

4. Handling

To facilitate installation and satisfying the specific requirements of each project, panels may be easily handled for cutting and drilling, making Parklex Facade an extremely manageable product. However, when doing so, it is important to follow minimum safety guidelines.

Standard requirements should be kept in mind when handling Parklex panels, especially with regards to:

- Dust removal.
- Dust collection.
- Fire precautions, etc.

Due to the possible presence of sharp edges, protective gloves should always be worn when handling Parklex panels. Contact with dust from HPLs does not normally present a problem, although some people may be sensitive or even allergic to it.

4.1. Cutting

Parklex panels may be machined using conventional commercial grade carpentry machines equipped with hard metal accessories.

Due to the high density of Parklex Facade, cutting speeds must be slower than those used with natural wood.

Parklex Facade panels may be cut with stationary circular table saws or with handheld circular saws.

If many panels are to be cut, stationary table saws must be equipped with diamond-tipped accessories. If not, or if manual machines are being used, the accessories must be made from hard metal plates or "Widia" (tungsten carbon), with a hardness of K-05 and K-01.

Accessories made from high-speed steel or that contain a high level of cobalt may be used to machine Parklex, although lower sharpening performance will be obtained.

Circular saw blades must have characteristics similar to those used to machine high pressure laminate or melamine panels. Blade diameters must be between 250 and 300 mm for circular table saws and between 150 and 190 mm for handheld saws. Flat, trapezoidal tooth profiles are the most efficient. The number of teeth should be between 24 and 60, depending on the diameter.

4.2. Drilling

The panels must be drilled using hard metal or "Widia" tools. Supporting sheets (martyr boards) must be used under the panel in order to drill a clean hole, without 'breakout'.

The blade teeth should always enter on the panel's good face. Table saws generally have the good face pointing up, as the blade rotates with the blade cutting on the 'downstroke'. Hand held circular saws generally cut on the 'upstroke', therefore the panel should face down.

