

FABRICATION GUIDELINES - SAWING

MATERIALS	SAWING			
	Material Thickness	Tooth Form	Pitch Teeth / In.	Brand Speeds Ft. / Min.
Delrin® Delrin® AF Nylon 101 Nylatron® GS Nylon Nylatron® GSM MC® 901/ 907 Nylon	<1/2" 1/2" - 1" 1" - 3" 3 "	Precision " Butress "	10 -14 6 3 "	3,000 2,500 2,000 1,500
Polycarbonate Polysulfone Ultem® 1000 Ultem® 2300	<1/2" 1/2" - 1" 1" - 3" 3 "	Precision " Butress "	10 -14 6 3 "	4,000 3,500 3,000 2,500
PEEK™	<1/2" 1/2" - 1" 1" - 3" 3 "	Precision " Butress "	8 -14 6 - 8 3 "	4,000 3,500 3,000 2,500
Techtron® PPS Ryton® PPS	<1/2" 1/2" - 1" 1" - 3" 3 "	Precision " Butress "	8 -14 6 - 8 3 "	5,000 4,300 3,500 3,000
Torlon® PAI	<1/2" 1/2" - 1" 1" - 3" 3 "	Precision " Butress "	8 -14 6 - 8 3 "	5,000 4,300 3,500 3,000
Ertalyte® PET-P Ertalyte® TX Hydex® 4101 PBT-P	<1/2" 1/2" - 1" 1" - 3" 3 "	Precision " Butress "	10 -14 6 3 "	5,000 4,300 3,500 3,000
Duratron® XP Vespel® PI Celazole® PBI	3/8" - 1" 1" - 2"	Precision " Butress "	10 10	3,000 1,500