

CUTTING TRIALS FOR EGR.

MATERIAL BASE Stylexlex

Hpl laminate Stylexlex face panel

Abs white Stylexlex carcass panel.

Testing covered the area of cutting and routing.

Results

Cutting beam saw and panel saw.

Stylexlex

material cuts for all intensive purpose the same as mdf , all standard saws in current use are suitable and all current cutting parameters are suitable. Both in the beam saw and panel saw.

Stylexlex hpl face panel

cuts as most hpl laminates do, tools and parameters are the same, this material benefits well from low cutting height of the saw blade.

Stylexlex abs carcass panel.

Material cuts well low height projection of the saw is important, all current high precision saws will cut well triple chips and group tooth formats will perform well.

There is always a need to be aware of unnecessary heat generation, melting of the edge is possible if care is not taken. this would normally mean to slow feed speed , to many teeth blunt saws. All normal parameters are suitable cutting speed and feed speed.

ROUTER TRIAL.

Trials were carried out on both flat bed router and pod style router.

Stylexlex

This material cuts for all intensive purposes the same as MDF, all standard carbide and or diamond tools are suitable for cutting.

Stylexlex hpl face panel .

This material cut as most hpl product, all standard tools for cutting hpl are suitable.

Stylexlex abs carcass panel.

this material cuts for all intensive the same as mdf. stand 2 wing compression tools are best suited.

As the same for mdf compression tools should be 2 wing,

Care should be taken when onion skinning onion skin should be 2mm this is to protect the abs from heat generated in the cut.

During nesting excessive heat generation can cause the offcut to compact in the groove.

Summary..

All stylelexlex material.

Saws,

Saws at standard speeds slower rpm where available,

low cutting height or saw projection, 15-30mm

standard triple chip or group tooth preferred.

Constant feed speed without start and stop in the panel.

A well functioning Dust extraction is important,

Routers.

On pod machines most routers are suitable 16,000-18,000 rpm

2 wing tools are preferred in small diameter

Surface material hpl stand tools for hpl

Surface material abs. standard carbide tools.

Nested base,

Compression routers 16,000-18,000 rpm.

Tools should be 2 wing.

Functioning dust extraction is needed

Onion skinning needs to be 2 mm.

All other cutting parameters same as mdf..

Regards.

NEIL STAGGS. Md leuco Australia.