

Werkzeugempfehlung / Tool recommendation:

Benz: 4-33651 V-Nut-Fräser



Firma / Company:

Benz GmbH Werkzeugsysteme
Im Mühlegrün 12
D-77716 Haslach im Kinzigtal

Processing instructions

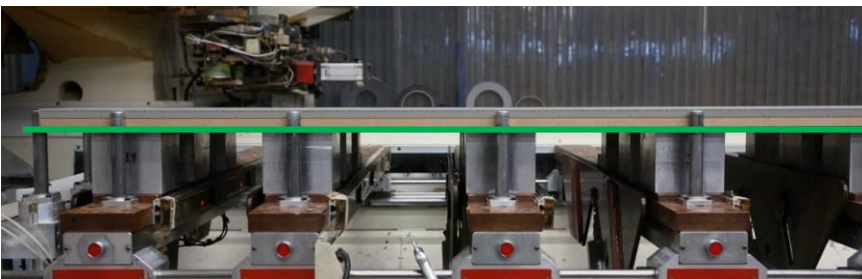
Step 1: Put up the cover board and machine it flat for an absolutely flatness.
Material: e.g. MDF, so that suction power comes through the board.



Step 2: To measure the thickness of the cover board and enter the correction in the program.

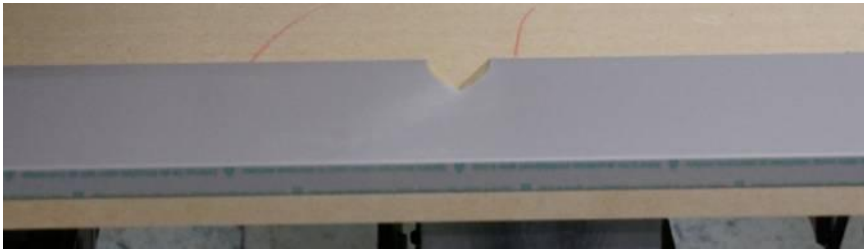


Step 3: To put up the workpiece in absolutely flatness.



Step 4.0: Ensure tools are sharp and the cut penetrates the peel coat.

Step 4.5: Premill on the exit-side, to avoid cracks.



Step 5: To carry out the V-groove milling . The deepness is in that to adjust, that the 75 µ Pianovo Lackgloss-foil is just touching. Also the quick-test in Step 6 is to pass.



Step 6: Quick-test. No MDF in the groove and on the foil.



Step 7: It is highly recommended to use PUR glue in the fold on all Metallic panels.

The general processing instructions apply to all further processing steps: See separate fabrication guide.