




## 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 scratches and to prevent the protective film from peeling off.
- During and after cutting, carefully remove all resulting debris, in order to avoid dents during storage or assembly and to prevent the blade clogging during the cutting process.
- The blade should be well maintained and either sharpened or replaced. Dull blades may result in burrs or distortion of the cut edge.