

Cutting

Rough Cutting

Rough cutting Richlite is a quick way to process panels that do not require a finished edge. Some examples include exterior paneling, non-visible fabricated edges, and mating assemblies and industrial applications. Due to the weight of the material, stationary cutting with a circular saw, panel saw or CNC router is preferred over table saws. While CNC routers are a good tool for certain operations as noted below, rough cutting and routing by hand is a very efficient way to process Richlite. The factory rough cut edge is to exact stated dimension and not oversized.

- Festool® track saw is ideal cutting setup.
- Standard circular saws can be used but will often leave saw marks due to less stable nature and lower rpm motors.
- Single pass cutting can be achieved if the proper blades are used. Appropriate feed speeds are critical in this situation and will be a function of thickness, and even in some cases color.

Finish Cutting

Finish cuts can be made with a high quality circular saw like a Festool® track saw or worm drive high horsepower unit. Feed speeds and high rpm's will ensure a clean cut. Taking a very light pass with a sharp proper blade can provide a cut that can be minimally sanded to achieve a quality edge treatment.

- An even rate of speed will prevent burn marks which can be routed off, but are difficult to sand off.
- For mated seams, routing or finish cutting will result in a tighter seam.
- Sliding table saw speeds between 3,450 RPMs and 4,000 RPMs
- Jig saws and hole saws are not recommended as a tool for Richlite as the blades tend to wear out very quickly.

Cutting Cont.

Equipment

Saws

- Festool® model TS 75 or TS 55
- Circular saw
- Sliding table saw

Saw Blades

- Festool® #495387 10" 80 tooth, negative 5 degree hook. Kerf 2.5 mm
- Festool® #495386 Solid Surface/Laminate Blade For The Kapex Miter Saw - 64 Tooth
- Amana Tool® Double Sided Melamine and Laminate Blade Line "MB" series
- FS tool 7.25 x .115 x 5/8 x 40T, triple chip negative hook
- Laminate and melamine blades from various manufacturers that follow general specifications of the above blades.