

TECHNICAL NOTE

AREMCOLOX 502-1600 **HOT-PRESSED BORON NITRIDE MACHINING**

Hot-pressed boron nitride is easily machinable using standard machine shop tooling. Specially hardened tools are not required. Machining should be done dry, without lubrication. All equipment should be cleaned of grease and oil to minimize contamination.

Where tight tolerances are required grinding may be necessary. A sharply dressed, soft grade wheel is suggested with conventional speeds and feed rates (wheel speeds of 5,500-6,500 SFPM and table speeds 20-50 FPM).

When shipped from the factory, hot-pressed boron nitride is dried and sealed in moisture proof pouches with a desiccant. It is recommended that when removed from the original package for machining it be repackaged immediately to avoid exposure to moisture in the atmosphere. Material can also be placed in a desiccator or stored in an oven at a constant temperature of 300°C.