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## CUTTING AND MACHINING OF PARKLEX FACADE PANELS

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### Cutting

Parklex panels may be machined using conventional carpentry machines manufactured in hard metal.

Due to Parklex Facade's high density, the cutting speeds must be slower than those used with solid wood.

Parklex Facade panels may be cut on a stationary circular table saw or with a handheld circular saw.

If many series are to be cut, the stationary table saw blades must be diamond-tipped. If they are not, or if hand held machines are used, the saw blades must be made from hard metal sheets or "Widia" tools (made from carbon tungsten), with a hardness of K-05 and K-01. Saw blades made from high speed steel or that contain a high level of Cobalt may be used to machine Parklex, although lower sharpening performance will be obtained.

Circular saw blades must have similar characteristics to those used to machine particle-board-core plywood and melamine panels. Blade diameters must be between 250 and 300 mm for circular table saws and between 150 and 190 mm for handheld saws. The most efficient tooth profile is flat trapezoidal. The number of teeth will depend on the diameter, and may be from 24 to 60.

The saw should always begin the cut on the good side of the panel. Depending on the rotational direction of the tool, the panel must be placed with the good side either facing up or down.

- Stationary saw: The panel must be placed with the good side up.
- Handheld saw: The panel must be placed with the good side up.

### Drilling

The panels must be drilled using hard metal or "Widia" tools. Support plates must be used under the panel in order to achieve a clean hole.