



polytec

Installation Guide

Venette

Low Pressure Melamine

Installation Guide

Handling & Storage

- When moving sheets ensure care is taken to avoid scratching of decorative surface.
- Store **polytec** Xenolith in an enclosed area protected from moisture and heat.
- When storing vertically, place side exactly vertical and support over full height.
- When storing horizontally, support bearers should be no more than 600mm apart.
- Ensure the pooling of water on the surface of **polytec** Xenolith cannot occur and allow sufficient ventilation and drainage in enclosed spaces.
- Maximum overhang must not exceed 300mm.

Processing

Tooling

Standard tools can be used for machining and processing such as sawing, drilling and routing.

Sawing

- To achieve optimum finishing always use trial pieces to test before actual operation. Always ensure the decorative surface is facing upwards to prevent damage and chipping edges of the surface. A carbide or diamond tipped saw blade should be used.
- Saw blades must always be sharp and if necessary, remove the blade to sharpen or change to a new blade before continuing. All sharp sawn edges should be removed with fine sand paper or router to achieve a smooth finish.

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 than 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.
For 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



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Contact

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