

ALUMINIUM COATING PANEL can be processed to any shapes with ordinary wood or metal processing tool, so it can meet the requirement of any building style, this is the advantage which the other decoration material can not compete with.

### Sawing

It can be easily processed with ordinary wood processing tool, as for the panel, in order to make the panel edge smooth, we recommend to use hard alloy blade .



### Cutting

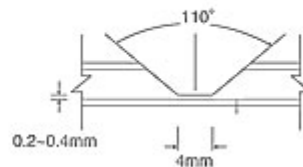
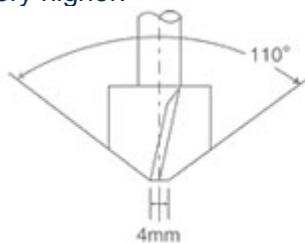
Cutting is the first step in the course of processing, as for the large project, we can use table-saw, curved-saw and digital control machining center to cut the required size according to the scale and the quantity of the project and different shapes.



As for the small project, we can use the portable electric saw, pull-out hand saw to process it according to the regulated line.

### Slotting

While making the slots on the back of the panel, it will be more suitable to keep 0.2-0.4 thickness of core material left, when processing U type slotting, we recommend to use the slotting machine with 110 degree slot angle, as for the big project, it can use large digital control equipment, the efficiency will be very higher.



### Compassplane operation coefficient:

While using the improved router for procession, please refer to the following form.

Number of teeth	2-4
Running speed	20,000-30,000 revolution/minute
Feeding speed	8-12 m/min.
Material	Hard alloy blade or other cutter with quartz

### Slotting operation coefficient:

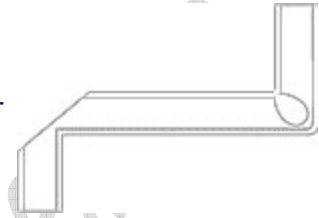
While processing large quantity ACP, please use professional fabrication plant, such as vertical cutter groover

Material	Hard alloy blade
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Outer diameter of gear	220 mm
Number of teeth	18
Running speed	3,000 to 5,000revolution/minute
Feeding speed	10-15m/min.

### Fold

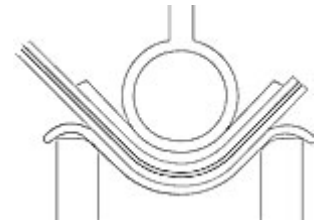
When folding the slotted panel, bending part must be put on the platform, the processing table must be kept tidy, and platen puncher plate folder or bending dies are applied as bending equipment, the temperature for the bending is over 10 degree.



### Bending with panel bender

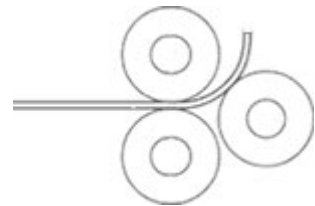
When plate folder is used to process the panel, dies should be placed on with appropriate radius.

**Notice:** In order to avoid destroying the surface coating of the panel, while bending the panel, it is better to add a protection on the surface of the dies.



### 3-roller panel bender

3-roller panel bender is more preferable for bending of large internal diameter of plate folder before the bending, it shall ensure that it can be manually bent after bending.



### Punching (drilling)

The **twist drill** tool which was used on metal or plastic, now it also can be used for panel, the drill tool with high-speed rotation and strong airflow can blow out all plastic debris which was made in the process of the drilling.



### Edge planer

While using the upright saws to process the panel, it always appears plastic debris or extra edge on the sides of the panel, here we recommend to use the flat edge planer machine to process its edge so that it can keep the panel flat and smooth.



#### Clamping and bolting

panel Can be clamped with a serrated corner joint and but sections for thickness of 3mm and 4mm.

When bolting,  $e=2D$  is the formula to use to calculate the distance of fixing to the end of the panel .



#### Welding (Only used for PE core)

panel can use the electronic welded gun to melt the PE plastic core and PE plastic **welding rod and make the connect after cool down**, Here we recommend to hot air to fasten the gap and node.

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