



MACHINING INSTRUCTIONS FOR FLUORILON FW-99™

We recommend a high tool speed and a fairly slow feed rate to get the best machining results. Carbide tipped tools are not required, as the material is non-abrasive and quite soft. We recommend fastening the Fluorilon to the machine or lathe bed with double sided tape, although larger pieces can be clamped gently. No lubricants (other than water) should be used. All tools and the area should be cleaned with alcohol before machining and latex or plastic gloves should be worn when handling the materials. FLUORILON (or any sintered PTFE product) IS EXTREMELY SENSITIVE TO GREASE AND OIL, WHICH WILL ADVERSELY AFFECT ITS OPTICAL PROPERTIES! It should also be noted that Fluorilon has a high coefficient of linear expansion, so very tight tolerances cannot be held.

We cannot overemphasize the importance of maintaining a clean machining environment and the use of gloves while handling Fluorilon. The material should be stored in zip-lock or similar bags when not being machined to avoid exposure to oil aerosols and other potential contaminants.