




## CBOND CUTTING INSTRUCTIONS

Cbond panels can be cut using various saws including table saws, circular saws as well as handheld jigsaws. Blades should be optimized for aluminum or plastic materials.

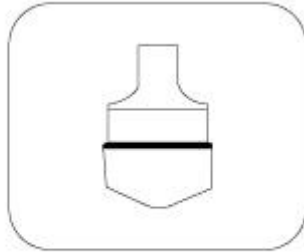
Tools/Parameter	Disk Saw	Band Saw	Jigsaw
Blade size	Carburization (CT)	Hardening Spring Steel	High-speed Steel (HSS)
	Tooth thickness: 2-4mm	Thickness: 0.8-1.2mm Width: 15-25mm	Thickness: 0.8-1.2mm Width: 5-15mm
	Trapezoidal tooth or Flat tooth	Hooked tooth	Herringbone tooth
	 cutting machine	 cutting & grooving machine	 jig saw machine
Pitch (t)	10-12mm	4-12mm	1.2-3mm
Clearance Angle ( $\alpha$ )	15°	35°	
Rake Angle ( $\gamma$ )	10°	3°-5°	
Max Cutting Speed (v)	5000m/min	3000m/min	160m/min
Max Feed Speed (s)	30m/min	25m/min	6m/min

### Notes on Saw Cutting:

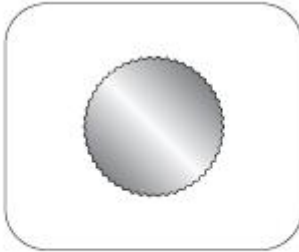
- Panels should be cut with the right side facing up to prevent the panel from scratches and to prevent the protective film from peeling off.
- During and after cutting, carefully remove all debris resulting so as to avoid dents during storage or assembly.
- The blade should be well maintained and either sharpened or replaced. Dull blades may result in burrs or distortion of the cut edge.

# 1. Routing and Folding Technique

Cbond Panel is easily formed into the desired shape. The reversed side is first routed and panel folded. Routing is performed using one of the three tools shown:



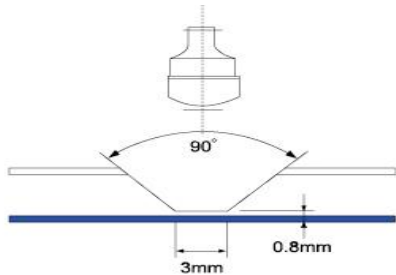
The common router with appropriate "bit".



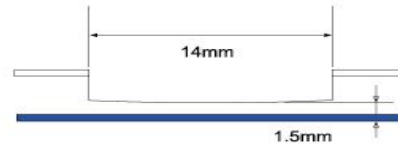
A disk cutter with disk appropriate for the angle.



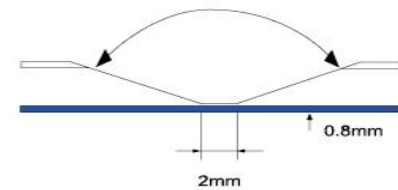
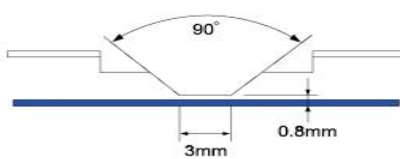
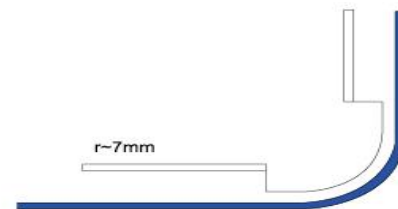
Atypical bench saw etc.



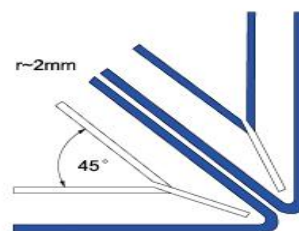
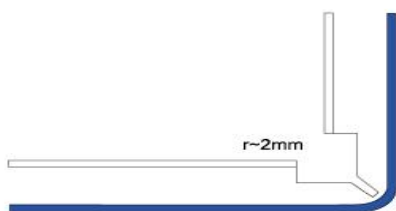
Groove 90° (V-shape) for foldings up to 90°



Not suitable for rectangular groove for foldings up to 150° depends on the panel thickness



Groove 135° (V-shape) for foldings up to 135°



## 2. Bending



Bending by cold

When plate folder is used to finish the Cbond panels, dies shall be placed with appropriate radius, and the required parameters of Cbond panels is showed as below:

Thickness of panel(mm)	Vertical	Cross
3	65	55
4	75	55
6	90	80