

Notes to
(for example PA 6.6 + GF)

Reinforced and filled plastics (for example glass fiber, carbon fiber etc.) have more residual stress than unfilled plastics.

Because of the reinforcements and fillers, the products tend to be harder and more brittle with lower impact strength. This makes these products very prone to cracking. Machining can release the residual stress causing the part to crack. In order to avoid this, you must follow these instructions for machining:

- before drilling or sawing, the material must be warmed up to about 120°C (about 5 – 6 minutes per mm of cross section)
- for machining use hardened steel tools or ideally polycrystalline diamond tooling
- when clamping the piece, avoid bending, pulling or loading of the material

Following these instructions allows for the machining of high quality plastic products.

Please note that claims due improper machining / handling will not be accepted.

Thank you for your understanding.