



**DRAKE**  
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## **MACHINING GUIDELINES FOR TORLON PRODUCTS**

### **FACE MILLING**

<b>DEPTH OF CUT:</b>	<b>SPEED (In/ Min.)</b>	<b>FEED (In/ Tooth)</b>
0.035"	500 TO 800	.006-.035

### **END MILLING**

<b>TOOL SIZE</b>	<b>DEPTH OF CUT</b>	<b>SPEED</b>	<b>FEED IN./ TOOTH</b>
1/4	.250"	270-450 FT/ MIN.	.002"
1/2	.250"	270-450 FT/ MIN.	.003"
3/4	.250"	270-450 FT/ MIN.	.005"
1.0	.250"	270-450 FT/ MIN.	.008"
1/4	.050"	300-500 FT/ MIN.	.001"
1/2	.050"	300-500 FT/ MIN.	.002"
3/4	.050"	300-500 FT/ MIN.	.004"

### **SAWING**

CIRCULAR SAW:	CARBIDE BLADE, 3-4000 RPM
BAND SAW:	BI METAL BLADE, 3-4000 FEET/ MIN.

### **TURNING**

<b>DEPTH OF CUT</b>	<b>SPEED</b>	<b>FEED IN./ REV.</b>
.025"	300-800 FT/ MIN.	.004-.025

### **DRILLING**

<b>HOLE DIAMETER</b>	<b>FEED IN/ REV.</b>
.0625"	.007
.125"	.010
.250"	.012
.500"	.015
.750" up	.020

NOTE: PCD Coated Carbide or sharp Carbide tools are recommended for optimal results