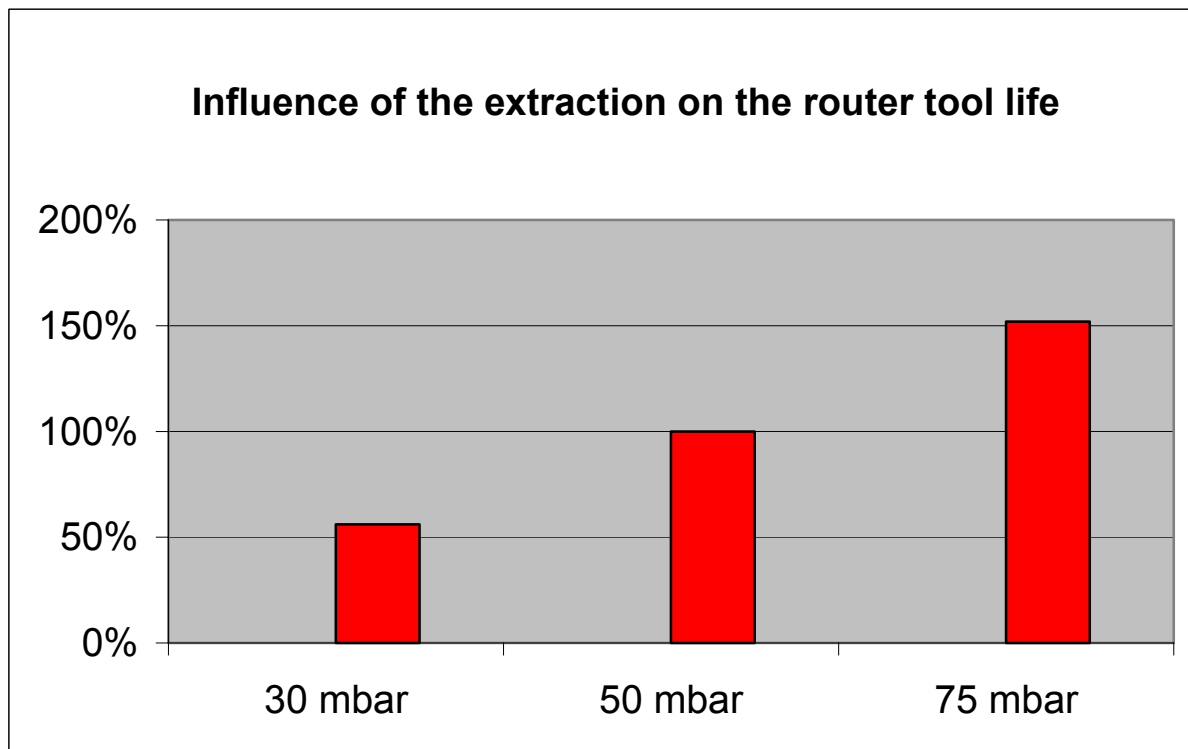


Topic: Influence of the extraction on the router tool life

Router: GCT Type 2 100 1000 070
 Ø 1.0 mm, flute length 7.0 mm, spiral cut, uncoated
 Material: FR 4, 1.55 mm thick, 3 panels per stack
 Spindle speed: 60000 rpm
 Feed rate: 0.50 m/min
 Direction: anticlockwise
 Machine: Schmoll
 Backup: Phenol paper, pre-routed
 Extraction system: Central, vacuum measured at the pressure foot



Johann Schmidt