

## Drilling Feed & Speed Chart for **Lexan / Acrylic PCB Material**

Recommended Tycom Drill Series: **Series 100, 150, 500**

(Note: Chart is based on 160K RPM Spindle Capability. Please use maximum spindle speed if listed RPM is unattainable)

| Size   | Diameter      | Feed                | Speed          | Retract             | Z-Axis Offset   | Max Hits | Chipload          | SFM |
|--------|---------------|---------------------|----------------|---------------------|-----------------|----------|-------------------|-----|
|        | <i>(inch)</i> | <i>(Inches/min)</i> | <i>(k-rpm)</i> | <i>(inches/min)</i> | <i>(inches)</i> |          | <i>(mils/rev)</i> |     |
| #80    | 0.0135        | 168                 | 42             | 1000                | -0.013          | 2000     | 4.00              | 150 |
| 0.35mm | 0.0138        | 168                 | 42             | 1000                | -0.013          | 2000     | 4.00              | 150 |
| #79    | 0.0145        | 168                 | 40             | 1000                | -0.013          | 2000     | 4.20              | 150 |
| 1/64   | 0.0156        | 163                 | 37             | 1000                | -0.014          | 2000     | 4.40              | 150 |
| 0.40mm | 0.0158        | 162                 | 36             | 1000                | -0.014          | 2000     | 4.50              | 150 |
| #78    | 0.0160        | 166                 | 36             | 1000                | -0.014          | 2000     | 4.60              | 150 |
| 0.45mm | 0.0177        | 154                 | 32             | 1000                | -0.014          | 2000     | 4.80              | 150 |
| #77    | 0.0180        | 160                 | 32             | 1000                | -0.014          | 2000     | 5.00              | 150 |
| 0.50mm | 0.0197        | 151                 | 29             | 1000                | -0.015          | 2000     | 5.20              | 150 |
| #76    | 0.0200        | 157                 | 29             | 1000                | -0.015          | 2000     | 5.40              | 150 |
| #75    | 0.0210        | 151                 | 27             | 1000                | -0.015          | 2000     | 5.60              | 150 |
| 0.55mm | 0.0217        | 151                 | 26             | 1000                | -0.015          | 2000     | 5.80              | 150 |
| #74    | 0.0225        | 150                 | 25             | 1000                | -0.015          | 2000     | 6.00              | 150 |
| 0.60mm | 0.0236        | 149                 | 24             | 1000                | -0.016          | 2000     | 6.20              | 150 |
| #73    | 0.0240        | 154                 | 24             | 1000                | -0.016          | 2000     | 6.40              | 150 |
| #72    | 0.0250        | 152                 | 23             | 1000                | -0.016          | 2000     | 6.60              | 150 |
| 0.65mm | 0.0256        | 150                 | 22             | 1000                | -0.016          | 2000     | 6.80              | 150 |
| #71    | 0.0260        | 154                 | 22             | 1000                | -0.016          | 2000     | 7.00              | 150 |
| 0.70mm | 0.0276        | 155                 | 21             | 1000                | -0.016          | 2000     | 7.40              | 150 |
| #70    | 0.0280        | 152                 | 20             | 1000                | -0.017          | 2000     | 7.60              | 150 |
| #69    | 0.0292        | 156                 | 20             | 1000                | -0.017          | 2000     | 7.80              | 150 |
| 0.75mm | 0.0295        | 152                 | 19             | 1000                | -0.017          | 2000     | 8.00              | 150 |
| #68    | 0.0310        | 148                 | 18             | 1000                | -0.017          | 2000     | 8.20              | 150 |
| 1/32   | 0.0312        | 151                 | 18             | 1000                | -0.017          | 2000     | 8.40              | 150 |
| 0.80mm | 0.0315        | 155                 | 18             | 1000                | -0.017          | 2000     | 8.60              | 150 |
| #67    | 0.0320        | 158                 | 18             | 1000                | -0.017          | 2000     | 8.80              | 150 |
| #66    | 0.0330        | 153                 | 17             | 1000                | -0.018          | 2000     | 9.00              | 150 |
| 0.85mm | 0.0335        | 156                 | 17             | 1000                | -0.018          | 2000     | 9.20              | 150 |
| #65    | 0.0350        | 154                 | 16             | 1000                | -0.018          | 2000     | 9.60              | 150 |
| 0.90mm | 0.0354        | 157                 | 16             | 1000                | -0.018          | 2000     | 9.80              | 150 |
| #64    | 0.0360        | 160                 | 16             | 1000                | -0.018          | 2000     | 10.00             | 150 |
| #63    | 0.0370        | 153                 | 15             | 1000                | -0.019          | 2000     | 10.20             | 150 |
| 0.95mm | 0.0374        | 156                 | 15             | 1000                | -0.019          | 2000     | 10.40             | 150 |
| #62    | 0.0380        | 159                 | 15             | 1000                | -0.019          | 2000     | 10.60             | 150 |
| #61    | 0.0390        | 162                 | 15             | 1000                | -0.019          | 2000     | 10.80             | 150 |
| 1.00mm | 0.0394        | 165                 | 15             | 1000                | -0.019          | 2000     | 11.00             | 155 |

| Size   | Diameter | Feed         | Speed   | Retract      | Z-Axis Offset | Hits | Chipload   | SFM |
|--------|----------|--------------|---------|--------------|---------------|------|------------|-----|
|        | (inch)   | (Inches/min) | (k-rpm) | (inches/min) | (inches)      |      | (mils/rev) |     |
| #60    | 0.0400   | 168          | 15      | 1000         | -0.019        | 2000 | 11.20      | 157 |
| #59    | 0.0410   | 171          | 15      | 1000         | -0.020        | 2000 | 11.40      | 161 |
| 1.05mm | 0.0413   | 174          | 15      | 1000         | -0.020        | 2000 | 11.60      | 162 |
| #58    | 0.0420   | 177          | 15      | 1000         | -0.020        | 2000 | 11.80      | 165 |
| #57    | 0.0430   | 180          | 15      | 1000         | -0.020        | 2000 | 12.00      | 169 |
| 1.10mm | 0.0433   | 183          | 15      | 1000         | -0.020        | 2000 | 12.20      | 170 |
| 1.15mm | 0.0453   | 189          | 15      | 1000         | -0.021        | 2000 | 12.60      | 178 |
| #56    | 0.0465   | 192          | 15      | 1000         | -0.021        | 2000 | 12.80      | 183 |
| 3/64   | 0.0469   | 195          | 15      | 1000         | -0.021        | 2000 | 13.00      | 184 |
| 1.20mm | 0.0472   | 198          | 15      | 1000         | -0.021        | 2000 | 13.20      | 185 |
| 1.25mm | 0.0492   | 201          | 15      | 1000         | -0.021        | 2000 | 13.40      | 193 |
| 1.30mm | 0.0512   | 207          | 15      | 1000         | -0.022        | 2000 | 13.80      | 201 |
| #55    | 0.0520   | 210          | 15      | 1000         | -0.022        | 2000 | 14.00      | 204 |
| 1.35mm | 0.0531   | 213          | 15      | 1000         | -0.022        | 2000 | 14.20      | 208 |
| #54    | 0.0550   | 219          | 15      | 1000         | -0.023        | 2000 | 14.60      | 216 |
| 1.40mm | 0.0551   | 222          | 15      | 1000         | -0.023        | 2000 | 14.80      | 216 |
| 1.45mm | 0.0571   | 228          | 15      | 1000         | -0.023        | 2000 | 15.20      | 224 |
| 1.50mm | 0.0591   | 234          | 15      | 1000         | -0.024        | 2000 | 15.60      | 232 |
| #53    | 0.0595   | 237          | 15      | 1000         | -0.024        | 2000 | 15.80      | 234 |
| 1.55mm | 0.0610   | 240          | 15      | 1000         | -0.024        | 2000 | 16.00      | 239 |
| 1/16   | 0.0625   | 240          | 15      | 1000         | -0.025        | 2000 | 16.00      | 245 |
| 1.60mm | 0.0630   | 240          | 15      | 1000         | -0.025        | 2000 | 16.00      | 247 |
| #52    | 0.0635   | 240          | 15      | 1000         | -0.025        | 2000 | 16.00      | 249 |
| 1.65mm | 0.0650   | 240          | 15      | 1000         | -0.025        | 2000 | 16.00      | 255 |
| 1.70mm | 0.0669   | 240          | 15      | 1000         | -0.026        | 2000 | 16.00      | 263 |
| #51    | 0.0670   | 240          | 15      | 1000         | -0.026        | 2000 | 16.00      | 263 |
| 1.75mm | 0.0689   | 240          | 15      | 1000         | -0.026        | 2000 | 16.00      | 270 |
| #50    | 0.0700   | 240          | 15      | 1000         | -0.026        | 2000 | 16.00      | 275 |
| 1.80mm | 0.0709   | 240          | 15      | 1000         | -0.027        | 2000 | 16.00      | 278 |
| 1.85mm | 0.0728   | 240          | 15      | 1000         | -0.027        | 2000 | 16.00      | 286 |
| #49    | 0.0730   | 240          | 15      | 1000         | -0.027        | 2000 | 16.00      | 287 |
| 1.90mm | 0.0748   | 240          | 15      | 1000         | -0.027        | 2000 | 16.00      | 294 |
| #48    | 0.0760   | 240          | 15      | 1000         | -0.028        | 2000 | 16.00      | 298 |
| 1.95mm | 0.0768   | 240          | 15      | 1000         | -0.028        | 2000 | 16.00      | 301 |
| 5/64   | 0.0781   | 240          | 15      | 1000         | -0.028        | 2000 | 16.00      | 307 |
| #47    | 0.0785   | 240          | 15      | 1000         | -0.028        | 2000 | 16.00      | 308 |
| 2.00mm | 0.0787   | 240          | 15      | 1000         | -0.028        | 2000 | 16.00      | 309 |
| 2.05mm | 0.0807   | 237          | 15      | 1000         | -0.029        | 2000 | 15.80      | 317 |
| #46    | 0.0810   | 234          | 15      | 1000         | -0.029        | 2000 | 15.60      | 318 |
| #45    | 0.0820   | 231          | 15      | 1000         | -0.029        | 2000 | 15.40      | 322 |
| 2.10mm | 0.0827   | 228          | 15      | 1000         | -0.029        | 2000 | 15.20      | 325 |
| 2.15mm | 0.0846   | 222          | 15      | 1000         | -0.030        | 2000 | 14.80      | 332 |
| #44    | 0.0860   | 216          | 15      | 1000         | -0.030        | 2000 | 14.40      | 338 |
| 2.20mm | 0.0866   | 213          | 15      | 1000         | -0.030        | 2000 | 14.20      | 340 |
| 2.25mm | 0.0886   | 207          | 15      | 1000         | -0.031        | 2000 | 13.80      | 348 |
| #43    | 0.0890   | 204          | 15      | 1000         | -0.031        | 2000 | 13.60      | 349 |
| 2.30mm | 0.0906   | 198          | 15      | 1000         | -0.031        | 2000 | 13.20      | 356 |
| 2.35mm | 0.0925   | 192          | 15      | 1000         | -0.032        | 2000 | 12.80      | 363 |
|        |          |              |         |              |               |      |            |     |

| Size   | Diameter | Feed         | Speed   | Retract      | Z-Axis Offset | Hits | Chipload   | SFM |
|--------|----------|--------------|---------|--------------|---------------|------|------------|-----|
|        | (inch)   | (Inches/min) | (k-rpm) | (inches/min) | (inches)      |      | (mils/rev) |     |
| #42    | 0.0935   | 189          | 15      | 1000         | -0.032        | 2000 | 12.60      | 367 |
| 3/32   | 0.0938   | 183          | 15      | 1000         | -0.032        | 2000 | 12.20      | 368 |
| 2.40mm | 0.0945   | 180          | 15      | 1000         | -0.032        | 2000 | 12.00      | 371 |
| #41    | 0.0960   | 174          | 15      | 1000         | -0.032        | 2000 | 11.60      | 377 |
| 2.45mm | 0.0965   | 171          | 15      | 1000         | -0.033        | 2000 | 11.40      | 379 |
| #40    | 0.0980   | 165          | 15      | 1000         | -0.033        | 2000 | 11.00      | 385 |
| 2.50mm | 0.0984   | 162          | 15      | 1000         | -0.033        | 2000 | 10.80      | 386 |
| #39    | 0.0995   | 159          | 15      | 1000         | -0.033        | 2000 | 10.60      | 391 |
| 2.55mm | 0.1004   | 156          | 15      | 1000         | -0.033        | 2000 | 10.40      | 394 |
| #38    | 0.1015   | 153          | 15      | 1000         | -0.034        | 2000 | 10.20      | 398 |
| 2.60mm | 0.1024   | 150          | 15      | 1000         | -0.034        | 2000 | 10.00      | 402 |
| #37    | 0.1040   | 150          | 15      | 1000         | -0.034        | 2000 | 10.00      | 408 |
| 2.65mm | 0.1043   | 150          | 15      | 1000         | -0.034        | 2000 | 10.00      | 409 |
| 2.70mm | 0.1063   | 150          | 15      | 1000         | -0.035        | 2000 | 10.00      | 417 |
| #36    | 0.1065   | 150          | 15      | 1000         | -0.035        | 2000 | 10.00      | 418 |
| 2.75mm | 0.1083   | 150          | 15      | 1000         | -0.035        | 2000 | 10.00      | 425 |
| 7/64   | 0.1094   | 150          | 15      | 1000         | -0.036        | 2000 | 10.00      | 429 |
| #35    | 0.1100   | 150          | 15      | 1000         | -0.036        | 2000 | 10.00      | 432 |
| 2.80mm | 0.1102   | 150          | 15      | 1000         | -0.036        | 2000 | 10.00      | 433 |
| #34    | 0.1110   | 150          | 15      | 1000         | -0.036        | 2000 | 10.00      | 436 |
| 2.85mm | 0.1122   | 150          | 15      | 1000         | -0.036        | 2000 | 10.00      | 440 |
| #33    | 0.1130   | 150          | 15      | 1000         | -0.036        | 2000 | 10.00      | 444 |
| 2.90mm | 0.1142   | 150          | 15      | 1000         | -0.037        | 2000 | 10.00      | 448 |
| #32    | 0.1160   | 150          | 15      | 1000         | -0.037        | 2000 | 10.00      | 455 |
| 2.95mm | 0.1161   | 150          | 15      | 1000         | -0.037        | 2000 | 10.00      | 456 |
| 3.00mm | 0.1181   | 150          | 15      | 1000         | -0.038        | 2000 | 10.00      | 464 |
| #31    | 0.1200   | 150          | 15      | 1000         | -0.038        | 2000 | 10.00      | 471 |
| 3.05mm | 0.1201   | 150          | 15      | 1000         | -0.038        | 2000 | 10.00      | 471 |
| 3.10mm | 0.1220   | 150          | 15      | 1000         | -0.038        | 2000 | 10.00      | 479 |
| 3.15mm | 0.1240   | 150          | 15      | 1000         | -0.039        | 2000 | 10.00      | 487 |
| 1/8    | 0.1250   | 150          | 15      | 1000         | -0.039        | 2000 | 10.00      | 491 |
| 3.20mm | 0.1260   | 160          | 16      | 1000         | -0.018        | 1500 | 10.00      | 528 |
| 3.25mm | 0.1280   | 160          | 16      | 1000         | -0.018        | 1500 | 10.00      | 536 |
| #30    | 0.1285   | 160          | 16      | 1000         | -0.019        | 1500 | 10.00      | 538 |
| 3.30mm | 0.1299   | 160          | 16      | 1000         | -0.019        | 1500 | 10.00      | 544 |
| 3.35mm | 0.1319   | 160          | 16      | 1000         | -0.019        | 1500 | 10.00      | 552 |
| 3.40mm | 0.1339   | 160          | 16      | 1000         | -0.019        | 1500 | 10.00      | 561 |
| 3.45mm | 0.1358   | 160          | 16      | 1000         | -0.019        | 1500 | 10.00      | 569 |
| #29    | 0.1360   | 160          | 16      | 1000         | -0.019        | 1500 | 10.00      | 569 |
| 3.50mm | 0.1378   | 160          | 16      | 1000         | -0.019        | 1500 | 10.00      | 577 |
| 3.55mm | 0.1398   | 160          | 16      | 1000         | -0.019        | 1500 | 10.00      | 585 |
| #28    | 0.1405   | 170          | 17      | 1000         | -0.019        | 1500 | 10.00      | 625 |
| 9/64   | 0.1406   | 170          | 17      | 1000         | -0.019        | 1500 | 10.00      | 625 |
| 3.60mm | 0.1417   | 170          | 17      | 1000         | -0.019        | 1500 | 10.00      | 630 |
| 3.65mm | 0.1437   | 170          | 17      | 1000         | -0.020        | 1500 | 10.00      | 639 |
| #27    | 0.1440   | 170          | 17      | 1000         | -0.020        | 1500 | 10.00      | 641 |
| 3.70mm | 0.1457   | 170          | 17      | 1000         | -0.020        | 1500 | 10.00      | 648 |
| #26    | 0.1470   | 170          | 17      | 1000         | -0.020        | 1500 | 10.00      | 654 |
|        |          |              |         |              |               |      |            |     |

| Size   | Diameter      | Feed                | Speed          | Retract             | Z-Axis Offset   | Hits | Chipload          | SFM |
|--------|---------------|---------------------|----------------|---------------------|-----------------|------|-------------------|-----|
|        | <i>(inch)</i> | <i>(Inches/min)</i> | <i>(k-rpm)</i> | <i>(inches/min)</i> | <i>(inches)</i> |      | <i>(mils/rev)</i> |     |
| 3.75mm | 0.1476        | 170                 | 17             | 1000                | -0.020          | 1500 | 10.00             | 657 |
| #25    | 0.1495        | 170                 | 17             | 1000                | -0.020          | 1500 | 10.00             | 665 |
| 3.80mm | 0.1496        | 170                 | 17             | 1000                | -0.020          | 1500 | 10.00             | 665 |
| 3.85mm | 0.1516        | 170                 | 17             | 1000                | -0.020          | 1500 | 10.00             | 674 |
| #24    | 0.1520        | 170                 | 17             | 1000                | -0.020          | 1500 | 10.00             | 676 |
| 3.90mm | 0.1535        | 170                 | 17             | 1000                | -0.020          | 1500 | 10.00             | 683 |
| #23    | 0.1540        | 170                 | 17             | 1000                | -0.020          | 1500 | 10.00             | 685 |
| 3.95   | 0.1555        | 170                 | 17             | 1000                | -0.020          | 1500 | 10.00             | 692 |
| 5/32   | 0.1562        | 170                 | 17             | 1000                | -0.020          | 1500 | 10.00             | 695 |
| #22    | 0.1570        | 170                 | 17             | 1000                | -0.020          | 1500 | 10.00             | 698 |
| 4.00mm | 0.1575        | 170                 | 17             | 1000                | -0.020          | 1500 | 10.00             | 701 |
| #21    | 0.1590        | 180                 | 18             | 1000                | -0.021          | 1500 | 10.00             | 749 |
| 4.05mm | 0.1594        | 180                 | 18             | 1000                | -0.021          | 1500 | 10.00             | 751 |
| #20    | 0.1610        | 180                 | 18             | 1000                | -0.021          | 1500 | 10.00             | 758 |
| 4.10mm | 0.1614        | 180                 | 18             | 1000                | -0.021          | 1500 | 10.00             | 760 |
| 4.15mm | 0.1634        | 180                 | 18             | 1000                | -0.021          | 1500 | 10.00             | 770 |
| 4.20mm | 0.1654        | 180                 | 18             | 1000                | -0.021          | 1500 | 10.00             | 779 |
| #19    | 0.1660        | 180                 | 18             | 1000                | -0.021          | 1500 | 10.00             | 782 |
| 4.25mm | 0.1673        | 180                 | 18             | 1000                | -0.021          | 1500 | 10.00             | 788 |
| 4.30mm | 0.1693        | 180                 | 18             | 1000                | -0.021          | 1500 | 10.00             | 797 |
| #18    | 0.1695        | 180                 | 18             | 1000                | -0.021          | 1500 | 10.00             | 798 |
| 4.35mm | 0.1713        | 180                 | 18             | 1000                | -0.021          | 1500 | 10.00             | 807 |
| 11/64  | 0.1719        | 180                 | 18             | 1000                | -0.021          | 1500 | 10.00             | 810 |
| #17    | 0.1730        | 180                 | 18             | 1000                | -0.021          | 1500 | 10.00             | 815 |
| 4.40mm | 0.1732        | 180                 | 18             | 1000                | -0.021          | 1500 | 10.00             | 816 |
| 4.45mm | 0.1752        | 180                 | 18             | 1000                | -0.022          | 1500 | 10.00             | 825 |
| #16    | 0.1770        | 180                 | 18             | 1000                | -0.022          | 1500 | 10.00             | 834 |
| 4.50mm | 0.1772        | 180                 | 18             | 1000                | -0.022          | 1500 | 10.00             | 835 |
| 4.55mm | 0.1792        | 180                 | 18             | 1000                | -0.022          | 1500 | 10.00             | 844 |
| #15    | 0.1800        | 180                 | 18             | 1000                | -0.022          | 1500 | 10.00             | 848 |
| 4.60mm | 0.1811        | 180                 | 18             | 1000                | -0.022          | 1500 | 10.00             | 853 |
| #14    | 0.1820        | 180                 | 18             | 1000                | -0.022          | 1500 | 10.00             | 857 |
| 4.65mm | 0.1831        | 180                 | 18             | 1000                | -0.022          | 1500 | 10.00             | 862 |
| #13    | 0.1850        | 180                 | 18             | 1000                | -0.022          | 1500 | 10.00             | 871 |
| 4.70mm | 0.1850        | 180                 | 18             | 1000                | -0.022          | 1500 | 10.00             | 871 |
| 4.75mm | 0.1870        | 180                 | 18             | 1000                | -0.022          | 1500 | 10.00             | 881 |
| 3/16   | 0.1875        | 180                 | 18             | 1000                | -0.022          | 1500 | 10.00             | 883 |
| 4.80mm | 0.1890        | 190                 | 19             | 1000                | -0.023          | 1000 | 10.00             | 940 |
| #12    | 0.1890        | 190                 | 19             | 1000                | -0.023          | 1000 | 10.00             | 940 |
| 4.85mm | 0.1909        | 190                 | 19             | 1000                | -0.023          | 1000 | 10.00             | 949 |
| #11    | 0.1910        | 190                 | 19             | 1000                | -0.023          | 1000 | 10.00             | 950 |
| 4.90mm | 0.1929        | 190                 | 19             | 1000                | -0.023          | 1000 | 10.00             | 959 |
| #10    | 0.1935        | 190                 | 19             | 1000                | -0.023          | 1000 | 10.00             | 962 |
| 4.95mm | 0.1949        | 190                 | 19             | 1000                | -0.023          | 1000 | 10.00             | 969 |
| #9     | 0.1960        | 190                 | 19             | 1000                | -0.023          | 1000 | 10.00             | 974 |
| 5.00mm | 0.1968        | 190                 | 19             | 1000                | -0.023          | 1000 | 10.00             | 978 |
| 5.05mm | 0.1988        | 190                 | 19             | 1000                | -0.023          | 1000 | 10.00             | 988 |
| #8     | 0.1990        | 190                 | 19             | 1000                | -0.023          | 1000 | 10.00             | 989 |
|        |               |                     |                |                     |                 |      |                   |     |

| Size   | Diameter | Feed | Speed | Retract | Z-Axis Offset | Hits | Chipload | SFM  |
|--------|----------|------|-------|---------|---------------|------|----------|------|
| 5.10mm | 0.2008   | 190  | 19    | 1000    | -0.023        | 1000 | 10.00    | 998  |
| #7     | 0.2010   | 190  | 19    | 1000    | -0.023        | 1000 | 10.00    | 999  |
| 5.15mm | 0.2028   | 190  | 19    | 1000    | -0.023        | 1000 | 10.00    | 1008 |
| 13/64  | 0.2031   | 190  | 19    | 1000    | -0.023        | 1000 | 10.00    | 1010 |
| #6     | 0.2040   | 190  | 19    | 1000    | -0.024        | 1000 | 10.00    | 1014 |
| 5.20mm | 0.2047   | 190  | 19    | 1000    | -0.024        | 1000 | 10.00    | 1018 |
| #5     | 0.2055   | 190  | 19    | 1000    | -0.024        | 1000 | 10.00    | 1022 |
| 5.25mm | 0.2067   | 190  | 19    | 1000    | -0.024        | 1000 | 10.00    | 1028 |
| 5.30mm | 0.2087   | 190  | 19    | 1000    | -0.024        | 1000 | 10.00    | 1038 |
| #4     | 0.2090   | 190  | 19    | 1000    | -0.024        | 1000 | 10.00    | 1039 |
| 5.35mm | 0.2106   | 190  | 19    | 1000    | -0.024        | 1000 | 10.00    | 1047 |
| 5.40mm | 0.2126   | 190  | 19    | 1000    | -0.024        | 1000 | 10.00    | 1057 |
| #3     | 0.2130   | 190  | 19    | 1000    | -0.024        | 1000 | 10.00    | 1059 |
| 5.45mm | 0.2146   | 190  | 19    | 1000    | -0.024        | 1000 | 10.00    | 1067 |
| 5.50mm | 0.2165   | 190  | 19    | 1000    | -0.024        | 1000 | 10.00    | 1076 |
| 5.55mm | 0.2185   | 190  | 19    | 1000    | -0.024        | 1000 | 10.00    | 1086 |
| 7/32   | 0.2188   | 190  | 19    | 1000    | -0.024        | 1000 | 10.00    | 1088 |
| 5.60mm | 0.2205   | 190  | 19    | 1000    | -0.025        | 1000 | 10.00    | 1096 |
| #2     | 0.2210   | 190  | 19    | 1000    | -0.025        | 1000 | 10.00    | 1099 |
| 5.65mm | 0.2224   | 190  | 19    | 1000    | -0.025        | 1000 | 10.00    | 1106 |
| 5.70mm | 0.2244   | 190  | 19    | 1000    | -0.025        | 1000 | 10.00    | 1116 |
| 5.75mm | 0.2264   | 190  | 19    | 1000    | -0.025        | 1000 | 10.00    | 1126 |
| #1     | 0.2280   | 190  | 19    | 1000    | -0.025        | 1000 | 10.00    | 1134 |
| 5.80mm | 0.2283   | 190  | 19    | 1000    | -0.025        | 1000 | 10.00    | 1135 |
| 5.85mm | 0.2302   | 190  | 19    | 1000    | -0.025        | 1000 | 10.00    | 1144 |
| 5.90mm | 0.2323   | 190  | 19    | 1000    | -0.025        | 1000 | 10.00    | 1155 |
| A      | 0.2340   | 190  | 19    | 1000    | -0.025        | 1000 | 10.00    | 1163 |
| 5.95mm | 0.2343   | 190  | 19    | 1000    | -0.026        | 1000 | 10.00    | 1165 |
| 15/64  | 0.2344   | 190  | 19    | 1000    | -0.026        | 1000 | 10.00    | 1165 |
| 6.00mm | 0.2362   | 190  | 19    | 1000    | -0.026        | 1000 | 10.00    | 1174 |
| B      | 0.2380   | 200  | 20    | 1000    | -0.026        | 1000 | 10.00    | 1246 |
| 6.05mm | 0.2382   | 200  | 20    | 1000    | -0.026        | 1000 | 10.00    | 1247 |
| 6.10mm | 0.2402   | 200  | 20    | 1000    | -0.026        | 1000 | 10.00    | 1257 |
| C      | 0.2420   | 200  | 20    | 1000    | -0.026        | 1000 | 10.00    | 1266 |
| 6.15mm | 0.2421   | 200  | 20    | 1000    | -0.026        | 1000 | 10.00    | 1267 |
| 6.20mm | 0.2441   | 200  | 20    | 1000    | -0.026        | 1000 | 10.00    | 1277 |
| D      | 0.2460   | 200  | 20    | 1000    | -0.026        | 1000 | 10.00    | 1287 |
| 6.25mm | 0.2461   | 200  | 20    | 1000    | -0.026        | 1000 | 10.00    | 1288 |
| 6.30mm | 0.2480   | 200  | 20    | 1000    | -0.026        | 1000 | 10.00    | 1298 |
| 6.35mm | 0.2500   | 200  | 20    | 1000    | -0.027        | 1000 | 10.00    | 1308 |
| 6.40mm | 0.2520   | 200  | 20    | 1000    | -0.027        | 1000 | 10.00    | 1319 |
| 6.50mm | 0.2559   | 200  | 20    | 1000    | -0.027        | 1000 | 10.00    | 1339 |
| F      | 0.2570   | 200  | 20    | 1000    | -0.027        | 1000 | 10.00    | 1345 |
| 6.60mm | 0.2598   | 200  | 20    | 1000    | -0.027        | 1000 | 10.00    | 1360 |
|        |          |      |       |         |               |      |          |      |

In some cases, there may be an opportunity to increase the chipload based on the application's robustness. Variables such as machine technology and condition, stack support materials, and Tycom design selection may allow the increased throughput with

higher chiploads. Multiply the recommended chipload by 1.15 to reach the higher chipload.

If the application is not as robust due to heavy glass, high copper content, tight annular ring requirements, or similar, multiply the recommended chipload by 0.85.

