

MACHINING GUIDELINES FOR CASTOMID®



Machining Guidelines



Mechanische Fertigungsrichtlinien



Indications pour l'usage

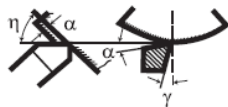


Indicaciones para el trabajo a maquina



Indicazioni di lavorazione

Turning



TURNING	DAS DREHEN	TOURNAGE	TORNO	TORNITURA	PA6
α Side Relief Angle °	α der Seitenfreiwinkel °	α Angle latéral de soulagement °	α Angulo del relieve lateral °	α Angolo laterale di rilievo °	α 6 - 10
γ Rake Angle °	γ der Spanwinke °	γ Angle de râtelier °	γ Angulo del rastrillo °	γ Angolo del rastrello °	γ 0 - 5
η Side Cutting Edge Angle °	η der Seitenschneidewinkel °	η Angle latéral de tranchant ou coupe °	η Angulo del filo de corte lateral °	η Angolo laterale del filo di lama °	η 45 - 60
v Cutting Speed m/min	v die Schreidgeschwindigkeit m/min	v Vitesse du coupe m/min	v Velocidad de corte m/min	v Velocità di taglio m/min	v 200 - 500
s Feed mm/rev	s der Vorschub mm/rev	s Alimentation mm/rev	s Alimentación mm/rev	s Alimentazione mm/rev	s 0.1 - 0.5
Peak Radius r to be min. 0.5mm	der Scheitelradius r ist min 0.5mm	Radio Peak doit tenir un min. 0.5mm	Radio Peak debe tener un mínimo de 0.5mm	Raggio peak (r) da essere min. 0.5mm	

Milling



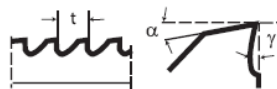
MILLING	DAS FRÄSEN	FRAISAGE	FRESADO	FRESATURA	PA6
α Relief Angle °	α der Freiwinkel °	α Angle de soulagement °	α Angulo del relieve °	α Angolo di rilievo °	α 10 - 20
γ Rake Angle °	γ der Spanwinkel °	γ Angle de râtelier °	γ Angulo del rastrillo °	γ Angolo del rastrello °	γ 5 - 15
v Cutting Speed m/min	v die Schreidgeschwindigkeit m/min	v Vitesse du coupe m/min	v Velocidad de corte m/min	v Velocità di taglio m/min	v <0.05 - 500
s Feed mm/tooth	s der Vorschub mm/tooth	s Alimentation mm/tooth	s Alimentación mm/tooth	s Alimentazione mm/tooth	s 250 - 500

Drilling



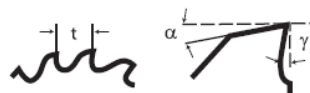
DRILLING	DAS BOHREN	PERCEUSE	PERFORADO	FORATURA	PA6
α Side Relief Angle °	α der Seitenfreiwinkel °	α Angle latéral de soulagement °	α Angulo del relieve lateral °	α Angolo laterale di rilievo °	α 15 - 15
γ Rake Angle °	γ der Spanwinkel °	γ Angle de râtelier °	γ Angulo del rastrillo °	γ Angolo del rastrello °	γ 10 - 20
ϕ Top Angle °	ϕ der Anschlagwinkel °	ϕ Angle supérieur °	ϕ Angulo superior °	ϕ Angolo superiore °	ϕ 90
v Cutting Speed m/min	v die Schreidgeschwindigkeit m/min	v Vitesse du coupe m/min	v Velocidad de corte m/min	v Velocità di taglio m/min	v 50 - 150
s Feed mm/rev	s der Vorschub mm/rev	s Alimentation mm/rev	s Alimentación mm/rev	s Alimentazione mm/rev	s 0.1 - 0.3

Belt Saw



BELT SAW	DIE BANDSÄGE	SCIER DE CEINTURE	SIERRA DE CINTA	SEGA A NASTRO	PA6
α Relief Angle °	α der Freiwinkel °	α Angle de soulagement °	α Angulo del relieve °	α Angolo di rilievo °	α 25 - 40
γ Rake Angle °	γ der Spanwinkel °	γ Angle de râtelier °	γ Angulo del rastrillo °	γ Angolo del rastrello °	γ 0 - 8
t Pitch mm	t die Neigung mm	t Lancement mm	t Paso mm	t Passo mm	t 4 - 10
v Cutting Speed m/min	v die Schreidgeschwindigkeit m/min	v Vitesse du coupe m/min	v Velocidad de corte m/min	v Velocità di taglio m/min	v 50 - 500

Circular Saw



CIRCULAR SAW	DIE KREISSÄGE	SCIER CIRCULAIRE	SIERRA CIRCULAR	SEGA CIRCOLARE	PA6
α Relief Angle °	α der Freiwinkel °	α Angle de soulagement °	α Angulo del relieve °	α Angolo di rilievo °	α 10 - 15
γ Rake Angle °	γ der Spanwinkel °	γ Angle de râtelier °	γ Angulo del rastrillo °	γ Angolo del rastrello °	γ 0 - 15
t Pitch mm	t die Neigung mm	t Lancement mm	t Paso mm	t Passo mm	t 8 - 45

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