

MASTER OAK'S GOLDEN RULES

Guidelines for processing HPL Master Oak (V2A)

Sawing, milling, edge banding, or drilling: you can process HPL Master Oak in many different ways. This guide shows you how to do it right. Maximise the performance of your panels with **our golden processing rules*** for interior professionals.

Any questions? Your Unilin Panels representative will be happy to help.

Good luck with your interior design project!

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PS: We love to see your creations. Tag us with @Unilin Panels in your social media posts or use #unilinpanels.

* These tips and recommendations are for HPL Master Oak (V2A) bonded on two sides to MDF or chipboard. They can also be used for processing HPL panels with other surface structures and for all types of melamine faced chipboard and MDF.



Skilful sawing

- Set the protrusion (the distance between the upper tooth and panel surface) between 15 and 25 mm, depending on the diameter of the saw blade and the number of teeth.
- Use preferably:
 - a combination of a main saw and a pre-scoring saw.
 - trapezoidal teeth, possibly in combination with flat teeth.
 - teeth made of polycrystalline diamond for long durability..
- Take into account the age of the saw blade specified by the manufacturer. Sharpen or replace the blade in time.
- Cut the panels with a feed rate of 10 to 30 m/min and with the decorative side upwards.
- Avoid vibrations by exerting sufficient pressure on the panels while sawing.

Meticulous milling

- Work with a milling machine, CNC milling table, or CNC machine to obtain optimum results.
- Use preferably:
 - a diamond-tipped cutterhead with a cutting angle between 30° and 70°.
 - diamond-tipped compact hoggers.
 - diamond-tipped routers.
- Ensure that the cutting pressure of the cutting blades/teeth is always directed towards the panel:
 - Point the cutting blades/teeth downwards to cut the upper side.
 - Point the cutting blades/teeth upwards to cut the underside.



Excellent edging

- Our recommendations on milling also apply when using an edge banding machine.
- Use diamond-mounted cutting blades/teeth and adjust the milling unit according to the manufacturer's guidelines.
- Ensure that the thickness of the joint trimming unit matches that of the edge tape.
- Allow for 5 mm extra edge tape width on top of the panel thickness for a clean finish (e.g., 18 mm panel thickness, 23 mm edge tape). After gluing, the excess will be cut off.

Dexterous drilling

- Preferably use a carbide drill bit or one with a carbide tip.
- Select a type of drill that is appropriate for the work to be carried out (e.g., dowel drill, through-hole drill, hinge drill, etc.).



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