



ECOMold[®] 95

ECOMold[®] 135

Machining Guidelines

Turning (Carbide Tool)			
	Rough	Semi-Finish	Finish
Speed (SFM)	300	700	950
Feed (IPR)	0.009	0.006	0.003
Face Milling (Carbide Tool)			
Speed (SFM)	350		
Feed (IPT)	0.003 – 0.005		
Drilling (High Speed Steel Tool)			
Speed (SFM)	300		
Feed (IPR)	0.007		
<p><u>Notes:</u> SFM – Surface Feet per Minute IPR – Inches per Revolution IPT – Inches per Tooth Positive Rake Angles are recommended. High Helix Angle for Drilling recommended.</p>			
Engraving & Texturing			
<p>ECOMold[®] copper mold materials are easily engraved. A wide range of surface textures and finishes can also be readily applied and maintained.</p>			



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