TECHNICAL DOCUMENTATION

TRESPA® TOPLAB®

Machining

TRESPA®

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 labour organizations.

Transport and handling

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

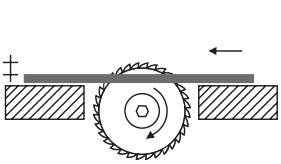
Additional guidelines apply for Trespa® TopLab® or other Trespa® panels provided with a protective foil:

- 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.

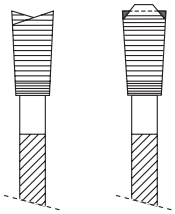
Sawing

The following general guideline apply to sawing of Trespa® TopLab® 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.



Saw-blade height setting



Alternate tooth

Trapezoid flat tooth

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

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 moulder:

DIAMETER		NUMBER OF REVOLUTIONS	SPEED		FEED	
MM	INCH		M/S	FT/S	M/MIN	FT/MIN
20 - 25	≈ 1	≈ 18.000 - 24.000/rnin	20 - 30	≈ 65 - 100	5	≈ 16
125	≈ 5	≈ 6.000 - 9.000/rnin	40 - 60	≈ 130 - 200	5 -15	≈ 16 - 50

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