

## FABRICATION GUIDELINES - MILLING

MATERIALS	END MILLING / SLOTTING				FACE MILLING (C2) CARBIDE TOOL		
	High Speed Steel (m <sup>2</sup> ,M7)	Dept of cut	Speed, Feet / Min.	Feed, In. / Tooth	Dept of cut	Speed, Feet / Min.	Feed, In. / Tooth
Delrin <sup>®</sup>	1/4"	.250	270-450	0.002	0.150	1300-1500	0.020
Delrin <sup>®</sup> AF Blend	1/2"	"	"	0.003	0.060	1500-2000	0.005
Nylon 101	3/4"	"	"	0.005			
Nylatron <sup>®</sup> GS Nylon	1",2"	"	"	0.008			
Nylatron <sup>®</sup> GSM	1/4"	.050	300-500	0.001			
Nylatron <sup>®</sup> NSM	1/2"	"	"	0.002			
MC <sup>®</sup> 901/ 907 Nylon	3/4"	"	"	0.004			
Polycarbonate	1/4"	.250	270-450	0.002	0.150	1300-1500	0.020
Polysulfone	1/2"	"	"	0.003	0.060	1500-2000	0.005
Ultem <sup>®</sup> 1000	3/4"	"	"	0.005			
Ultem <sup>®</sup> 2300	1",2"	"	"	0.008			
	1/4"	.050	300-500	0.001			
	1/2"	"	"	0.002			
	3/4"	"	"	0.004			
PEEK <sup>™</sup>	1/4"	.250	270-450	0.002	0.150	500-750	0.020
	1/2"	"	"	0.003	0.060	"	0.005
	3/4"	"	"	0.005			
	1",2"	"	"	0.008			
	1/4"	.050	300-500	0.001			
	1/2"	"	"	0.002			
	3/4"	"	"	0.004			
Techtron <sup>®</sup> PPS	1/4"	.250	270-450	0.002	0.150	1300-1500	0.020
Ryton <sup>®</sup> PPS	1/2"	"	"	0.003	0.060	1500-2000	0.005
	3/4"	"	"	0.005			
	1",2"	"	"	0.008			
	1/4"	.050	300-500	0.001			
	1/2"	"	"	0.002			
	3/4"	"	"	0.004			
Torlon <sup>®</sup> PAI	1/4"	.250	270-450	0.002	0.035	500-800	.006 - .035
	1/2"	"	"	0.003			
	3/4"	"	"	0.005			
	1",2"	"	"	0.008			
	1/4"	.050	300-500	0.001			
	1/2"	"	"	0.002			
	3/4"	"	"	0.004			
Ertalyte <sup>®</sup> PET-P	1/4"	.250	270-450	0.002	0.150	1300-1500	0.020
Ertalyte <sup>®</sup> TX	1/2"	"	"	0.003	0.060	1500-2000	0.005
Hydex <sup>®</sup> 4101 PBT-P	3/4"	"	"	0.005			
	1",2"	"	"	0.008			
	1/4"	.050	300-500	0.001			
	1/2"	"	"	0.002			
	3/4"	"	"	0.004			
Duratron <sup>®</sup> XP	1/4"	.50	450-650	0.005	0.050	450-650	0.005 - .010
Vespel <sup>®</sup> PI	1/2"	"	"				
Celazole <sup>®</sup> PBI	3/4"	"	"				
	1",2"	"	"				
	1/4"	.015	250-350	0.002	0.015	250-350	.002-.006
	1/2"	"	"				
	3/4"	"	"				

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