

MACHINING TRESPA® METEON®

This document is intended to provide general recommendations only. Trespa provides these guidelines and all testing, code and design data for informational purposes only and strongly advises that the customer, project owner and architect seek independent advice from a certified construction professional and/or engineer regarding application and installation as well as compliance with design requirements, applicable codes, laws and regulations, and test standards. Please check your local codes and applicable design requirements for proper use.

General

Machining panels should only be done by a machining or construction professional with proper equipment.

The homogeneous composition of the material makes it possible to machine both the sides and the surface. Machining Trespa® panels is comparable to machining high quality hardwood. Trespa® panels may be machined using carpentry tools. The hardness of Trespa® panels makes greater demands on tools than machining materials composed of softwood. The use of hard metal tools is advised. Diamond-tipped tools are recommended for large series. This ensures a very good finish and a long tool life.

Health and safety

Please note that serious dangers are inherent with the use of (carpentry) machinery. In all cases, adhere strictly to the guidelines of the machinery manufacturers and the recommendations of the safety and labor organizations.

Transport and handling

In general, lift the Trespa® panels and avoid sliding them as much as possible, also during transport and assembly.

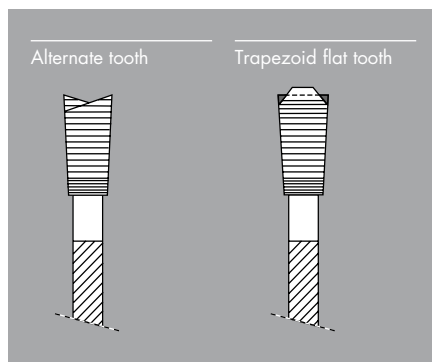
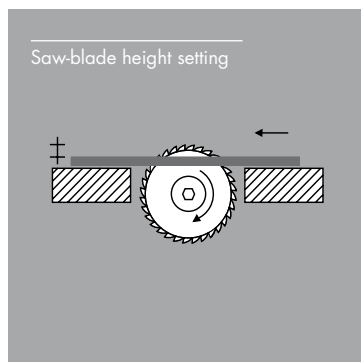
Additional guidelines apply for Trespa® Meteon® Gloss or other Trespa® panels provided with a protective foil:

- Do not remove protective foil during machining.
- Machine preferably using computer operated equipment.
- Do not write directly on the protective foil but use adhesive stickers for marking/coding.
- Remove only the foil in the affected areas in case of the foil burns or melts during machining.

Sawing

The following general guideline apply to sawing of Trespa® Meteon® panels.

- Feed: 7 - 22 m/min (≈ 23 - 72 ft/min).
- Tooth: Alternate tooth or trapezoid flat tooth.
- Positioning: Entering tooth always at the decorative side of the Trespa® panel.
- Cutting edges: Best results are obtained with stationary machines.
Any sharp edges can be removed with sandpaper or router.
- Rake angle: A rake angle of 45° gives the best performance.
- Use insert templates covered with rubber mats to prevent the Trespa® panels from sliding if the machine does not have a moving worktop and/or if you are machining double-sided panels.



Stationary circular saw

Have the decorative side facing upwards when sawing, drilling and routing.

When a decorative side must be slid over the machine's worktop while machining, it is recommended to place a protective panel, for example of hardwood, on the worktop.

Diameter		Teeth	Number of revolutions	Saw blade thickness		Saw blade height setting	
mm	inch			mm	inch	mm	inch
300	≈ 12	72	≈ 6,000/min	3.4	≈ 1/8	30	≈ 1 1/4
350	≈ 14	84	≈ 5,000/min	4.0	≈ 3/16	35	≈ 1 3/8
400	≈ 16	96	≈ 4,000/min	4.8	≈ 3/16	40	≈ 1 5/8

Portable circular saw

When using a portable circular saw, the non-decorative side should be upwards.

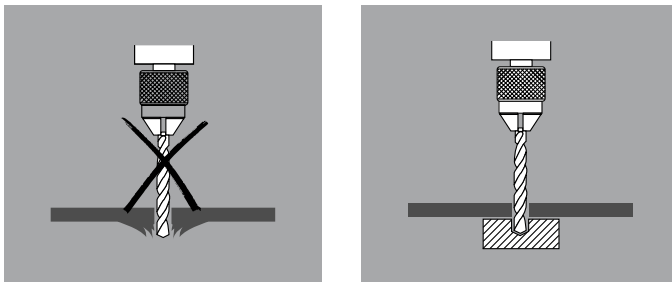
Diameter		Teeth	Number of revolutions	Blade thickness		Height setting	
mm	inch			mm	inch	mm	inch
150	≈ 6	36	≈ 4,000/min	2.5	≈ 1/8	15	≈ 5/8
200	≈ 8	46	≈ 4,000/min	3.0	≈ 1/8	20	≈ 3/4

Jig saw

- Jig saw: carbide-tipped, interior corners of cut-outs should be drilled first with 8 - 10 mm (≈ 5/16 - 3/8 in) hole diameter.
- Consider the use of a specific jig saw blade for decorative surfaces.

Drilling

Carbide-tipped HSS-drill, top angle 60-80°. Trespa® panels should be drilled with support sheets.



Diameter		Number of revolutions	Feed	
mm	inch		mm/min	inch/min
5	≈ 1/4	≈ 3,000/min	60 - 120	≈ 2 - 5
8	≈ 5/16	≈ 2,000/min	40 - 80	≈ 1 1/2 - 3
10	≈ 3/8	≈ 1,500/min	30 - 60	≈ 1 - 2

Large holes, e.g. for suspension and locking equipment, are to be drilled with combination drills without a centering point.

Routing

Routing shapes:

- straight and slanted bits for cutting edges and beveling;
- hollow or round ground bits for rounded edges;
- diamond groove-circular saw blades for grooves.

Material:

- cutters made of hard metal or diamond.

Manually operated routing cutter or spindle molder:

Diameter		Number of revolutions	Speed		Feed	
mm	inch		m/s	ft/s	m/min	ft/min
20 - 25	≈ 1	≈ 18,000 - 24,000/min	20 - 30	≈ 65 - 100	5	≈ 16
125	≈ 5	≈ 6,000 - 9,000/min	40 - 60	≈ 130 - 200	5 - 15	≈ 16 - 50

Disclaimer

This is a print generated by you from www.trespa.info ("Website"). By accessing the Website and printing this document you have accepted the Terms of Use of the Website. Please refer to the Website for all conditions that apply to this document. Not all the systems shown in this document may be suitable for all applications and jurisdictions. We provide you with testing, code and design data for informational purposes only and strongly recommend that you or any other user of this document obtains independent advice regarding compliance with design requirements, applicable codes, laws and regulations, and test standards. Please check your local codes and design requirements for proper use. Trespa will not accept any liability in relation to your use of this document.

All intellectual property rights, including copyrights and other rights regarding the content of the Website and this print generated from the Website (including logos, trademarks, service marks, software, databases, audio, video, text and photographs) are owned by Trespa and/or its licensors. Trespa®, Meteon®, Athlon®, TopLab®, TopLab^{PLUS}®, TopLab^{ECO-FIBRE}®, Virtuon®, Volkern®, Trespa Essentials® and Mystic Metallics® are registered trademarks of Trespa.

All oral and written statements, offers, quotations, sales, supplies, deliveries and/or agreements and all related activities of Trespa are governed by the Trespa General Terms and Conditions of Sale (Algemene verkoopvoorwaarden Trespa International B.V.) filed with the Chamber of Commerce and Industry for Noord- en Midden- Limburg in Venlo (NL) on 11 April 2007 under number 24270677, which can be found on and downloaded from the Trespa website, www.trespa.com.

All oral and written statements, offers, quotations, sales, supplies, deliveries and/or agreements and all related work of Trespa North America, Ltd. are governed by the Trespa General Terms and Conditions of Sale, which can be found on and downloaded from the Trespa North America Ltd. website, www.trespa.com/na. A copy of these general conditions of sale will be provided free of charge on request.