

VENETTE panels

The below is only a overall guide of how we process this product at **polytec**, to assist in helping customers achieve a better finished result, outcomes may still vary.

Cutting

Panel Saw:

- Level and clean cutting table
- Ensure good quality new or near new blade is fitted
- Ensure Scribe blade is turned on and adjusted correctly
- Cut the Venette finish of the board – face down
- Push board through blade at a consistent motion and slower than other finish types
- Ensure trim cut is performed edge of sheet

Beam Saw:

- Ensure good quality new or near new blade is fitted
- Ensure scribe blade is turned on and adjusted correctly
- Cut the Venette finish of the board – face down
- Feed rate is 150 metres per minute – slow feed rate down if chipping occurs

Routing / Nesting:

- Router cutters are set to 23 metres per minute
- Machine the Venette finish of the board – face down
- 9mm to 12mm diameter spiral cutters that shear up and down to prevent chipping
- Cutters should be going through and protruding into the sacrificial board by 0.2mm

Applying Edgetape

Edge bander:

- Ensure edge bander has pre-milling and cutters are sharp
- Pre mill 1mm off and apply 1mm edge tape
- Run edge bander at 23 metres per minute

If chipping is still occurring from being cut on the panel saw after edgetape is applied:

- The chips may still be visible from the saw, if the chips are larger then what is pre milling off on the edge bander, pre mill 2mm to 3mm off on the edge bander, this will mean the pieces will need to be cut oversize on the panel saw. *Example = Cut the piece 1mm oversize, pre mill 2mm off on the edge bander and apply 1mm edgetape, bringing the door back to the correct finish size.*

If chipping is occurring through the edge banding process:

- Reduce the pressure on all tracing shoes
- Increase cutter speed and reduce feed rate

CONTACT:

For further information on this product contact:

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Date of last update: May 2021