

PROCESSING INSTRUCTION

aluminum plastic composite panel can be machined with wood-machine or metal-machine, it can be cut, saw, mill, punch, fold, bend as will to form a certain shape. It can be shaped to any shape according to building decoration requirement, especially good at arch, back-arch, small radius circle, inner/ outer corner. Any other decoration material could not match this feature.

Sawing

Use Normal aluminum machining machine and wood machine could Process ACP without any special refit. And Saw with wood sawing machine is ok. But Hard alloy saw sword plate is highly recommended

Cutting and grooving

U shape groove is best, leave 0.2-0.4mm thickness PE plastic core. 110 degree is the recommended groove angle.

1. Milling and clipping machine Drill tip as below picture on left.

tooth: 24

Revolution 20,000-30,000rpm

Cutting Speed: 3-5meter/minute

Material: hard alloy

2. when make many U shape grooves . Use round-saw and band saw is suitable. The following is one example for grooving knife.

Material: hard alloy plate

Outer radius: 305mm

Tooth: 24

Revolution: 3,000-5,000rpm

Cutting speed: 5meter/minute

Process Hem

Work on flat roof, bending part should be straight. Flat punch machine , bending machine or folding machine is recommended. And work in place above 10degrees celsius.

Bending with bending machine

When use bending machine bend GOLDSTAR panel, it is recommended use right radius upper mold. Goldstar panel need least radius as below form.

Three Roller Bending Machine

Three roller bending machine is good for large radius bending. And it is recommended to bend the part with hand before use machine.

Riveting and Bolt connection

Use the rivets with aluminum core for fixed connecting, and stainless steel screw or Bolt is also suitable. Considering the different shape and size of panel and long-time loose, we suggest use the diameter of the screw cap can not less than the twice dia. Of screw body.