	Please refer to „Technical information about thread mill 1940“		1940	⇒ GCT diamond coating thread mill
Depaneling of pcb	Please refer to „Parameter depaneling“ and „Parameter depaneling IMS“		1200 / 1204 1700 / 1704 1760 1312 1322 / 1328	⇒ GCT diamond coated router with spiral or diamond patterned geometry or single- and 2-flute end mill for IMS