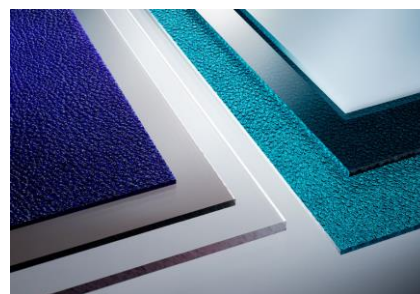


marlon fs

Machining: Cutting & Drilling



Cutting

MARLON FS/FSX is easy to saw and cut on standard workshop equipment. It can be machined on conventional milling machines with standard high speed tools. Notches adversely affect the mechanical properties of polycarbonate and should be avoided.

Recommendations	Circular Saw	Band Saw	Milling Machine
Clearance Angle	20 – 30°	20 – 30°	20 – 25°
Rake Angle	15°	0 – 5°	0 – 5°
Cutting Speed	1800 – 2400 m/min	600 – 1000 m/min	100 – 500 m/min
Feed Speed	19 – 25 m/min	19 – 25 m/min	0.1 – 0.5 mm/rev
Tooth Spacing	2 – 5 mm	1.5 - 2.5 mm	-

Drilling

Any commercially available metal drill without a specially ground bit is suitable for use with **MARLON FS**.

Parameter	Value
Clearance Angle	5 – 8°
Tip Angle	90 – 130°
Helix angle	Ca 30°
Rake Angle	3 – 5°
Cutting Speed	0.1 – 0.5 mm/rpm
Drill Tip Speed	10 – 60 m/min

The following point should be observed when drilling MARLON FS:

- Do not use cutting oils
- Use a new drill that has not been used for drilling other materials
- The sheet may break as a result of notching
- Do not countersink fixings
- Fixing threads should only be used if there is no alternative
- The hole should be at least 1.5 x hole diameter from the edge of the sheet.
- The hole diameter should be 6mm larger than the fixing shank diameter for sheets up to 2m and an additional 3mm per metre length thereafter.



Access Plastics Ltd., pursues a policy of continuous product development and reserves the right to amend specifications without notice.

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