

FABRICATION GUIDELINES - MILLING

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