

Guide to machining plastic parts

Imperial system



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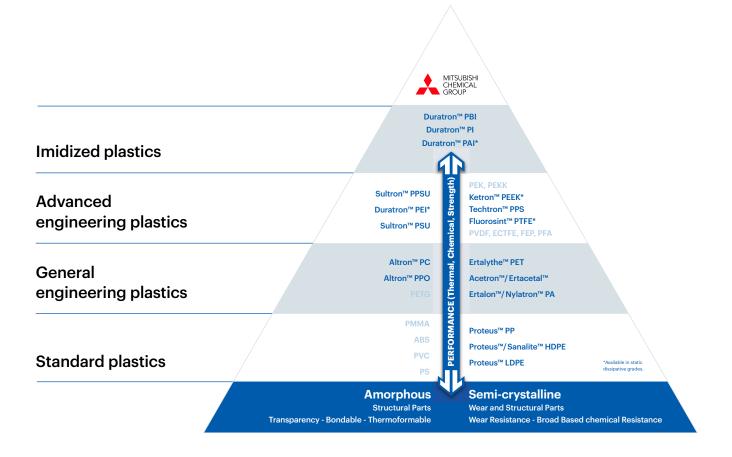
Machining plastics vs. metals

For their mechanical, chemical, and lightweight properties, plastics are increasingly replacing metals in a wide range of engineering applications. Many of the same machining methods used to fabricate metal parts are also used for plastics; however, best practices for machining plastics differ considerably.

Plastics exhibit a number of properties that influence machining procedures, including:

- Thermal expansion of plastics is up to 10 times higher than that of metals.
- Plastics lose heat more slowly than metals, increasing the risk ofl local overheating.
- Softening and melting temperatures of plastics are much lower than metals.
- Plastics are much more elastic than metals.

From material selection to proper tooling, from feed rates to stabilizing methods, part producers must weigh a range of factors in order to achieve good results when machining plastics. The following guidelines cover the most common plastic machining methods and provide useful tips and data for working with engineering polymers from Mitsubishi Chemical Group.



Plastic machining processes

This section covers the most common methods of machining plastic engineering components, providing guidelines and tips to achieve the best results with each.

Proper machining is crucial to achieving part dimensions and performance. Improper machining can create stress within the finished part, negatively impacting its mechanical properties and risking premature part failure.

Threading and tapping

What is threading? What is tapping?

Tapping and threading are two machining methods used to produce screw threads. Threading is the process of using a die tool to carve external threads, where tapping is the process of using a tap tool to create threads on the inside of a drilled hole.

Threading and tapping with plastic vs. metal

A primary consideration when threading and tapping plastic is that plastics are more notch-sensitive than metals. Some polymer materials may tear during threading, especially in fine pitch procedures.

Threading tips for plastic

Threading plastic should be done by single point using a carbide insert, taking four to five 0.001" passes at the end. Coolant usage is suggested.

Tapping tips for plastic

When tapping plastic, use the specified drill with a two-flute tap. Keep the tap clean of chip build-up. Use of a coolant during tapping is also suggested.

Common causes of machined-in stress include:

- Using dull or improperly designed tooling.
- Excessive heat generated from inappropriate speeds and feed rates.
- Machining away large volumes of material, usually from one side of the stock shape.

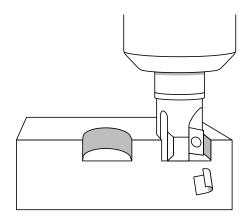
Milling

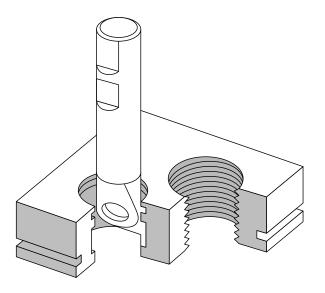
What is milling?

Milling is a machining method that applies a highspeed cylindrical cutting tool to a stationary plastic shape, moving the cutter on an axis to subtract from the shape in different directions. Computerized numerical control (CNC) milling increases the accuracy and efficiency of plastic milling.

Milling plastic vs. metal

When milling plastic, it is crucial to properly stabilize the part on the worktable and minimize vibrations from the high-speed cutting tool – these may result in chatter marks and decreased accuracy due to the shape wandering.





Milling tips for plastic

- Climb milling, also known as down milling, is recommended over conventional milling.
- Sufficient fixturing on the mill bed allows fast table travel and high spindle speeds.
- The shape should not be fixed too tightly, however, as it may deform or spring.
- When face milling, use positive geometry cutter bodies.

End milling/slotting guidelines

MATERIAL TYPES	RECOMMENDED CARBIDE	DEPTH OF CUT	SPEED (FT./MIN)	FEED (IN./TOOTH)
TIVAR [™] UHMW-PE, Nylatron [™] / Ertalon [™] PA6, Acetron [™] / Ertacetal [™] POM-H, Proteus [™] PP, Altron [™] PC, Sultron [™] PSU & PPSU, Ertalyte [™] PET, Ketron [™] PEK, Techtron [™] PPS, Fluorosint [™] PTFE, Duratron [™] PEI, Duratron [™] PAI, Duratron [™] PI	1/4", 1/2", 3/4", 1", 2" 1/4", 1/2", 3/4"	0.250 0.050	270-450 300-500	0.002, 0.003, 0.005 0.008, 0.001, 0.002, 0.004
Duratron™ PBI	1/4", 1/2", 3/4", 1", 2" 1/4", 1/2", 3/4"	0.015	250-350	0.002
Fluorosint™ MT-01 PTFE		*Contact our Techn	iical Services team	for advice

Face milling guidelines (C-2, carbide tool)

MATERIAL TYPES	RECOMMENDED CARBIDE	DEPTH OF CUT	SPEED (FT./MIN)	FEED (IN./TOOTH)
TIVAR [™] UHMW-PE, Nylatron [™] / Ertalon [™] PA6, Acetron [™] / Ertacetal [™] POM-H, Proteus [™] PP, Altron [™] PC, Sultron [™] PSU & PPSU, Duratron [™] PEI		0.150 0.060	1300-1500 1500-2000	0.020 0.005
Ertalyte™ PET	1/4", 1/2", 3/4", 1", 2" 1/4", 1/2", 3/4"	0.250 0.050	270-450 300-500	0.002, 0.003, 0.005 0.008, 0.001, 0.002, 0.004
Ketron™ PEEK		0.150 0.060	500-750	0.020 0.005
Fluorosint™ PTFE		0.150 0.060	500-700 550-750	0.010 0.005
Techtron™ PPS		0.150 0.060	1300-1500 1500-2000	0.020 0.005
Duratron™ PAI & PI		0.035	500-800	00.6-0.35
Duratron™ PBI	1/4", 1/2", 3/4", 1", 2" 1/4", 1/2", 3/4"	0.015	250-350	0.002
Fluorosint™ MT-01 PTFE		*Contact our Tech	nical Services team	n for advice

Sawing

What is sawing?

Sawing is a machining method that involves cutting a material into multiple pieces using a bandsaw, table saw, or other specialized equipment.

Sawing plastic vs. metal

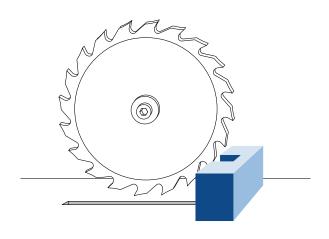
The primary difference between sawing plastic vs. metal is that the heat generated by the saw blade can negatively impact the plastic parts due to lower softening and melting temperatures. It is crucial to account for the speed of the blade, the thermal properties of the material, and the thickness of the shape when sawing plastic.

Tips for selecting a saw tool

- Band saws are versatile and perform well for straight, continuous curves, and irregular cuts.
- Table saws are convenient for straight cuts and can be used to cut multiple thicknesses and thicker cross sections up to 4" with adequate horsepower.

Tips for selecting a saw blade

- Rip and combination blades with a 0° tooth rake and 3° to 10° tooth set are best for general sawing in order to reduce frictional heat.
- Hollow ground circular saw blades without set will yield smooth cuts up to 3/4" thickness.
- Tungsten carbide blades wear well and provide optimum surface finishes.



Sawing guidelines (C-2, carbide tool)

MATERIAL TYPES	MATERIAL THICKNESS	BAND SPEEDS FT./MIN	PITCH TEETH/IN.	TOOTH FORM
TIVAR™ UHMW-PE,	<.5"	3000	10-14	Precision
Ertalon™ / Nylatron™ PA6,	.5"-1.0"	2500	6	FIECISION
Ertacetal [™] / Acetron [™] POM-H,	1.0"-3.0"	2000	3	Buttress
Ertalyte™ PET	>3.0"	1500	3	Dutticoo
Proteus™ PP,	<.5"	4000	10-14	Precision
Altron™ PC,	.5"-1.0"	3500	6	Precision
Sultron™ PSU & PPSU,	1.0"-3.0"	3000	3	Buttress
Duratron™ PEI	>3.0"	2500	3	Dutticss
	<.5"	4000	8-14	Precision
<pre>Ketron™ PEEK</pre>	.5"-1.0"	3500	6-8	Precision
RELIGIT PEEK	1.0"-3.0"	3000	3	Buttress
	>3.0"	2500	3	Duttiess
	<.5"	3000	8-14	Precision
-luorosint™ PTFE,	.5"-1.0"	2500	6-8	Precision
Techtron™ PPS	1.0"-3.0"	2000	3	Buttress
	>3.0"	1500	3	Dutticss
	<.5"	5000	8-14	Precision
Duratron™ PAI & PI	.5"-1.0"	4300	6-8	FIECISION
	1.0"-3.0"	3500	3	Buttress
	>3.0"	3000	3	Datacos
	<.375"-1.0"	3000	10	Precision
Duratron™ PBI	1.0"-2.0"	1500	10	Buttress
Fluorosint™ MT-01 PTFE		*Contact our Technical	Services team fo	r advice

Drilling and boring

What is drilling? What is boring?

Drilling is a machining method that creates cylindrical holes and throughholes by means of a pointed helical tool. Boring is a secondary process for enlarging or finishing drilled holes.

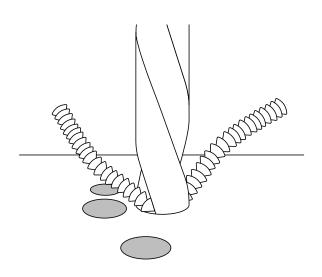
Drilling and boring plastic vs. metal

The heat insulating characteristics of plastics require consideration during drilling operations, especially when the depth of the hole is greater than twice its diameter. Excessive heat build-up may result in chipping, rough surfaces, and inadequate tolerances.

Drilling tips for plastic

For small diameter holes (1/32" to 1")

- High-speed steel twist drills are generally sufficient.
- Frequent pullout (peck drilling) is suggested to improve swarf removal.
- A slow spiral (low helix) drill will allow for better swarf removal. For large diameter holes (1" and greater).
- A slow spiral (low helix) drill or general-purpose drill bit ground to a 118° point angle with 9° to 15° lip clearance is recommended. The lip rake should be ground (dubbed off) and the web thinned.
- Avoid hand feeding drill grabbing can result in microcracks.
- It is generally best to drill a pilot hole (maximum



1/2" diameter) using 600 to 1,000 rpm and a positive feed of 0.005" to 0.015" per revolution.

- Secondary drilling at 400 to 500 rpm at 0.008" to 0.020" per revolution is required to expand the hole to larger diameters.
- For especially notch-sensitive materials (such as Ertalyte[™] PET and glass reinforced materials).
- A two-step process involving both drilling and boring minimizes heat build-up and reduces the risk of cracking.
- First, drill a 1" diameter hole using an insert drill at 500 to 800 rpm with a feed rate of 0.005" to 0.015" per revolution.
- Next, bore the hole to final dimensions using a boring bar with carbide insert with 0.015" to 0.030" radii at 500 to 1,000 rpm and a feed rate of 0.005" to 0.010" per revolution.

Drilling guidelines (C-2, carbide tool)

MATERIAL TYPES	NOMINAL HOLE DIAMETER	FEED IN./REV.	
TIVAR™ UHMW-PE, Ertalon™ / Nylatron™ PA6, Ertacetal™ / Acetron™ POM-H	1/16" to 1/4" 1/2" to 3/4" 1" to >2"	.007015 .015025 .020050	
Proteus [™] PP, Altron [™] PC, Sultron [™] PSU & PPSU, Duratron [™] PEI	1/16" to 1/4" 1/2" to 3/4" 1" to >2"	.007015 .015025 .020050	
Ertalyte™ PET	1/16", 1/8", 1/4" 1/2", 3/4" 1", 1-1/2", 2", >2"	.002005 .015025 .020050	
Ketron™ PEEK, Fluorosint™ PTFE, Techtron™ PPS, Duratron™ PAI & PBI	1/16", 1/8", 1/4" 1/2", 3/4" 1", 1-1/2", 2", >2	.007015 .015025 .020050	
Duratron [™] PBI	1/2″ or larger	.015025	
Fluorosint™ MT-01 PTFE	*Contact our Technical Services team for advice		

Turning

What is turning?

Turning is a machining process in which a plastic shape is rotated around a stationary lathe. Turning is especially useful for machining parts that are symmetrical along a common rotational axis.

Turning plastic vs. metal

As with other plastic machining processes, turning generates heat. In order to prevent damage to a plastic part, rotation speed, tool selection, and coolants should all be considered carefully along with the thermal properties of the material.

Turning tips for plastic

- Turning operations require inserts with positive geometries and ground peripheries.
- Ground peripheries and polished top surfaces generally reduce material build-up on the insert, improving the attainable surface finish.
- A fine-grained C-2 carbide is often recommended for plastic turning operations.

Turning guidelines (C-2, carbide tool)

MATERIAL TYPES	DEPTH OF CUT (IN.)	SPEED (FT./MIN)	FEED (IN./TOOTH)
TIVAR [™] UHMW-PE, Nylatron [™] / Ertalon [™] PA6, Acetron [™] / Ertacetal [™] POM-H, Proteus [™] PP, Altron [™] PC, Sultron [™] PSU & PPSU, Duratron [™] PEI, Ertalyte [™] PET	0.150 0.025	500-600 600-700	.010015 .004007
Ketron™ PEEK	0.150 0.025	350-500 500-600	.010015 .003008
Fluorosint™ PTFE	0.150 0.025	600-1000 600-700	.010016 .004007
Techtron™ PPS	0.150 0.025	100-300 250-500	.010020 .005010
Duratron [™] PAI & PI	0.025	300-800	.004025
Duratron™ PBI	0.025	150-225	.002006

Additional treatments

Depending on the requirements for the part and machining process, coolants and/or annealing may be recommended in order to improve the finished results. This section covers the use of coolants and annealing, as applicable in machining plastic parts.

Coolants

What are coolants?

Coolants reduce the build-up of localized frictional heat, thus improving the machining results and extending the life of the tool. There are several types of coolants commonly used when machining engineering plastics, including pressurized air, dry ice, spray mists, and specially developed cooling agents.

When are cooling agents recommended?

Coolants are not necessary for most machining practices and most engineering plastics.

However, we recommend coolants in the following cases:

- When drilling or parting-off plastics two processes that generate high frictional heat.
- When machining especially notch-sensitive materials, such as Ertalyte[™] PET, Duratron[™] PAI, Duratron[™] PBI, and glass- or carbon-reinforced products.
- When it is necessary to achieve optimum surface finishes and close tolerances.

Annealing

What is annealing?

Annealing is a heat treatment process that improves the physical properties of a plastic, increasing its ductility and reducing its hardness to make the shape easier to machine. Annealing helps to relieve internal pressure from within the plastic, giving a machined part higher dimensional stability over time. The annealing process involves heating a plastic shape to half its melt temperature for a determined period and letting it cool at a specific rate.

Tips for selecting a coolant

- Spray mists and pressurized air are very effective means of cooling the cutting interface.
- General purpose petroleum-based cutting fluids, although suitable for many metals and plastics, may contribute to stress cracking of amorphous plastics such as Altron[™] PC, Sultron[™] PSU, Sultron[™] PPSU, and Duratron[™] U1000 PEI.
- Two flood coolants suitable for most plastics are Trim E190 and Tim Sol LC SF.

Annealing pre-machining

All plastic stock shapes from Mitsubishi Chemical Group are annealed using a proprietary stress relieving cycle that minimizes any internal stresses that may have resulted from the manufacturing process. This ensures that the material will remain dimensionally stable during and after machining.

Annealing post-machining

Few machined plastic parts require annealing after machining to meet dimensional or performance requirements; however, post-machining annealing does have several benefits, including:

- Improved chemical resistance PC, PSU, and PEI materials can benefit from post-machining annealing to reduce stress crazing.
- Better flatness, tighter tolerances Extremely close-tolerance parts requiring precision flatness and non-symmetrical contours sometimes require intermediate annealing between machining operations.
- High pressure velocity and low wear PAI Extruded or injection-molded Duratron[™] PAI parts requiring high pressure velocities or the lowest possible wear factor benefit from an additional cure after machining. This curing process optimizes the wear properties. Only PAI benefits from such a cycle.

Tips for annealing plastics

- Improved flatness can be attained by rough machining, annealing, and finish machining with a very light cut.
- To reduce the potential for machined-in stress, review the fabrication guidelines for the specific material. Note that guidelines change as the material type changes.
- Ensure parts are fixtured to the necessary shape or flatness to prevent distortion. Do not unfix until the parts have completed the entire cycle and are cool to the touch.
- Finish machining to critical dimensions should be performed after annealing.
- Changes in heat-up and hold time may be possible if cross sections are thin.

Post-machining air annealing guidelines

MATERIAL TYPES	HEAT UP	HOLD	COOL DOWN	ENVIRONMENT
Type 6 Nylons	4 hours to 300° F			Oil or Nitrogen
Type 6/6 Nylons, Ertalyte™ PET	4 hours to 350° F			On of Millogen
Ertacetal [™] C POM-C / Acetron [™] GP POM-C	4 hours to 310° F			
Ertacetal [™] / Acetron [™] POM-H	4 hours to 320° F	30 minutes per		Nitrogon or Air
Altron™ PC	4 hours to 275° F	1/4" thickness		Nitrogen or Air
Sultron [™] PSU & PPSU	4 hours to 330° F			
Duratron [™] PEI	4 hours to 390° F			
Techtron [™] PPS	4 hours to 350° F		50° F per hour	Air
Ketron™ PEEK	4 hours to 300° F 4 hours to 375° F	60 minutes per 1/4" thickness		
Duratron™ PAI	4 hours to 300° F 4 hours to 420° F 4 hours to 470° F	1 day		
	4 hours to 500° F	3 to 10 days		
Duratron™ PI	4 hours to 300° F 4 hours to 450° F 4 hours to 600° F	60 minutes per 1/4″ thickness		

Troubleshooting guidelines

Drilling troubleshooting

DIFFICULTY	COMMON CAUSE
Tapered hole	Incorrectly sharpened drill Insufficient clearance Feed too heavy
Burnt or melted surface	Wrong drill type Incorrectly sharpened drill Feed too light Dull drill Web too thick
Surface chipping	Feed too heavy Clearance too large Too much rake (thin web as described)
Chatter	Clearance too great Feed too light Drill overhang too large Too much rake (thin web as described)
Feed marks or spiral lines on inside diameter	Feed too heavy Drill not centered Drill ground not centered
Oversize holes	Drill ground not centered Web too thick Insufficient clearance Feed rate too heavy Point angle too great
Undersize holes	Dull drill Too much clearance Point angle too small
Holes not concentric	Feed too heavy Spindle speed too slow Drill enters next piece too far Cut-off tool leaves nib, deflecting drill Web too thick Drill speed too heavy at start Drill not mounted at center Drill not sharpened correctly
Burr at cut-off	Dull cut-off tool Drill does not pass completely through piece
Rapid dulling of drill	Feed too light Spindle speed too fast Insufficient lubrication from coolant

Turning and boring troubleshooting

DIFFICULTY	COMMON CAUSE
Melted surface	Too dull or heel rubbing Insufficient side clearance Feed rate too slow Spindle speed too fast
Rough finish	Feed too heavy Incorrect clearance angles Sharp point on tool (slight nose radius required) Tool not mounted at center
Burrs at edge of cut	No chamfer provided at sharp corners Dull tool Insufficient side clearance Lead angle not provided on tool (tool should ease out of cut gradually, not suddenly)
Cracking or chipping of corners	Too much positive rake on tool Tool not eased into cut (suddenly hits work) Dull tool Tool mounted below center Sharp point on tool (slight nose radius required)
Chatter	Too much nose radius on tool Tool not mounted solidly Material not supported properly Width of cut too wide (use two cuts)

Cutting off troubleshooting

DIFFICULTY	COMMON CAUSE
Melted surface	Dull tool Insufficient side clearance Insufficient coolant supply
Rough finish	Feed too heavy Tool improperly sharpened Cutting edge not honed
Spiral marks	Tool rubs during its retreat Burr on point of tool
Concave or convex surfaces	Point angle too large Tool not perpendicular to spindle Tool deflecting Feed too heavy Tool mounted from above or below center
Nibs or burrs at cut-off point	Point angle not large enough Dull tool Feed too heavy
Burrs on outside diameter	No chamber before cut-off diameter Dull tool

Appendix

Machinability ratings of advanced materials

Easy to machine	1	Ertacetal [™] C POM-C / Acetron [™] GP POM-C, Ertacetal [™] / Acetron [™] POM-H, Ertacetal [™] H-TF / Acetron [™] AF POM-H, Fluorosint [™] 500 PTFE, Fluorosint [™] 207 PTFE, Fluorosint [™] HPV PTFE, Nylatron [™] MC901 PA6 / Ertalon [™] 6PLA PA6, Nylatron [™] MC [™] 907 PA6, Nylatron [™] GS PA66, Nylatron [™] GSM PA6, Nylatron [™] 101 PA66 / Ertalon [™] 66 SA PA66
	2	Ertalyte™ PET, Ertalyte™ TX PET, Nylatron™ GSM Blue PA6, Nylatron™ NSM PA6, Altron™ 1000 PC
	3	Fluorosint™ MT-01 PTFE, Sultron™ PSU, Sultron™ PPSU, Techtron™ PPS
	5	Duratron™ T42O3 PAI, Duratron™ T43O1 PAI, Ketron™ 1000 PEEK, Techtron™ PSBG PPS
	6	Duratron™ T4501 PAI, Duratron™ T4503 PAI, Ketron™ HPV PEEK, Techtron™ HPV PPS
	7	Duratron™ U1000 PEI, Duratron™ U2300 PEI, Ketron™ GF30 PEEK
	8	Duratron™ T5530 PAI
Challenging to machine	10	Duratron™ CU60 PBI

Unit conversions

1/320.3120.7931/325.3121.4.333/640.4681.1903/645.4681.8.901/160.6251.5879/165.6251.2.275/640.7911.9843/7645.7911.6.643/320.9372.38119/325.93715.617/641.9932.7783/646.09315.787/641.9032.7783/646.09315.789/641.4063.5714.1646.09315.795/321.5623.9682/326.56216.681/641.7184.3654.1646.76117.0653/161.8754.76211/166.87517.46213/642.0315.1592.3/327.18718.65317/642.0315.5562.3/327.18718.65317/642.6566.74649/647.50119.05017/642.6567.4625.1643.1620.63717/643.2817.30713.168.1250.63717/643.9069.215.7648.9332.8283/83.759.5257/648.9062.2122.6443.9069.215.7648.9062.2122.7643.9069.215.7648.9062.2122.7644.5311.1096.1649.7532.3121.7644.9351.121.7663.7322.812 <t< th=""><th>FRACTION (IN.)</th><th>DECIMAL (IN.)</th><th>ММ</th><th>FRACTION (IN.)</th><th>DECIMAL (IN.)</th><th>ММ</th></t<>	FRACTION (IN.)	DECIMAL (IN.)	ММ	FRACTION (IN.)	DECIMAL (IN.)	ММ
3/64.0468.11903/5/64.5488.13.801/16.0625.1587.9/16.5625.12.875/64.0781.1984.3/64.5781.16.843/32.09372.381.19/32.5371.587/64.10932.778.3964.6093.5.781/8.125.3.175.662.6.68.6.715/32.1562.3.968.6.66.6.71.6.681/164.1718.3.65.4.764.6.781.1.7681/164.1875.4.762.1/16.6.781.1.7681/164.2031.5.556.2.32.7.187.1.8531/164.2343.5.554.4/64.7.31.1.8591/164.2554.5.564.7.343.1.8631/164.2564.6.746.7.31.1.8591/164.2564.6.746.7.31.1.8631/164.2512.7.143.5.614.7.614.9.6141/164.3.937.5.614.8.125.0.6131/164.3.937.5.254.7.644.8.93.2.2251/164.3.914.9.214.5.614.8.914.2.1341/124.3.937.9.21.5.644.8.914.2.1341/124.3.914.9.124.5.614.8.914.2.1341/142.3.914.9.124.5.614.8.914.2.1341/142.3.914.9.124.5.614.8.914.2.134 <td>1/64</td> <td>.0156</td> <td>0.396</td> <td>33/64</td> <td>.5156</td> <td>13.096</td>	1/64	.0156	0.396	33/64	.5156	13.096
1/16.06251.5879/16.562514.2875/64.07811.984.3764.57811.6843/32.0937.38119/32.593715.0817/64.1093.2778.9964.609315.4789/64.125.3175.58.62515.8759/64.1406.571.14/64.640616.2715/32.1562.368.11/6.6675.16.6811/64.1718.3656.4762.14/64.6875.176213/64.2031.5556.15/64.6675.176213/64.2031.5556.23/32.187.18531/4.250.6350.4764.7343.18531/4.250.6350.316.7464.750.19469/32.2812.7143.5764.8281.03441/12.3437.525.5764.8281.2014.172.3437.525.7464.8593.225.716.306.921.5764.8936.225.716.306.921.5764.8916.2018.717.4172.525.5764.8916.2172.718.306.921.5764.8916.2172.718.306.921.5764.8916.2172.716.4267.9164.9164.9164.2172.716.4267.9176.9164.9164.2172<	1/32	.0312	0.793	17/32	.5312	13.493
5/64.0781.1984.37/64.5781.14.644.3/32.0937.2,381.19/32.5937.15.081.7/64.1093.2,778.39/64.6093.15.478.7/84.125.3175.5/8.625.15.87.9/64.1406.5,711.4/64.6406.16.21.5/32.162.9.68.1/14.6406.16.21.5/32.162.9.68.1/16.6862.16.68.1/14.178.4.365.4/64.6781.17.65.1/16.1875.4.762.1/16.6875.17.65.1/14.2031.5.56.2/3/2.7.87.18.75.1/24.2433.5.56.2/3/2.7.87.18.55.1/14.250.5.56.2/3/2.7.81.18.55.1/14.250.6.350.3/4.7.50.19.650.1/14.250.6.350.3/4.7.50.19.650.1/14.250.7.14.2.51.1.42.1.42.1/14.250.7.14.2.12.1.42.1.42.1/14.2.12.7.14.2.12.1.42.1.42.1/14.2.12.7.14.2.12.1.42.1.42.1/14.2.14.7.14.2.14.1.42.1.42.1/14.2.14.7.14.2.14.1.42.1.42.1/14.2.14.7.14.2.14.2.14.1.42.1/14.2.14.7.14.2.14.2.	3/64	.0468	1.190	35/64	.5468	13.890
3/320.9372.38119/325.93715.0817/641.0932.77839/646.09315.4781/81.253.1755/86.2515.8759/641.4063.57141/646.40616.2115/321.5623.96821/326.56216.6681/1641.7184.36543/646.78117.653/161.8754.76211/166.87517.46213/642.0315.1594.7647.03118.5515/642.0315.5642.3/327.18718.5615/642.5326.3503/47.5019.05017/642.5036.3503/47.5019.05017/642.6666.74649/647.65619.4469/322.8127.1335.5645.7648.91219.63319/643.9217.5019.05013.1619.24219.34319/643.5939.2135.7648.9342.2252/643.9069.215.7648.9062.2213/83.759.5257.7648.9062.2111/324.06210.3182.9325.9643.9133.1511/644.21810.7155.9649.2183.1611.1521/644.53111.121.7163.9372.3122.3141/324.68711.121.7163.9312.4201/341.509<	1/16	.0625	1.587	9/16	.5625	14.287
76410932.77839/646.09315.4781/81253.1755/86.2515.8759/641.4063.5714/1646.40616.2715/321.5623.9684/1646.40616.2715/321.5623.9684/3646.78117.6553/161.7184.3654/3646.78117.6553/161.8754.7621/166.87517.46213/642.0315.5567.4627.03118.55917.842.3435.9534/647.03118.55917.442.506.3503/47.5019.65017.442.506.3503/47.5019.65017.442.6566.74649/647.61219.4669/322.8127.1435.5648.28110.34417.453.3257.51648.2812.04245/1643.9215.5648.9362.2252.7643.9069.215.7648.9062.22113/324.06210.3185.7648.9062.22113/324.06210.3185.7649.9163.9162.7643.9069.9215.7648.9062.22113/324.06210.3185.7649.9163.9162.7643.9369.9215.7649.9163.91613/244.6771.1125.7649.9163.91613/341.509 </td <td>5/64</td> <td>.0781</td> <td>1.984</td> <td>37/64</td> <td>.5781</td> <td>14.684</td>	5/64	.0781	1.984	37/64	.5781	14.684
1/81253.1755/86.2515.8759/641.4063.57141/646.40616.2715/321.5623.96821/326.56216.66811/641.7184.36543/646.78117.0553/161.8754.76211/166.87517.46213/64.20315.15945/647.03117.8597/32.21875.55623/327.18718.25615/64.23435.9534/64.74318.65317/44.2506.3503/4.75019.05017/64.26566.74649/64.765619.4469/32.2812.714351/64.828120.32419/64.32818.33453/648.28120.34711/2.34378.73155/648.59321.8283/8.3759.5257/848.9062.22525/64.39069.92157/648.9062.22513/32.406210.31859/64.91823.41813/32.406311.1259/64.9132.318229/64.453111.90613/32.968724.02915/24.468711.90613/32.968724.02915/24.468711.906.5764.96872.406915/24.468711.906.59/64.96872.318215/24.468711.906.59/64.96872.406	3/32	.0937	2.381	19/32	.5937	15.081
96414063.57141/646.40616.2715/3215623.96821/326.56216.66811/6417184.36543/646.78117.0553/1618754.76211/166.87517.46213/642.0315.15945/647.03118.55915/642.3435.95347/647.34318.65317/642.5566.3503/47.5019.66317/642.6566.74649/647.56619.4669/322.8127.14351/647.96820.24019/642.9687.54051/648.12520.63711/123.4378.33453/648.28120.63721/643.5939.12855/648.59321.22525/643.9069.2151/648.9062.22527/644.43711.11251/649.91623.41513/324.66210.31821.3251/648.9062.22127/644.51311.11251/649.91623.4153.41515/169.92151/649.92153/649.21823.41517/164.37511.11251/649.91623.4153.41517/164.51311.50951/649.93124.20915/244.68711.90651/649.68724.00915/244.68711.90651/649.68724.00915/24 <td>7/64</td> <td>.1093</td> <td>2.778</td> <td>39/64</td> <td>.6093</td> <td>15.478</td>	7/64	.1093	2.778	39/64	.6093	15.478
5/32 1562 3.968 21/32 6.562 16.668 11/64 1.718 4.365 43/64 6.781 17.065 3/16 1.875 4.762 11/16 6.875 17.462 13/64 2.031 5.159 45/64 .7031 17.859 7/32 2.187 5.556 23/32 .7187 18.553 15/64 2.343 5.953 47/64 .7343 18.653 17/64 2.556 6.766 49/64 .750 19.050 17/64 2.656 6.746 49/64 .756 19.466 9/32 2.812 7.143 25/32 .7812 19.833 19/64 2.968 7.540 51/64 .8281 20.240 5/16 3.325 7.937 13/16 .8281 20.240 11/32 3.437 8.334 .5/64 .8593 21.225 25/64 3.906 9.21 5/764 .8906 22.621	1/8	.125	3.175	5/8	.625	15.875
1/641/184.36543/646.678117.0653/161.8754.76211/166.87517.46213/642.0315.1594.564.003117.8597/322.1875.5562.3/32.18718.55315/642.3435.9534.764.734318.65317/64.2506.3503/4.75019.06017/64.26566.74649/64.765619.4469/32.2812.71435.5764.812519.84319/64.2968.75405.764.812520.63721/64.32818.3345.364.828121.34413/32.34379.252.787.859321.8283/8.3759.221.5764.890622.2527/64.421810.715.5964.9218.23.457/16.437511.12.5164.9315.23.8129/64.45311.509.5164.9218.23.8121/64.39069.21.5764.8906.22.6113/32.4687.1112.5964.918.23.8121/64.4375.1112.5164.9315.23.8121/64.4531.1509.51/64.9531.24.0615/20.4687.1509.51/64.9687.24.0621/64.4531.1509.51/64.9687.24.0621/64.4581.1509.51/64.9687	9/64	.1406	3.571	41/64	.6406	16.271
3/16 1875 4.762 $11/16$ 6875 17.462 $13/64$ 2031 5.159 $45/64$ $.0031$ 17.859 $7/32$ 2187 5.556 $23/32$ $.7187$ 18.256 $15/64$ 2343 5.953 $47/64$ $.7343$ 18.653 $17/4$ 250 6.350 $3/4$ $.750$ 19.666 $17/64$ $.2656$ 6.746 $49/64$ $.7656$ 19.466 $9/32$ $.2812$ $.7143$ $25/32$ $.7812$ 19.843 $19/64$ $.2968$ 7.540 $51/64$ $.7968$ 20.240 516 $.3125$ 7.937 $13/16$ $.8125$ 20.324 $11/32$ $.3437$ 8.334 $53/64$ $.8281$ 21.324 $23/64$ $.3593$ 9.128 $55/64$ $.8593$ 21.828 $3/8$ $.375$ 9.255 $7/8$ $.875$ 22.255 $25/64$ $.3906$ 9.214 $59/64$ $.9062$ 2.614 $13/22$ $.4062$ 10.318 $59/64$ $.9218$ 23.415 $7/16$ $.4375$ 11.12 $51/64$ $.9218$ 23.415 $7/164$ $.4531$ 1.509 $61/64$ $.9531$ 24.208 $15/24$ $.4687$ 1.906 $13/32$ $.9687$ 24.606 $31/44$ $.4843$ 1.203 $.63/64$ $.9843$ 2.606	5/32	.1562	3.968	21/32	.6562	16.668
13/64 2031 5.159 $45/64$ 7031 17.859 $7/32$ 2187 5.556 $23/32$ 7187 18.256 $15/64$ 2343 5.953 $47/64$ 7343 18.653 $1/4$ 250 6.350 $3/4$ 750 19.650 $17/64$ 2656 6.746 $49/64$ 7556 19.466 $9/32$ 2812 7143 $25/32$ 8125 19.466 $9/34$ 2968 7.540 $51/64$ 8125 20.637 $51/64$ 3281 8.334 $53/64$ 8.281 21.034 $11/32$ 3437 8.731 $27/32$ 8437 21.431 $23/64$ 3593 9.253 $7/8$ 8593 21.225 $25/64$ 3906 9.214 $51/64$ 8066 22.621 $13/32$ 4062 10.318 $29/32$ 9.062 23.018 $27/64$ 4218 10.715 $59/64$ 9.218 23.415 716 4375 11.12 $15/16$ 9.375 23.812 $29/64$ 4531 15.09 $61/64$ 9.531 24.606 $15/22$ 4687 11.906 $31/32$ 9.687 24.606 $31/44$ 8433 12.303 $63/64$ 9.843 25.007	11/64	.1718	4.365	43/64	.6781	17.065
7/32 .2187 5.556 23/32 .7187 18.256 15/64 .2343 5.953 47/64 .7343 18.653 1/4 .250 6.350 3/4 .750 19.050 17/64 .2656 6.766 49/64 .7656 19.446 9/32 .2812 .7143 25/32 .7812 19.843 19/64 .2968 .7540 51/64 .7968 20.200 5/16 .3125 .7937 13/16 .8125 20.637 21/64 .3281 8.334 53/64 .8281 21.034 11/32 .3437 8.731 27/32 .8437 21.431 23/64 .3593 9.128 55/64 .8593 21.828 3/8 .375 9.525 .786 .8006 22.621 13/32 .4062 10.318 29/32 .9062 23.018 27/64 .4218 10.715 59/64 .9218 23.415 7/16 .4335 11.12 15/16 .9375 23.812	3/16	.1875	4.762	11/16	.6875	17.462
15/64 $.2343$ 5.953 $47/64$ $.7343$ 18.653 $1/4$ $.250$ 6.350 $3/4$ $.750$ 19.050 $17/64$ $.2656$ 6.746 $49/64$ $.756$ 19.446 $9/32$ $.2812$ 7.143 $25/32$ $.7812$ 19.843 $19/64$ $.2968$ 7.540 $51/64$ $.7968$ 20.240 $51/64$ $.3125$ 7.937 $13/16$ $.8125$ 20.637 $21/64$ $.3281$ 8.334 $53/64$ $.8281$ 21.034 $11/32$ $.3437$ 8.731 $27/32$ $.8437$ 21.431 $23/64$ $.3593$ 9.128 $55/64$ $.8593$ 21.225 $25/64$ $.3906$ 9.214 $.57/64$ $.8906$ 22.621 $13/32$ $.4062$ 10.318 $29/32$ $.9062$ 23.018 $27/64$ $.4375$ 11.12 $15/16$ $.9218$ 23.415 $27/64$ $.4375$ 11.509 $61/64$ $.9531$ 24.209 $15/32$ $.4887$ 11.906 $31/32$ $.9687$ 24.606 $15/34$ $.4843$ 12.303 $.63/64$ $.9843$ $.250.026$	13/64	.2031	5.159	45/64	.7031	17.859
1/4 250 6.350 $3/4$ 750 19.050 $17/64$ 2656 6.746 $49/64$ 7656 19.466 $9/32$ 2812 7.143 $25/32$ 7812 18.843 $19/64$ 2968 7.540 $51/64$ $.7968$ 20.240 $51/6$ 3125 7.937 $13/16$ $.8125$ 20.637 $21/64$ 3281 8.334 $53/64$ $.8281$ 21.034 $11/32$ 3437 8.731 $27/32$ $.8437$ 21.431 $23/64$ 3593 9.525 $7/8$ $.8593$ 21.225 $27/64$ $.3906$ 9.214 $57/64$ $.8906$ 22.225 $27/64$ $.4218$ 10.715 $59/64$ $.9218$ 23.415 $7/16$ $.4375$ 11.12 $51/64$ $.9375$ 23.245 $27/64$ $.4531$ 1.509 $61/64$ $.9531$ 24.209 $15/32$ $.4687$ 11.906 $31/32$ $.9687$ 24.609 $31/4$ $.4843$ 12.303 $63/64$ $.9843$ 25.003	7/32	.2187	5.556	23/32	.7187	18.256
17/64 2656 6.746 $49/64$ 7.656 19.446 $9/32$ 2812 7.143 $25/32$ 7812 19.843 $19/64$ 2.968 7.540 $51/64$ 7968 20.240 $5/16$ 3125 7.937 $13/16$ 8125 20.347 $21/64$ 3281 8.334 $53/64$ 8281 21.034 $11/32$ 3437 8.731 $27/32$ 8437 21.431 $23/64$ 3593 9.128 $55/64$ 8593 21.225 $25/64$ 3906 9.214 $57/64$ 8906 22.225 $27/64$ 4218 10.715 $59/64$ 9.9218 23.415 $7/16$ 4375 11.12 $15/16$ 9.9218 23.415 $27/64$ 4218 10.715 $59/64$ 9.9218 23.415 $27/64$ 4531 11.509 $61/64$ 9.531 24.209 $15/32$ 4687 11.906 $31/32$ 9.687 24.609 $15/44$ 8433 12.303 $63/64$ 9.843 25.003	15/64	.2343	5.953	47/64	.7343	18.653
9/32 .2812 7.143 25/32 .7812 19.843 19/64 .2968 7.540 51/64 .7968 20.240 5/16 .3125 7.937 13/16 .8125 20.637 21/64 .3281 8.334 53/64 .8281 21.034 1/32 .3437 8.731 27/32 .8437 21.431 23/64 .3593 9.128 55/64 .8593 21.828 3/8 .375 9.525 7/8 .875 22.225 25/64 .3906 9.921 57/64 .8906 22.621 13/32 .4062 10.318 29/32 .9062 23.018 27/64 .4218 10.715 59/64 .9218 23.415 716 .4375 11.12 15/16 .9375 23.812 29/64 .4581 1.509 61/64 .9531 24.609 15/32 .4687 11.906 31/32 .9687 24.609 31/64 .4843 12.303 63/64 .9843 25.003 <td>1/4</td> <td>.250</td> <td>6.350</td> <td>3/4</td> <td>.750</td> <td>19.050</td>	1/4	.250	6.350	3/4	.750	19.050
19/64 2968 7.540 164 7.968 20.240 $5/16$ 3125 7.937 $13/16$ 8125 20.637 $21/64$ 3281 8.334 $53/64$ 8281 21.034 $11/32$ 3437 8731 $27/32$ 8437 21.431 $23/64$ 3593 9.128 $55/64$ 8593 21.828 $3/8$ 375 9.525 $7/8$ 875 22.225 $25/64$ 3906 9.921 $57/64$ 8906 22.621 $13/32$ 4062 10.318 $29/32$ 9062 23.018 $27/64$ 4218 10.715 $59/64$ 9.918 23.412 $7/64$ 4375 11.12 $59/64$ 9.918 23.412 $29/64$ 4531 11.509 $61/64$ 9.531 24.606 $31/32$ 4687 11.906 $31/32$ 9687 24.606 $31/64$ 8433 12.303 $63/64$ 9.843 25.003	17/64	.2656	6.746	49/64	.7656	19.446
5/16 .3125 7.937 13/16 .8125 20.637 21/64 .3281 8.334 53/64 .8281 21.034 11/32 .3437 8.731 27/32 .8437 21.431 23/64 .3593 9.128 55/64 .8593 21.828 3/8 .375 9.525 7/8 .875 22.225 25/64 .3906 9.921 57/64 .8906 22.621 13/32 .4062 10.318 29/32 .9062 23.018 27/64 .4218 10.715 59/64 .9218 23.415 716 .4375 11.112 15/16 .9375 23.812 29/64 .4531 11.509 61/64 .9531 24.606 31/32 .4687 11.906 31/32 .9687 24.606 31/64 .4833 12.303 63/64 .9843 25.003	9/32	.2812	7.143	25/32	.7812	19.843
21/64 .3281 8.334 53/64 .8281 21.034 11/32 .3437 8.731 27/32 .8437 21.431 23/64 .3593 9.128 55/64 .8593 21.828 3/8 .375 9.525 7/8 .875 22.225 25/64 .3906 9.921 57/64 .8906 22.621 13/32 .4062 10.318 29/32 .9062 23.018 27/64 .4218 10.715 59/64 .9218 23.415 7/16 .4375 11.112 15/16 .9218 23.415 15/32 .4687 11.906 31/32 .9687 24.608 15/32 .4687 11.906 31/32 .9687 24.608 31/64 .9364 .9843 25.003	19/64	.2968	7.540	51/64	.7968	20.240
11/32 .3437 8.731 27/32 .8437 21.431 23/64 .3593 9.128 55/64 .8593 21.828 3/8 .375 9.525 7/8 .875 22.225 25/64 .3906 9.921 57/64 .8906 22.621 13/32 .4062 10.318 29/32 .9062 23.018 27/64 .4218 10.715 59/64 .9218 23.415 7/16 .4375 11.112 15/16 .9375 23.812 29/64 .4531 11.509 61/64 .9531 24.606 31/32 .4687 11.906 31/32 .9687 24.606 31/64 .4843 12.303 63/64 .9843 25.003	5/16	.3125	7.937	13/16	.8125	20.637
23/64 .3593 9.128 55/64 .8593 21.828 3/8 .375 9.525 7/8 .875 22.225 25/64 .3906 9.921 57/64 .8906 22.621 13/32 .4062 10.318 29/32 .9062 23.018 27/64 .4218 10.715 59/64 .9218 23.415 7/16 .4375 11.112 15/16 .9375 23.812 29/64 .4531 11.509 61/64 .9531 24.209 15/32 .4687 11.906 31/32 .9687 24.606 31/64 .9304 .92.03 .9687 25.003	21/64	.3281	8.334	53/64	.8281	21.034
3/8 .375 9.525 7/8 .875 22.225 25/64 .3906 9.921 57/64 .8906 22.621 13/32 .4062 10.318 29/32 .9062 23.018 27/64 .4218 10.715 59/64 .9218 23.415 7/16 .4375 11.112 15/16 .9375 23.812 29/64 .4531 11.509 61/64 .9531 24.209 15/32 .4687 11.906 31/32 .9687 24.606 31/64 .8433 12.303 63/64 .9843 25.003	11/32	.3437	8.731	27/32	.8437	21.431
25/64 .3906 9.921 57/64 .8906 22.621 13/32 .4062 10.318 29/32 .9062 23.018 27/64 .4218 10.715 59/64 .9218 23.415 7/16 .4375 11.112 15/16 .9375 23.812 29/64 .4531 11.509 61/64 .9531 24.209 15/32 .4687 11.906 31/32 .9687 24.606 31/64 .4843 12.303 63/64 .9843 25.003	23/64	.3593	9.128	55/64	.8593	21.828
13/32 .4062 10.318 29/32 .9062 23.018 27/64 .4218 10.715 59/64 .9218 23.415 7/16 .4375 11.112 15/16 .9375 23.812 29/64 .4531 11.509 61/64 .9531 24.209 15/32 .4687 11.906 31/32 .9687 24.606 31/64 .9843 12.303 63/64 .9843 25.003	3/8	.375	9.525	7/8	.875	22.225
27/64 .4218 10.715 59/64 .9218 23.415 7/16 .4375 11.112 15/16 .9375 23.812 29/64 .4531 11.509 61/64 .9531 24.209 15/32 .4687 11.906 31/32 .9687 24.606 31/64 .4843 12.303 63/64 .9843 25.003	25/64	.3906	9.921	57/64	.8906	22.621
7/16 .4375 11.12 15/16 .9375 23.812 29/64 .4531 11.509 61/64 .9531 24.209 15/32 .4687 11.906 31/32 .9687 24.606 31/64 .4843 12.303 63/64 .9843 25.003	13/32	.4062	10.318	29/32	.9062	23.018
29/64 .4531 11.509 61/64 .9531 24.209 15/32 .4687 11.906 31/32 .9687 24.606 31/64 .4843 12.303 63/64 .9843 25.003	27/64	.4218	10.715	59/64	.9218	23.415
15/32 .4687 11.906 31/32 .9687 24.606 31/64 .4843 12.303 63/64 .9843 25.003	7/16	.4375	11.112	15/16	.9375	23.812
31/64 .4843 12.303 63/64 .9843 25.003	29/64	.4531	11.509	61/64	.9531	24.209
	15/32	.4687	11.906	31/32	.9687	24.606
1/2 .500 12.700 1 1.000 25.40C	31/64	.4843	12.303	63/64	.9843	25.003
	1/2	.500	12.700	1	1.000	25.400



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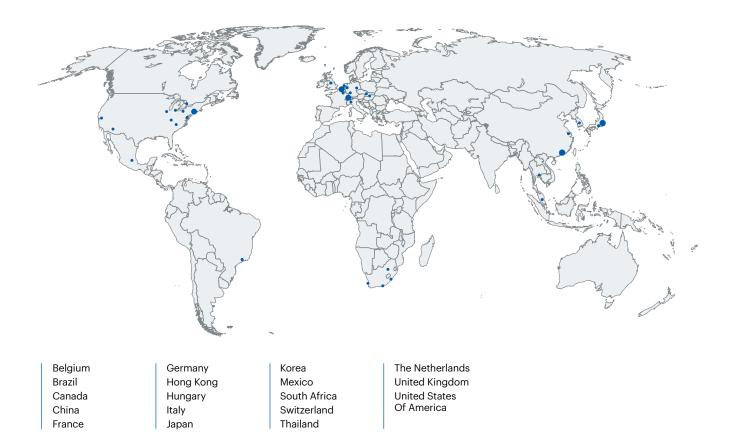
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