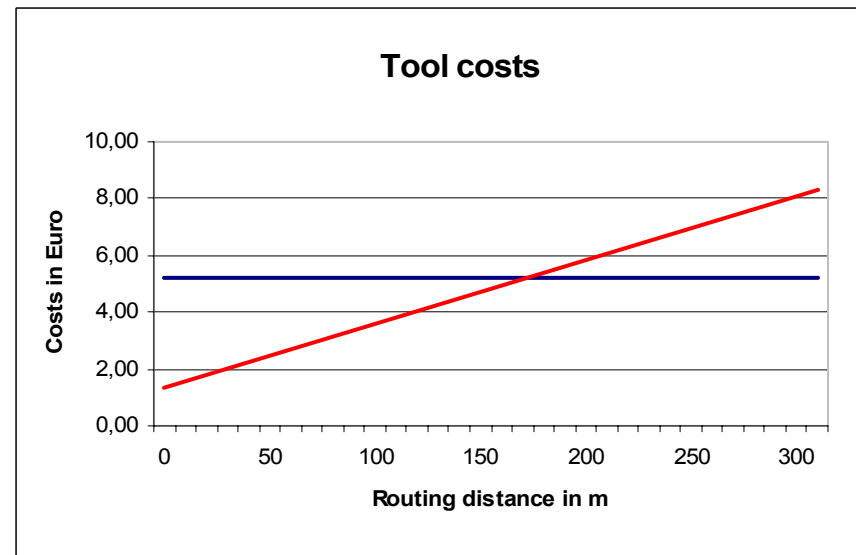
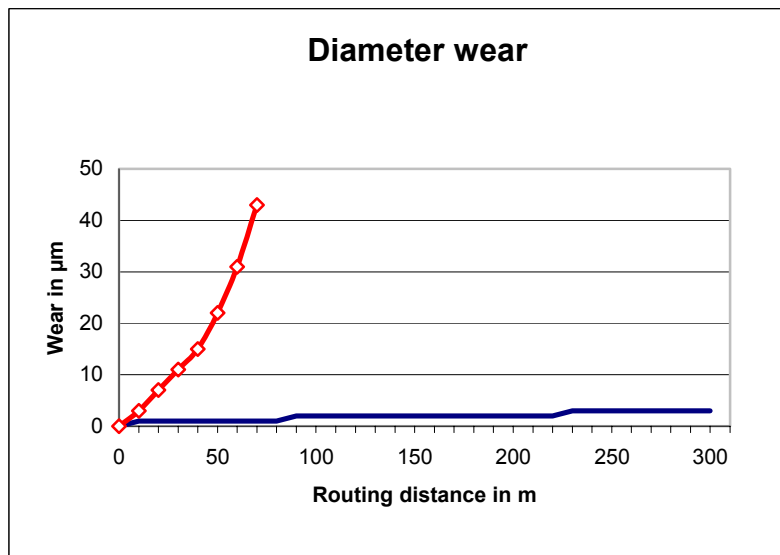


Comparison of standard and diamond coated router

Trial conditions:

Material: FR 4, DS, 4 panel/stack, thickness 1.55 mm
 Tools: GCT router 1 100 and 2 100 2000 090 (Ø 2.0 mm)
 Spindle speed: 35000 rpm
 XY feed rate: 1.30 m/min
 Extraction: 50 mbar at the pressure foot



Summary:

The diameter wear of standard routers increases after 50-60 m very fast. During the whole tool life the wear of diamond coated routers is only a few µm.
 Even a quadruplicate routing distance saves tool costs. The tool life of diamond coated routers increases by at least factor 6.
 Additional advantages resulting from less tool change and handling increase the cost savings to approx. 40%.