# MACHINING GUIDELINES: BRONZE PLATED WEAR PRODUCTS

The following information is to aid in the machining Lamina bronze plated wear plate:

- Place product securely in a fixture to avoid vibration
- Use coolant during the machining process
  - ***Excessive heat during the machining process could cause peeling***
- Use sharp cutting tools
  - ***Dull cutting tools could cause excessively sharp, rough edges***
- Mill with tools that have a 0.030"minimum corner radius
- Mill perpendicular to the plated surface
- Address the plate from the plated side when drilling or milling
  - **Drilling or milling through from the opposite side could cause the plate to peel or buckle**
- Take a 0.020" to 0.030" minimum depth of cut when milling in to the plated surface
  - ***Too little depth of cut could cause peeling and too much could cause excessively sharp rough edges***
- Use the climb or down milling technique to ensure that downward force is applied to workpiece.

Note:

1. This product is composed of two dissimilar materials with unique thermal expansion and contraction rates. The characteristics that bind these two materials together can be disrupted if care is not taken during subsequent machining.

2. Applying these principals does not imply that the plating and base material will never separate. Specific machining and tooling recommendations should be obtained through your tooling provider. In order to be flat this material must be fastened to a flat surface. Material furnished is parallel within .001 over 8 feet.

If you have additional questions or concerns please feel free to contact us
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