

Machining Tips for Vespel® CR-6100

Some key points to remember

Customers have asked us if there is a summary of the online machining guide for Vespel® CR-6100. What if you just need to convey the key points to your machinist?

Here are the basics--tooling, speed, and feed rates:

- Tooling to be used: PCD (polycrystalline diamond) recommended
- Machining speed not to exceed: 1000 rpm
- Feed rate not to exceed: If the tool radius is 0.2 mm (0.008"), then the max feed rate is 0.04 mm (0.0015")/revolution. If the tool radius is 0.4 mm (0.016") then the max feed is 0.07 mm (0.003")/revolution.
- No coolant required



Vespel® CR-6100 comes off the tool like a ribbon of tape during machining

Vespel® CR-6100 is very easy to machine and install, so there is a significant latitude of practices which will work. If your shop has been machining Vespel® CR-6100 for many years, we would love to hear your input on what works for you.

Until Next Time

Vespel® CR-6100 can be used in nearly all process chemicals from cryogenic temperatures to 260 C (500 F). PSS has a wide range of sizes of Vespel® CR-6100 in stock available for immediate shipment. If you don't have an on-site machine shop or you just prefer to purchase parts, PSS can supply machined parts in a matter of days. Contact us today with your process conditions and dimensions and we can supply a quote.

Finally, for all of our American friends and colleagues, Happy Thanksgiving.