

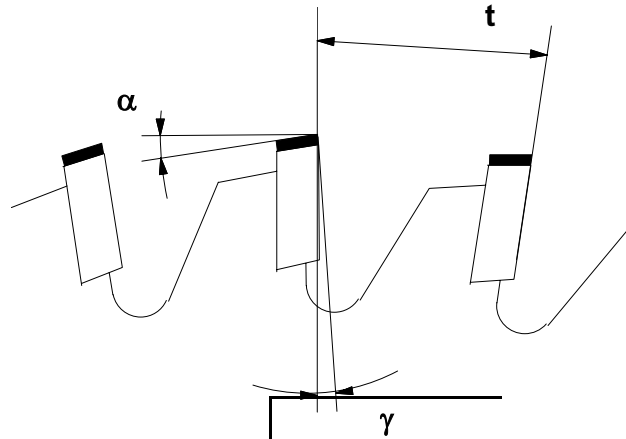
Veralite® - Sawing

Veralite® can be sawn by use of a circular saw or a band saw, following guidelines :

1) Circular saw :

Try to avoid high heat-development during sawing.

Sawing with a circular saw will give better results than sawing with a band saw.



Advised lip clearance α	10° - 30°
Cutting clearance γ	5° - 15°
Saw speed	2500 m/min. - 6000 m/min.
Teeth distance t	3 mm - 11 mm

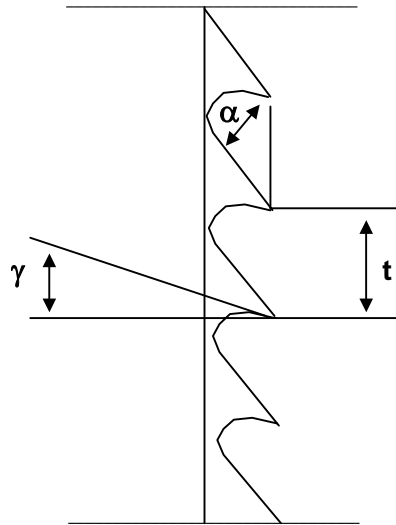
It is advised to keep the saw blade 1,5 teeth higher than the pile of sheets to be sawn. With Veralite 100 sheets with a thickness < 2mm, it is advised to slow down the carriage speed while coming out of the pile of sheets, as following :

Sheet thickness of :	Carriage speed :
0,50 mm >>>>	0,50 m/min.
0,75 mm >>>>	0,75 m/min.
1,00 mm >>>>	1,00 m/min
1,50 mm >>>>	1,50 m/min

If there occur height differences in a pile of sheets (because of thickness tolerances), it is advised to restack the sheets or support the sheets, to have an equal pile of sheets. Avoid using hard rubbers on the clamping bar, so you can compensate this height difference.

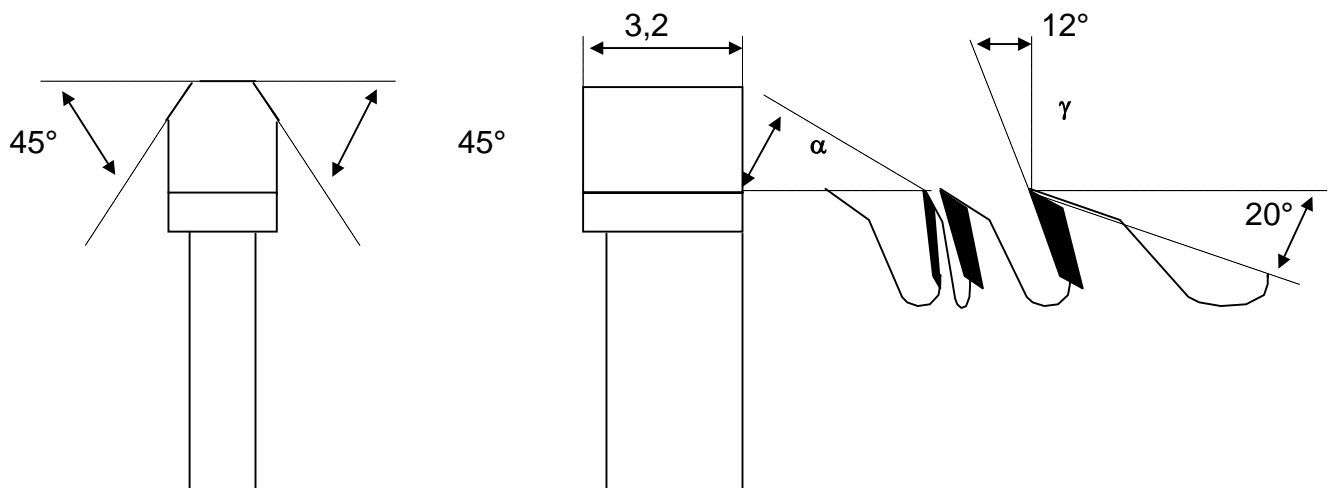
Veralite® can be sawn by use of a circular saw or a band saw, following guidelines :

2) Band saw :

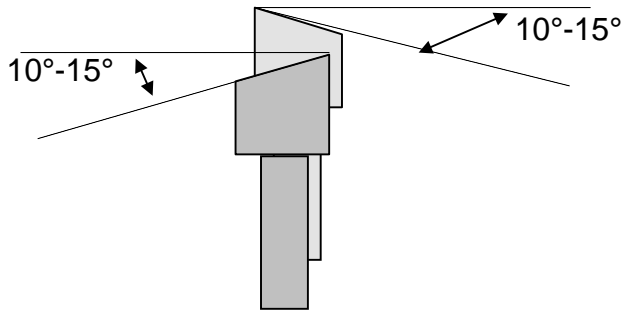


Advised lip clearance α	30° - 40°
Cutting clearance γ	0° - 5°
Saw speed	1200 m/min. - 2000 m/min.
Teeth distance t	2 mm - 3 mm

Some technical advice on usable saws :



Type : **AKE21.220.30Z64**



Type : **AKE16.300.2,9Z96**
with inclination of teeth switching
left, right, left, ...

Troubleshooter sawing :

	Teeth dimension	Saw speed
Notched edges	decrease	increase RPM
Melted edges	increase	decrease RPM

It is to be preferred to use a thick sheet(+3mm) to cover and support the pile of sheets, and so preventing that the first and top sheet will tremble and cause shattering of the sheet edges.

The use of an forsaw which saws underneath instead of above can solve the problem of shattered edges without the use of a supporting sheet.

All above information is based on current knowledge and experience. The data does not imply any warranty from the manufacturer towards third parties. Users should consider the above data as a guideline and gather additional information, to make independant decisions regarding the proper use, disposal, safety towards other parties and the protection of the environment.

For more specific information, please feel free to contact our technical department :

I.P.B. nv
Steenovenstraat 30
8790 Waregem
BELGIUM
Tel.+32.56.60.79.19
Fax +32.56.61.08.85