

NR50-5100ATC/EM-3060 ϕ 2.0mm End mill Application (PCB)

Motor Spindle	NR50-5100ATC/EM-3060/E3000
Machine	Sodick MC (MC430L)
Tools	ϕ 2mm Carbide router
Work	PCB (FR-4 board) t1.6
Cutting	Groove cutting
Coolant	Dry
Cutting Condition	Cutting Speed: 220m/min Spindle Speed: 35,000min ⁻¹ Feed: 1,000/1,500/2,000/2,500/3,000/3,500 4,000/4,500/5,000/5,500/6,000 mm/min Depth of cut: Ap1.6mm $\times$ Ae2mm

The router did not fall out.

Good cutting surface obtained when the feed was 4000mm/min⁻¹ or under.

