



DRAKE
PLASTICS LLC CO.

MACHINING GUIDELINES FOR PEEK PRODUCTS

FACE MILLING

DEPTH OF CUT	SPEED (IN/MIN.)	FEED (IN/TOOTH)
0.060"	500 TO 700	.010 - .040"

END MILLING

TOOL SIZE	DEPTH OF CUT	SPEED	FEED IN/TOOTH
¼	.150"	500-600 FT/MIN.	.002"
½	.150"	500-600 FT/MIN.	.003"
¾	.150"	500-600 FT/MIN.	.005"
1.0	.150"	500-600 FT/MIN.	.008"
¼	.050"	500-600 FT/MIN.	.001"
½	.050"	500-600 FT/MIN.	.002"
¾	.50"	500-600 FT/MIN.	.004"

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
.030"	500-800 FT/MIN.	.004-.015

DRILLING

HOLE DIAMETER	FEED IN/REV
.0625"	.005
.125"	.005
.250"	.005
.500"	.008
.750" up	.010

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

