



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® Meteon® Gloss or other Trespa® panels provided with a protective foil:

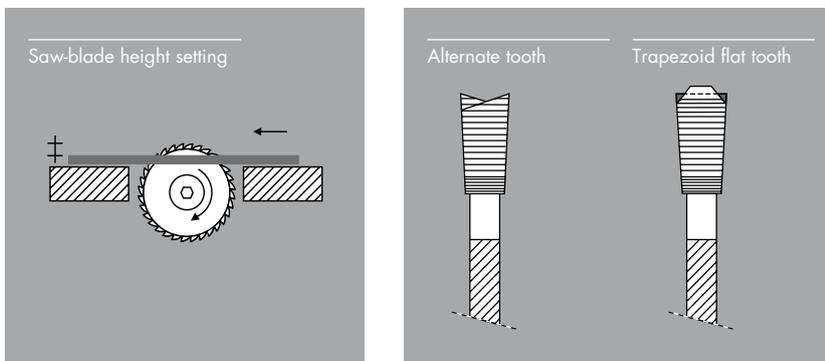
- Do not remove protective foil during machining.
- Machine preferably using computer operated equipment.
- Do not write directly on the protective foil but use adhesive stickers for marking/coding.
- Remove only the foil in the affected areas in case of the foil burns or melts during machining.



Sawing

The following general guideline apply to sawing of Trespa® Meteor® 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

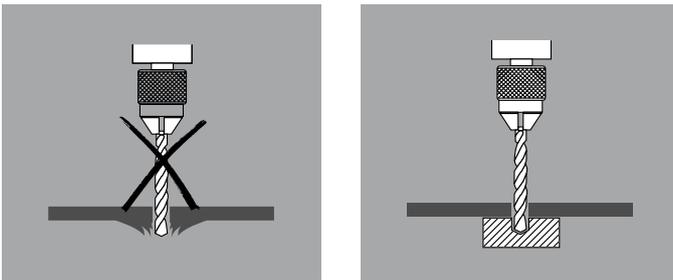


Jig saw

- Jig saw: carbide-tipped, interior corners of cut-outs should be drilled first with 8 - 10 mm ($\approx 5/16 - 3/8$ 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	$\approx 1/4$	$\approx 3.000/\text{min}$	60 - 120	$\approx 2 - 5$
8	$\approx 5/16$	$\approx 2.000/\text{min}$	40 - 80	$\approx 1\ 1/2 - 3$
10	$\approx 3/8$	$\approx 1.500/\text{min}$	30 - 60	$\approx 1 - 2$

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 bevelling;
- 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	$\approx 18.000 - 24.000/\text{min}$	20 - 30	$\approx 65 - 100$	5	≈ 16
125	≈ 5	$\approx 6.000 - 9.000/\text{min}$	40 - 60	$\approx 130 - 200$	5 - 15	$\approx 16 - 50$

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