

Machining TeroTuf™

CIP's TeroTuf™ materials are easily machined by using conventional tooling and methods. You can use the same methods as you would for Aluminum or Brass. Machine dry. Dust mask and or work area air suction is suggested.

For lathe work, carbide or diamond tipped tools can be used to generate a fine surface finish. TeroTuf™ is 100% polyester resin material with no fillers.

To achieve a **fine** finish us 3M Scotch-Brite Finishing Flap Brush **Grade 5A VFN #01162**.

Cutting Angles of Turning

Top Rake	0° to 6°
Side Rake	5° to 8°
Front Rake	4° to 5°

Speeds for Cutting

Normal for surface finish	22 to 26 feet/second
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Speeds for Feed

First pass/roughing	.015 to .035 inches per revolution
Last pass/finishing	.010 to .015 inches per revolution