



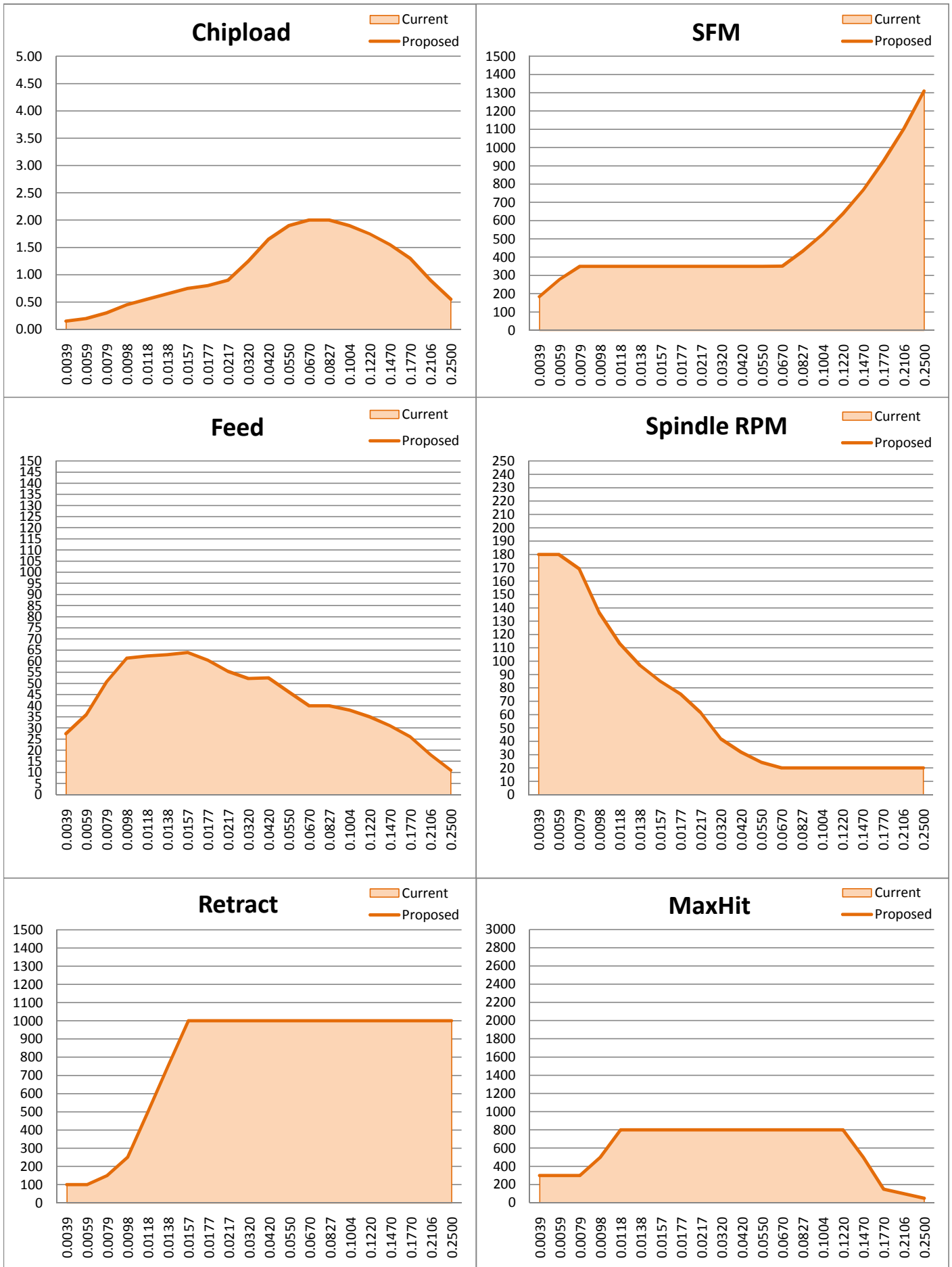
Application:	
Material Type:	Polyimide
Drill Designs:	MDBT, UCMT/UCCP, WTCB

Process Parameters:	
Cutting Speed (SFM)	350
Maximum Chipload (0.001"/Revolution)	2.00
Maximum Hit Count	800
Maximum Spindle RPM	180
Minimum Spindle RPM	20
Z-Offset (1-Point Clearance + Additional Depth; 2-Diameter)	1
Additional Depth (inch)	0.010
Maximum Drill Depth (Inch)	0.040

	Diameter		Chipload	SFM	Retract	MaxHit
1	0.0039	0.10MM	0.15		100	300
2	0.0059	#97 - 0.15MM	0.20		100	300
3	0.0079	#92 - 0.20MM	0.30		150	300
4	0.0098	0.25MM	0.45		250	500
5	0.0118	0.30MM	0.55		500	800
6	0.0138	0.35MM	0.65		750	800
7	0.0157	0.40MM	0.75		1000	800
8	0.0177	0.45MM	0.80		1000	800
9	0.0217	0.55MM	0.90		1000	800
10	0.0320	#67	1.25		1000	800
11	0.0420	#58	1.65		1000	800
12	0.0550	#54	1.90		1000	800
13	0.0670	#51	2.00		1000	800
14	0.0827	2.10MM	2.00		1000	800
15	0.1004	2.55MM	1.90		1000	800
16	0.1220	3.10MM	1.75		1000	800
17	0.1470	#26	1.55		1000	500
18	0.1770	#16	1.30		1000	150
19	0.2106	5.35MM	0.90		1000	100
20	0.2500	1/4 - 6.35MM	0.55		1000	50

Polyimide

MDBT, UCMT/UCCP, WTCB





Polyimide MDBT, UCMT/UCCP, WTCB

Series	Diameter		Feed	Speed	Retract	MaxHit	Z-offset	SFM	Chipload
	(in.)		(IPM)	(K-RPM)	(IPM)		(in.)		(0.001"/Rev.)
MDBT	0.0039	0.10MM	27	180	100	300	-0.011	184	0.15
	0.0051	0.13MM	33	180	100	300	-0.011	240	0.18
	0.0059	#97 - 0.15MM	36	180	100	300	-0.011	278	0.20
	0.0063	#96	39	177	110	300	-0.011	292	0.22
	0.0067	#95	42	175	120	300	-0.012	307	0.24
	0.0071	#94	45	173	130	300	-0.012	321	0.26
	0.0075	#93	48	171	140	300	-0.012	336	0.28
UCMT / UCCP	0.0079	#92 - 0.20MM	51	169	150	300	-0.012	350	0.30
	0.0083	#91	53	161	171	350	-0.012	350	0.33
	0.0087	#90	56	154	192	400	-0.012	350	0.36
	0.0091	#89	58	147	213	450	-0.012	350	0.39
	0.0095	#88	60	141	234	475	-0.012	350	0.43
	0.0098	0.25MM	61	136	250	500	-0.012	350	0.45
	0.0100	#87	61	134	275	550	-0.012	350	0.46
	0.0105	#86	62	127	338	625	-0.012	350	0.49
	0.0110	#85	62	122	400	700	-0.013	350	0.51
	0.0115	#84	62	116	463	775	-0.013	350	0.54
	0.0118	0.30MM	62	113	500	800	-0.013	350	0.55
	0.0120	#83	62	111	525	800	-0.013	350	0.56
	0.0125	#82	63	107	588	800	-0.013	350	0.59
	0.0130	#81	63	103	650	800	-0.013	350	0.61
	0.0135	#80	63	99	713	800	-0.013	350	0.64
	0.0138	0.35MM	63	97	750	800	-0.013	350	0.65
	0.0145	#79	63	92	842	800	-0.013	350	0.69
	0.0156	1/64	64	86	987	800	-0.014	350	0.74
	0.0157	0.40MM	64	85	1000	800	-0.014	350	0.75
	0.0160	#78	63	84	1000	800	-0.014	350	0.76
	0.0177	0.45MM	60	76	1000	800	-0.014	350	0.80
	0.0180	#77	60	74	1000	800	-0.014	350	0.81
	0.0197	0.50MM	58	68	1000	800	-0.015	350	0.85
0.0200	#76	57	67	1000	800	-0.015	350	0.86	
MDBT	0.0210	#75	56	64	1000	800	-0.015	350	0.88
	0.0217	0.55MM	55	62	1000	800	-0.015	350	0.90
	0.0225	#74	55	59	1000	800	-0.015	350	0.93
	0.0236	0.60MM	55	57	1000	800	-0.016	350	0.96



Polyimide MDBT, UCMT/UCCP, WTCB

Series	Diameter (in.)		Feed (IPM)	Speed (K-RPM)	Retract (IPM)	MaxHit	Z-offset (in.)	SFM	Chipload (0.001"/Rev.)
MDBT	0.0240	#73	54	56	1000	800	-0.016	350	0.98
	0.0250	#72	54	53	1000	800	-0.016	350	1.01
	0.0256	0.65MM	54	52	1000	800	-0.016	350	1.03
	0.0260	#71	54	51	1000	800	-0.016	350	1.05
	0.0276	0.70MM	53	48	1000	800	-0.016	350	1.10
	0.0280	#70	53	48	1000	800	-0.017	350	1.11
	0.0292	#69	53	46	1000	800	-0.017	350	1.15
	0.0295	0.75MM	53	45	1000	800	-0.017	350	1.17
	0.0310	#68	52	43	1000	800	-0.017	350	1.22
	0.0312	1/32	52	43	1000	800	-0.017	350	1.22
	0.0315	0.80MM	52	42	1000	800	-0.017	350	1.23
	0.0320	#67	52	42	1000	800	-0.017	350	1.25
	0.0330	#66	52	41	1000	800	-0.018	350	1.29
	0.0335	0.85MM	52	40	1000	800	-0.018	350	1.31
	0.0350	#65	52	38	1000	800	-0.018	350	1.37
	0.0354	0.90MM	52	38	1000	800	-0.018	350	1.39
	0.0360	#64	52	37	1000	800	-0.018	350	1.41
	0.0370	#63	52	36	1000	800	-0.019	350	1.45
	0.0374	0.95MM	52	36	1000	800	-0.019	350	1.47
	0.0380	#62	52	35	1000	800	-0.019	350	1.49
	0.0390	#61	52	34	1000	800	-0.019	350	1.53
	0.0394	1.00MM	52	34	1000	800	-0.019	350	1.55
	0.0400	#60	52	33	1000	800	-0.019	350	1.57
	0.0410	#59	52	33	1000	800	-0.020	350	1.61
	0.0413	1.05MM	53	32	1000	800	-0.020	350	1.62
	0.0420	#58	53	32	1000	800	-0.020	350	1.65
	0.0430	#57	52	31	1000	800	-0.020	350	1.67
	0.0433	1.10MM	52	31	1000	800	-0.020	350	1.68
	0.0441	1.12MM	51	30	1000	800	-0.020	350	1.69
	0.0453	1.15MM	51	30	1000	800	-0.021	350	1.71
	0.0465	#56	50	29	1000	800	-0.021	350	1.74
	0.0469	3/64	50	29	1000	800	-0.021	350	1.74
0.0472	1.20MM	50	28	1000	800	-0.021	350	1.75	
0.0492	1.25MM	49	27	1000	800	-0.021	350	1.79	
0.0512	1.30MM	48	26	1000	800	-0.022	350	1.83	



Polyimide MDBT, UCMT/UCCP, WTCB

Series	Diameter		Feed	Speed	Retract	MaxHit	Z-offset	SFM	Chipload
	(in.)		(IPM)	(K-RPM)	(IPM)		(in.)		(0.001"/Rev.)
MDBT	0.0520	#55	47	26	1000	800	-0.022	350	1.84
	0.0531	1.35MM	47	25	1000	800	-0.022	350	1.86
	0.0550	#54	46	24	1000	800	-0.023	350	1.90
	0.0551	1.40MM	46	24	1000	800	-0.023	350	1.90
	0.0571	1.45MM	45	23	1000	800	-0.023	350	1.92
	0.0591	1.50MM	44	23	1000	800	-0.024	350	1.93
	0.0595	#53	44	22	1000	800	-0.024	350	1.94
	0.0610	1.55MM	43	22	1000	800	-0.024	350	1.95
	0.0625	1/16	42	21	1000	800	-0.025	351	1.96
	0.0630	1.60MM	42	21	1000	800	-0.025	351	1.97
	0.0635	#52	42	21	1000	800	-0.025	351	1.97
	0.0650	1.65MM	41	21	1000	800	-0.025	351	1.98
	0.0669	1.70MM	40	20	1000	800	-0.026	351	2.00
	0.0670	#51	40	20	1000	800	-0.026	351	2.00
	0.0689	1.75MM	40	20	1000	800	-0.026	361	2.00
	0.0700	#50	40	20	1000	800	-0.026	367	2.00
	0.0709	1.80MM	40	20	1000	800	-0.027	371	2.00
	0.0728	1.85MM	40	20	1000	800	-0.027	381	2.00
	0.0730	#49	40	20	1000	800	-0.027	382	2.00
	0.0748	1.90MM	40	20	1000	800	-0.027	392	2.00
	0.0760	#48	40	20	1000	800	-0.028	398	2.00
	0.0768	1.95MM	40	20	1000	800	-0.028	402	2.00
	0.0781	5/64	40	20	1000	800	-0.028	409	2.00
	0.0785	#47	40	20	1000	800	-0.028	411	2.00
	0.0787	2.00MM	40	20	1000	800	-0.028	412	2.00
	0.0807	2.05MM	40	20	1000	800	-0.029	423	2.00
	0.0810	#46	40	20	1000	800	-0.029	424	2.00
	0.0820	#45	40	20	1000	800	-0.029	429	2.00
	0.0827	2.10MM	40	20	1000	800	-0.029	433	2.00
	0.0846	2.15MM	40	20	1000	800	-0.030	443	1.99
	0.0860	#44	40	20	1000	800	-0.030	450	1.98
	0.0866	2.20MM	40	20	1000	800	-0.030	453	1.98
	0.0886	2.25MM	39	20	1000	800	-0.031	464	1.97
0.0890	#43	39	20	1000	800	-0.031	466	1.96	
0.0906	2.30MM	39	20	1000	800	-0.031	474	1.96	



Polyimide MDBT, UCMT/UCCP, WTCB

Series	Diameter		Feed	Speed	Retract	MaxHit	Z-offset	SFM	Chipload
	(in.)		(IPM)	(K-RPM)	(IPM)		(in.)		(0.001"/Rev.)
MDBT	0.0925	2.35MM	39	20	1000	800	-0.032	484	1.94
	0.0935	#42	39	20	1000	800	-0.032	490	1.94
	0.0938	3/32	39	20	1000	800	-0.032	491	1.94
	0.0945	2.40MM	39	20	1000	800	-0.032	495	1.93
	0.0960	#41	38	20	1000	800	-0.032	503	1.92
	0.0965	2.45MM	38	20	1000	800	-0.032	505	1.92
	0.0980	#40	38	20	1000	800	-0.033	513	1.91
	0.0984	2.50MM	38	20	1000	800	-0.033	515	1.91
	0.0995	#39	38	20	1000	800	-0.033	521	1.91
	0.1004	2.55MM	38	20	1000	800	-0.033	526	1.90
	0.1015	#38	38	20	1000	800	-0.034	531	1.89
	0.1024	2.60MM	38	20	1000	800	-0.034	536	1.89
	0.1040	#37	38	20	1000	800	-0.034	545	1.88
	0.1043	2.65MM	37	20	1000	800	-0.034	546	1.87
	0.1063	2.70MM	37	20	1000	800	-0.035	557	1.86
	0.1065	#36	37	20	1000	800	-0.035	558	1.86
	0.1083	2.75MM	37	20	1000	800	-0.035	567	1.85
	0.1094	7/64	37	20	1000	800	-0.036	573	1.84
	0.1100	#35	37	20	1000	800	-0.036	576	1.83
	0.1102	2.80MM	37	20	1000	800	-0.036	577	1.83
	0.1110	#34	37	20	1000	800	-0.036	581	1.83
	0.1122	2.85MM	36	20	1000	800	-0.036	587	1.82
	0.1130	#33	36	20	1000	800	-0.036	592	1.81
	0.1142	2.90MM	36	20	1000	800	-0.037	598	1.80
	0.1160	#32	36	20	1000	800	-0.037	607	1.79
	0.1161	2.95MM	36	20	1000	800	-0.037	608	1.79
	0.1181	3.00MM	36	20	1000	800	-0.038	618	1.78
	0.1200	#31	35	20	1000	800	-0.038	628	1.76
	0.1201	3.05MM	35	20	1000	800	-0.038	629	1.76
	0.1220	3.10MM	35	20	1000	800	-0.038	639	1.75
0.1240	3.15MM	35	20	1000	800	-0.039	649	1.73	
0.1250	1/8	35	20	1000	775	-0.039	654	1.73	
WTCB	0.1260	3.20MM	34	20	1000	775	-0.018	660	1.72
	0.1280	3.25MM	34	20	1000	750	-0.018	670	1.70
	0.1285	#30	34	20	1000	725	-0.018	673	1.70



Polyimide MDBT, UCMT/UCCP, WTCB

Series	Diameter		Feed	Speed	Retract	MaxHit	Z-offset	SFM	Chipload
	(in.)		(IPM)	(K-RPM)	(IPM)		(in.)		(0.001"/Rev.)
WTCB	0.1299	3.30MM	34	20	1000	725	-0.019	680	1.69
	0.1319	3.35MM	33	20	1000	700	-0.019	691	1.67
	0.1339	3.40MM	33	20	1000	675	-0.019	701	1.65
	0.1358	3.45MM	33	20	1000	650	-0.019	711	1.64
	0.1360	#29	33	20	1000	650	-0.019	712	1.64
	0.1378	3.50MM	32	20	1000	625	-0.019	722	1.62
	0.1398	3.55MM	32	20	1000	600	-0.019	732	1.61
	0.1405	#28	32	20	1000	600	-0.019	736	1.60
	0.1406	9/64	32	20	1000	600	-0.019	736	1.60
	0.1417	3.60MM	32	20	1000	575	-0.019	742	1.59
	0.1437	3.65MM	32	20	1000	550	-0.019	752	1.58
	0.1440	#27	31	20	1000	550	-0.019	754	1.57
	0.1457	3.70MM	31	20	1000	525	-0.020	763	1.56
	0.1470	#26	31	20	1000	500	-0.020	770	1.55
	0.1476	3.75MM	31	20	1000	500	-0.020	773	1.55
	0.1495	#25	31	20	1000	475	-0.020	783	1.53
	0.1496	3.80MM	31	20	1000	475	-0.020	783	1.53
	0.1516	3.85MM	30	20	1000	450	-0.020	794	1.51
	0.1520	#24	30	20	1000	450	-0.020	796	1.51
	0.1535	3.90MM	30	20	1000	425	-0.020	804	1.50
	0.1540	#23	30	20	1000	425	-0.020	806	1.49
	0.1555	3.95MM	30	20	1000	425	-0.020	814	1.48
	0.1562	5/32	29	20	1000	400	-0.020	818	1.47
	0.1570	#22	29	20	1000	400	-0.020	822	1.47
	0.1575	4.00MM	29	20	1000	400	-0.020	825	1.46
	0.1590	#21	29	20	1000	375	-0.020	833	1.45
	0.1594	4.05MM	29	20	1000	375	-0.020	835	1.45
	0.1610	#20	29	20	1000	350	-0.021	843	1.43
	0.1614	4.10MM	29	20	1000	350	-0.021	845	1.43
	0.1634	4.15MM	28	20	1000	325	-0.021	856	1.41
	0.1654	4.20MM	28	20	1000	300	-0.021	866	1.40
	0.1660	#19	28	20	1000	300	-0.021	869	1.39
	0.1673	4.25MM	28	20	1000	275	-0.021	876	1.38
0.1693	4.30MM	27	20	1000	250	-0.021	886	1.36	
0.1695	#18	27	20	1000	250	-0.021	887	1.36	



Polyimide MDBT, UCMT/UCCP, WTCB

Series	Diameter		Feed	Speed	Retract	MaxHit	Z-offset	SFM	Chipload
	(in.)		(IPM)	(K-RPM)	(IPM)		(in.)		(0.001"/Rev.)
WTCB	0.1713	4.35MM	27	20	1000	225	-0.021	897	1.35
	0.1719	11/64	27	20	1000	225	-0.021	900	1.34
	0.1730	#17	27	20	1000	200	-0.021	906	1.33
	0.1732	4.40MM	27	20	1000	200	-0.021	907	1.33
	0.1752	4.45MM	26	20	1000	175	-0.022	917	1.32
	0.1770	#16	26	20	1000	150	-0.022	927	1.30
	0.1772	4.50MM	26	20	1000	150	-0.022	928	1.30
	0.1791	4.55MM	26	20	1000	150	-0.022	938	1.28
	0.1800	#15	25	20	1000	150	-0.022	942	1.26
	0.1811	4.60MM	25	20	1000	150	-0.022	948	1.25
	0.1820	#14	25	20	1000	150	-0.022	953	1.24
	0.1831	4.65MM	25	20	1000	150	-0.022	959	1.23
	0.1850	4.70MM	24	20	1000	150	-0.022	969	1.20
	0.1870	4.75MM	24	20	1000	150	-0.022	979	1.18
	0.1875	3/16	24	20	1000	150	-0.022	982	1.18
	0.1890	#12 - 4.80MM	23	20	1000	150	-0.022	990	1.16
	0.1909	4.85MM	23	20	1000	150	-0.023	1000	1.13
	0.1910	#11	23	20	1000	150	-0.023	1000	1.13
	0.1929	4.90MM	22	20	1000	150	-0.023	1010	1.11
	0.1935	#10	22	20	1000	150	-0.023	1013	1.10
	0.1949	4.95MM	22	20	1000	125	-0.023	1020	1.09
	0.1960	#9	21	20	1000	125	-0.023	1026	1.07
	0.1969	5.00MM	21	20	1000	125	-0.023	1031	1.06
	0.1988	5.05MM	21	20	1000	125	-0.023	1041	1.04
	0.1990	#8	21	20	1000	125	-0.023	1042	1.04
	0.2008	5.10MM	20	20	1000	125	-0.023	1051	1.02
	0.2010	#7	20	20	1000	125	-0.023	1052	1.01
	0.2028	5.15MM	20	20	1000	125	-0.023	1062	0.99
	0.2031	13/64	20	20	1000	125	-0.023	1063	0.99
	0.2040	#6	20	20	1000	125	-0.023	1068	0.98
	0.2047	5.20MM	19	20	1000	125	-0.023	1072	0.97
	0.2055	#5	19	20	1000	125	-0.024	1076	0.96
	0.2067	5.25MM	19	20	1000	125	-0.024	1082	0.95
0.2087	5.30MM	18	20	1000	125	-0.024	1093	0.92	
0.2090	#4	18	20	1000	125	-0.024	1094	0.92	



Polyimide MDBT, UCMT/UCCP, WTCB

Series	Diameter (in.)		Feed (IPM)	Speed (K-RPM)	Retract (IPM)	MaxHit	Z-offset (in.)	SFM	Chipload (0.001"/Rev.)
WTCB	0.2106	5.35MM	18	20	1000	100	-0.024	1103	0.90
	0.2126	5.40MM	18	20	1000	100	-0.024	1113	0.88
	0.2130	#3	18	20	1000	100	-0.024	1115	0.88
	0.2146	5.45MM	17	20	1000	100	-0.024	1124	0.86
	0.2165	5.50MM	17	20	1000	100	-0.024	1134	0.85
	0.2185	5.55MM	17	20	1000	100	-0.024	1144	0.83
	0.2188	7/32	17	20	1000	100	-0.024	1146	0.83
	0.2205	5.60MM	16	20	1000	100	-0.025	1155	0.81
	0.2210	#2	16	20	1000	100	-0.025	1157	0.81
	0.2224	5.65MM	16	20	1000	100	-0.025	1164	0.80
	0.2244	5.70MM	16	20	1000	100	-0.025	1175	0.78
	0.2264	5.75MM	15	20	1000	100	-0.025	1185	0.76
	0.2280	#1	15	20	1000	100	-0.025	1194	0.75
	0.2283	5.80MM	15	20	1000	100	-0.025	1195	0.74
	0.2303	5.85MM	15	20	1000	75	-0.025	1206	0.73
	0.2323	5.90MM	14	20	1000	75	-0.025	1216	0.71
	0.2340	#A	14	20	1000	75	-0.025	1225	0.69
	0.2343	5.95MM	14	20	1000	75	-0.025	1227	0.69
	0.2344	15/64	14	20	1000	75	-0.025	1227	0.69
	0.2362	6.00MM	13	20	1000	75	-0.026	1237	0.67
	0.2380	#B	13	20	1000	75	-0.026	1246	0.66
	0.2382	6.05MM	13	20	1000	75	-0.026	1247	0.65
	0.2402	6.10MM	13	20	1000	75	-0.026	1258	0.64
	0.2420	#C	12	20	1000	75	-0.026	1267	0.62
	0.2421	6.15MM	12	20	1000	75	-0.026	1268	0.62
	0.2441	6.20MM	12	20	1000	75	-0.026	1278	0.60
	0.2460	#D	12	20	1000	75	-0.026	1288	0.59
	0.2461	6.25MM	12	20	1000	75	-0.026	1289	0.58
	0.2480	6.30MM	11	20	1000	75	-0.026	1299	0.57
	0.2500	1/4 - 6.35MM	11	20	1000	50	-0.026	1309	0.55