



The values given are a rough guide and may differ from the table depending on the machine and peripherals.

Parameter recommendation for milling external contours in FR4

Millingtype:		Spiraltoothed					
Cutting speed:		v = 180-200 m/min for Spindle max. 60.000 RPM					
D1	n	fx	Fxy	Fz	Fz	H	Tiefe
Milling cutter diameter	Spindle num of rev	Feed/ revolutions	Feedrate	with	without	Cutting depth	In die
[mm]	[1/mm]	[μ m/1]	[m/min]	Pre-drilling		[mm]	Millingpad
				[m/min]	[m/min]		[mm]
0.8	>50000	5	0.25	1.0	0.3	3.2	0.6
0.9	>50000	6	0.30	1.0	0.4	3.2	0.6
1.0	>50000	7	0.40	2.0	0.5	4.8	0.8
1.1	>50000	8	0.40	2.0	0.5	4.8	0.8
1.2	>50000	10	0.50	2.0	0.6	4.8	1.1
1.3	48000	11	0.50	2.0	0.6	4.8	1.1
1.4	44000	13	0.60	2.0	0.7	4.8	1.1
1.5	41000	15	0.60	2.0	0.8	4.8	1.1
1.6	38000	18	0.70	3.0	0.9	4.8	1.1
1.7	35000	20	0.70	3.0	1.0	4.8	1.1
1.8	33000	24	0.80	3.0	1.0	4.8	1.1
1.9	31000	29	0.90	3.0	1.0	4.8	1.1
2.0	29000	35	1.00	3.0	1.0	4.8	1.5
2.4	24000	41	1.00	4.0	1.0	4.8	1.5
2.5	23000	43	1.00	4.0	1.0	4.8	1.5
3.0	19000	44	0.80	4.0	1.0	4.8	1.5
3.175	18000	45	0.80	4.0	1.0	4.8	1.5