



DRAKE
PLASTICS LLC CO.

MACHINING GUIDELINES FOR TORLON PRODUCTS

FACE MILLING

DEPTH OF CUT	SPEED (IN/MIN.)	FEED (IN/TOOTH)
0.035"	500 TO 800	.006 - .035"

END MILLING

TOOL SIZE	DEPTH OF CUT	SPEED	FEED IN/TOOTH
¼	.250"	270-450 FT/MIN.	.002"
½	.250"	270-450 FT/MIN.	.003"
¾	.250"	270-450 FT/MIN.	.005"
1.0	.250"	270-450 FT/MIN.	.008"

SAWING

CIRCULAR SAW:	CARBIDE BLADE, 3000-4000 RPM
BAND SAW:	BI METAL BLADE, 3000-4000 FEET/MIN.

TURNING

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

DRILLING

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

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