

Routerbits & Saw Blades



corian.

Below is an overview of recommended cutters for Corian®.

Be sure to use **Tungsten Carbide** cutters.

We recommend two companies who have proven to deliver outstanding quality which will help you to get the best out of your work with Corian:

- * **Albin Kraus**
- * **Titman.**



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Tungsten Carbide - (for cutting and trimming)

- Hardness of Corian® requires saw blades and cutters in Tungsten carbide

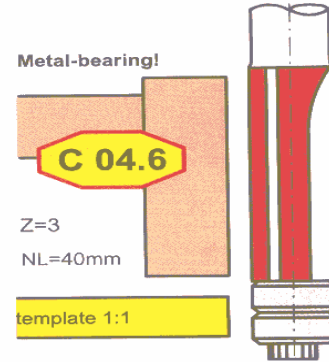
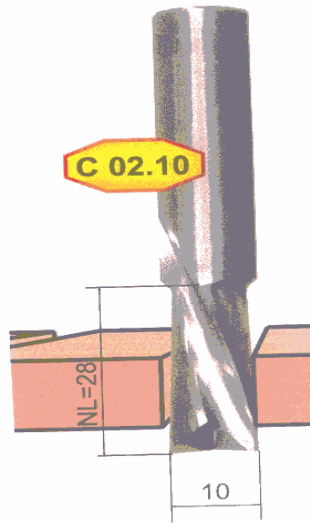
Material MOH Hardness scale (1 TO 10)

•Diamond	10	<u>hard</u>
•Tungsten carbide	9	
•Sand paper	7	
•Granite	7	
•Titanium	7	
•Knife steel blade	5	<u>soft</u>
• <u>Corian®</u>	3	
•Marble	3	
•talc	1	

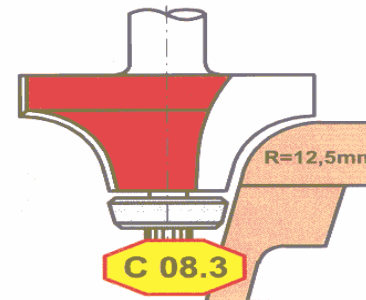
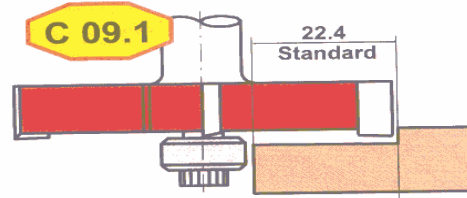


- Spiral Tungsten carbide for CNC
- Single flute cutters best for hole cutouts
- Always use sharp tools on Corian (*no high speed steel cutting tools*)

Albin Kraus cutting tools : basic cutters for cut-out, trimming, backsplash rebate

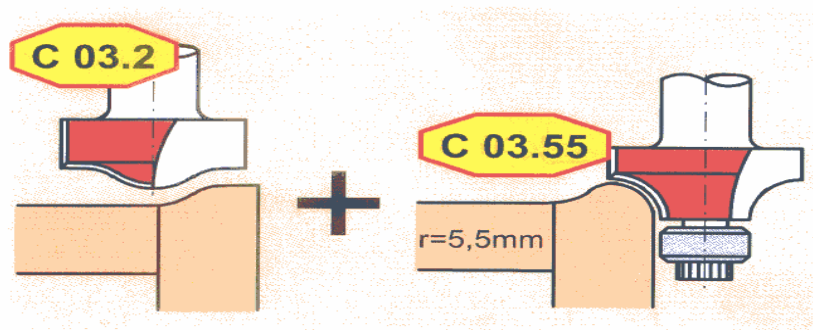
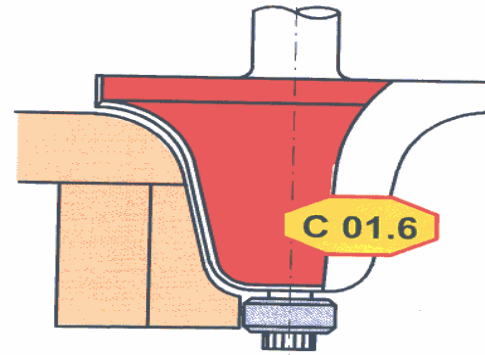
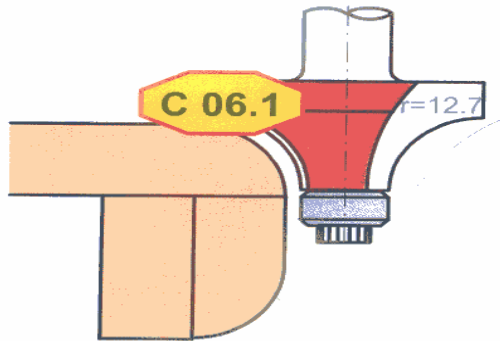


1. Do the rabbet

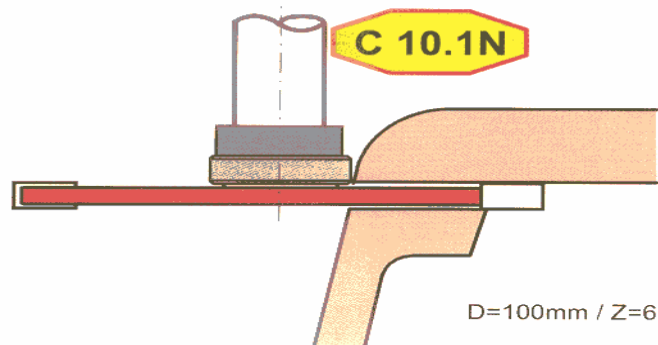
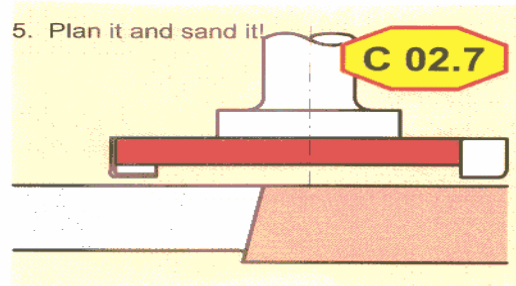


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Albin Kraus cutting tools : rounding



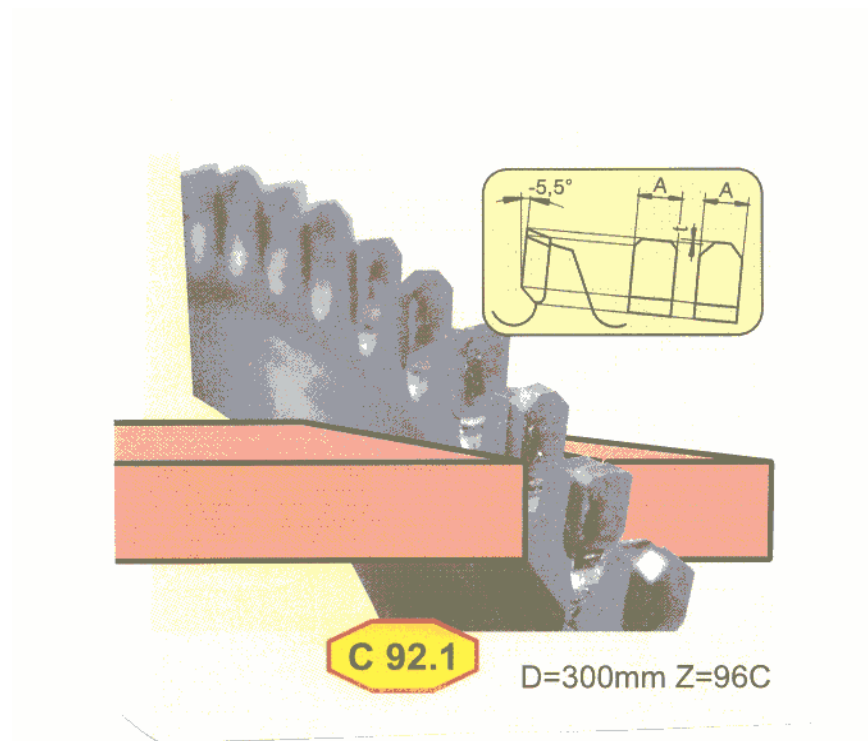
Albin Kraus cutting tools: planing and bowl cut-out



Albin Kraus: saw blades

Be sure to use a sawblade

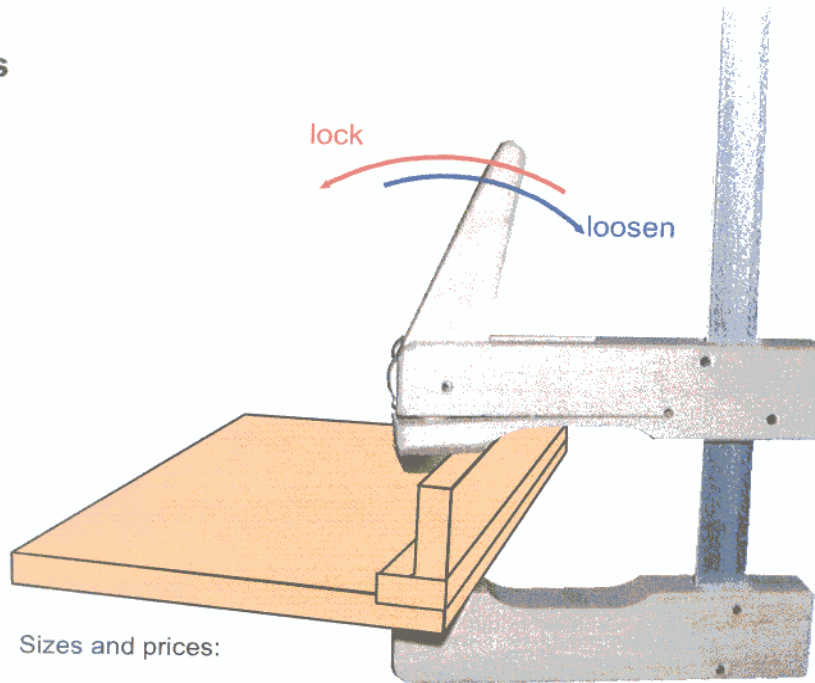
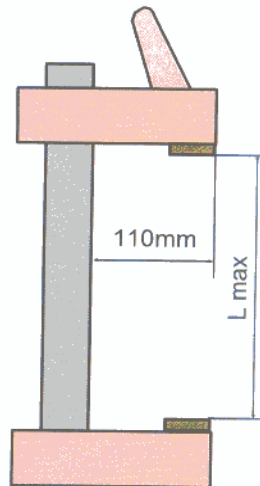
- with a negative angle (-5°) for a chipfree cut
- Carbide for long durability
- Heavy duty body, 300 mm diameter, 96 teeth



Albin Kraus: clamps

3. Wooden clamps

- ✓ excenter technique
- ✓ cork-layer
- ✓ very quick
- ✓ stable
- ✓ different sizes available
- ✓ light-weight construction
- ✓ the economic alternative



Sizes and prices:

C 89.2	Lmax = 200mm
C 89.3	Lmax = 300mm
C 89.4	Lmax = 400mm
C 89.6	Lmax = 600mm
C 89.8	Lmax = 800mm

Albin Kraus cutting tools : AK8 backsplash router (optional)

A must-have for the professional fabricator!

Coved backsplashes are the main-advantage of solid surface and should be done on every kitchen- and bath-top!

The NEW machine with buildt-in transmission for greater milling power!

**Order now the best
AK 8 ever!**

Possible radius 0-14mm

Combined guiding and
exhaust system

x-large base-plate

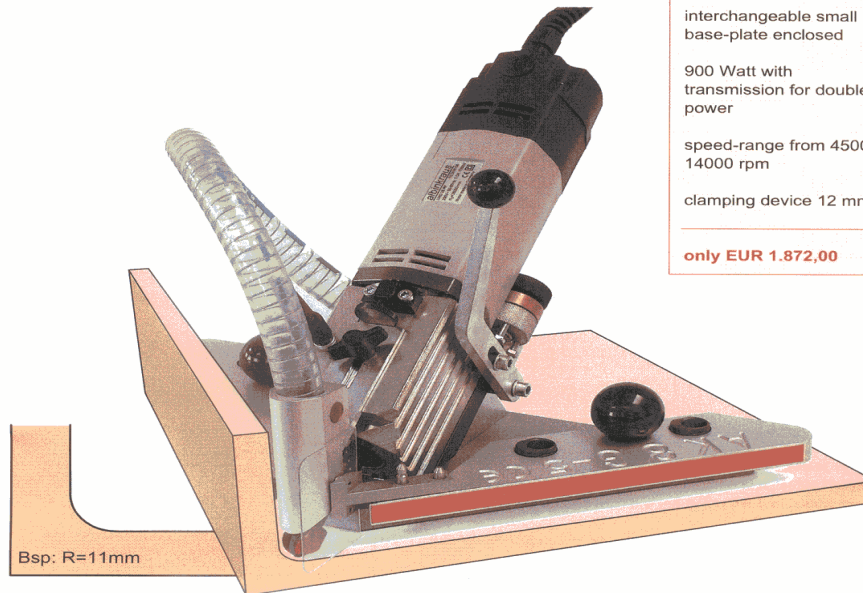
interchangeable small
base-plate enclosed

900 Watt with
transmission for double
power

speed-range from 4500-
14000 rpm

clamping device 12 mm

only EUR 1.872,00



Have it all!

Options: **drainbord-sledge WAF 8**
Vertical-table

More information next pages!



corian.

Albin Kraus contact data

Ask for info and prices

Robert Kraus,

Tel : ++43-2272-82077

Fax : ++43-2272-82077-20

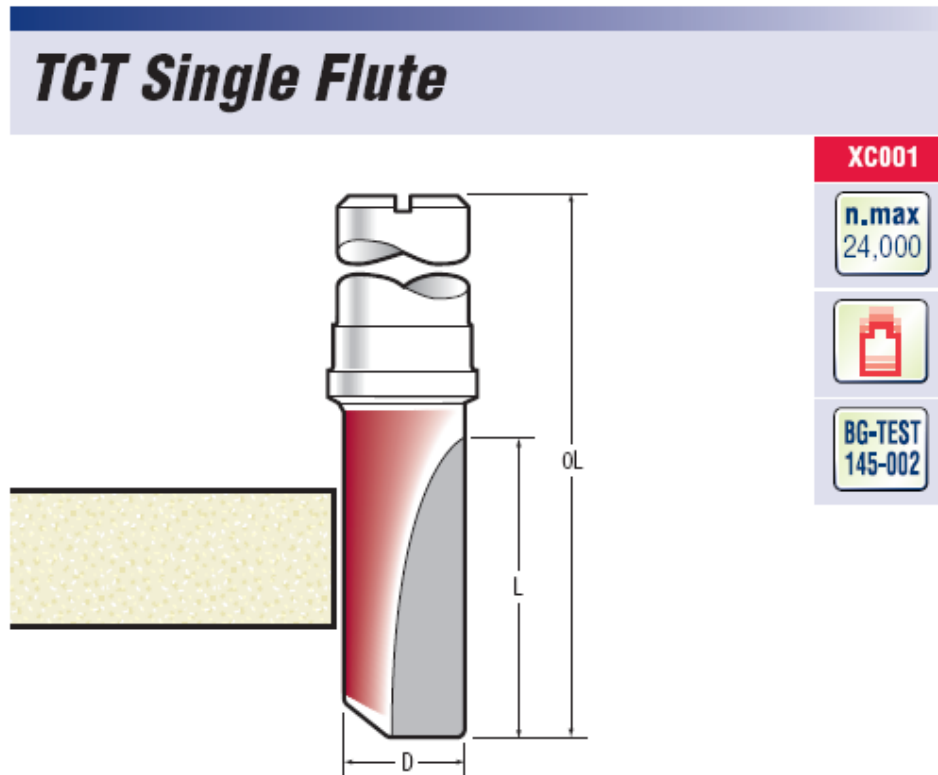
Mail : service@albinkraus.at

www.albinkraus.at



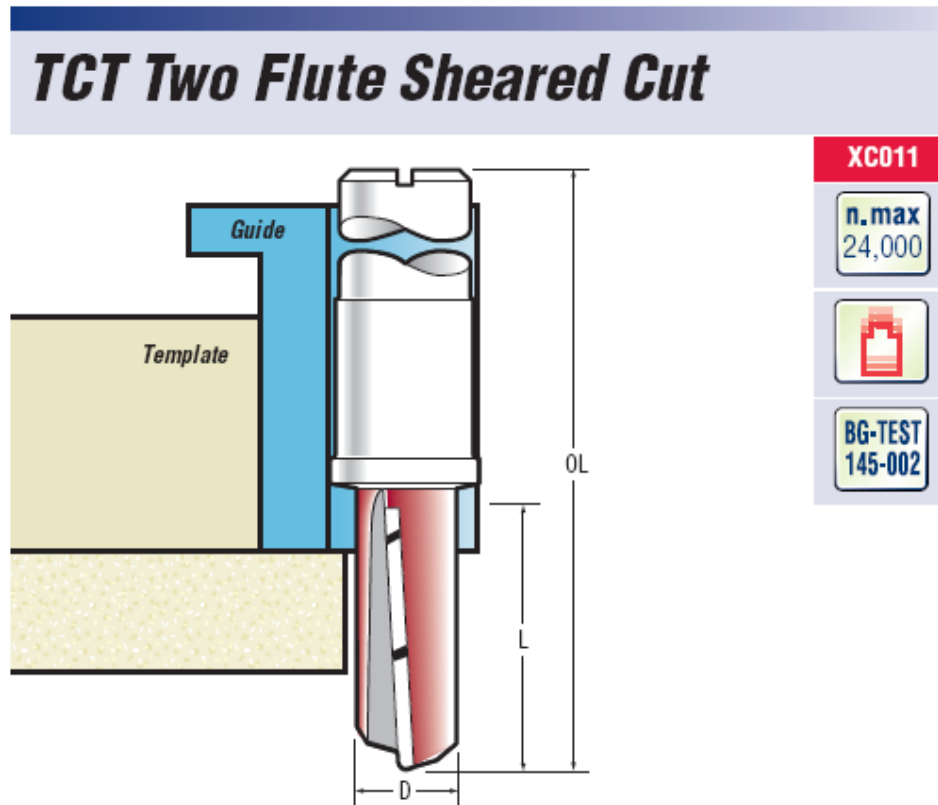
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Titman cutters for Corian : single flute cut-out



A high performance, single flute, cutter for extra clearance when cutting apertures & shaping work. The single flute gives a stronger backing support to the cutting edge.

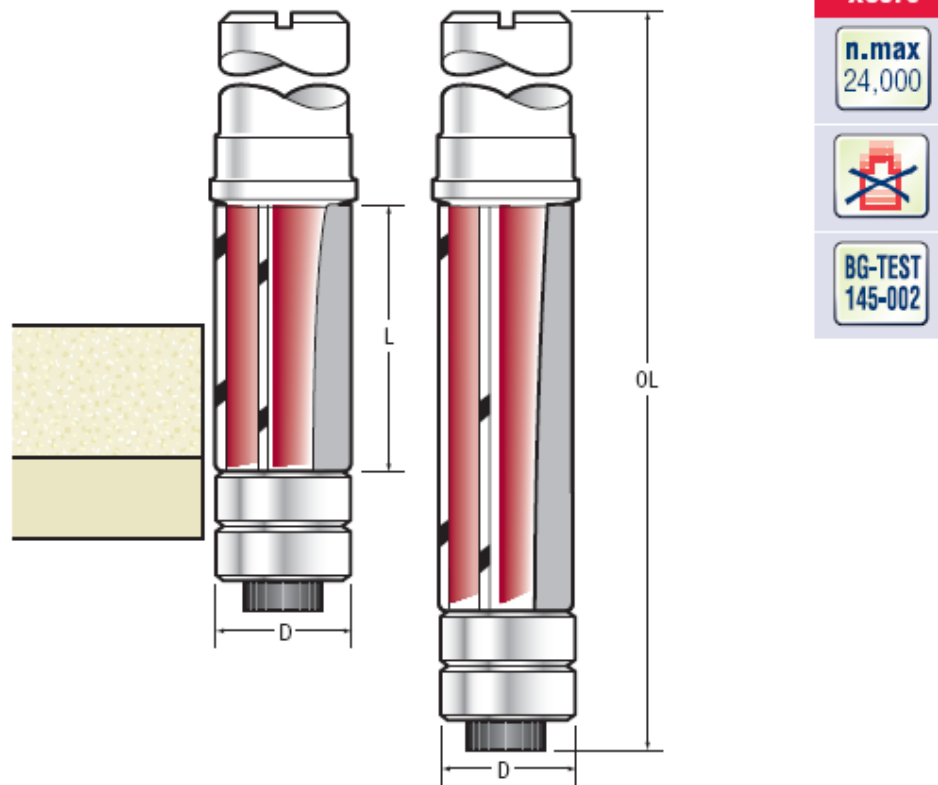
Titman cutters for Corian : double flute (required for mirror-cut)



Shear action downcut to reduce breakout for longer life and improved performance.
Pushes waste material away from the operator.

Titman Trimming cutters.

TCT Triple Flute Inlay Trimmer

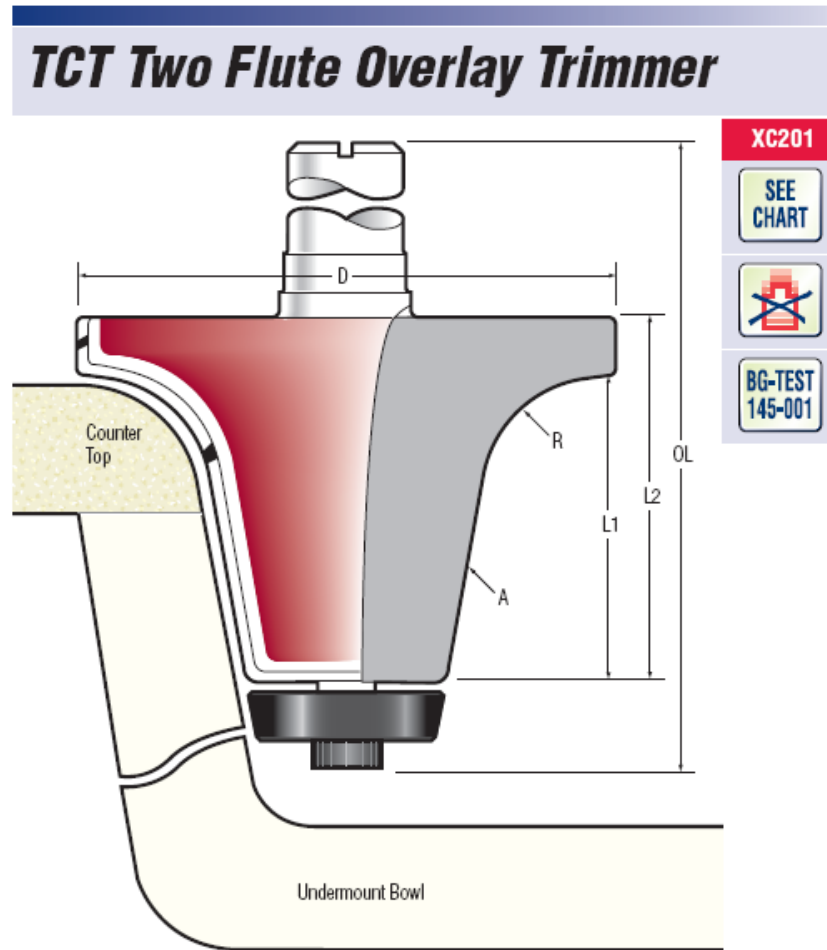


Self-guiding triple flute cutter for extra fine trimming. Suitable for most edge trimming operations.



corian.

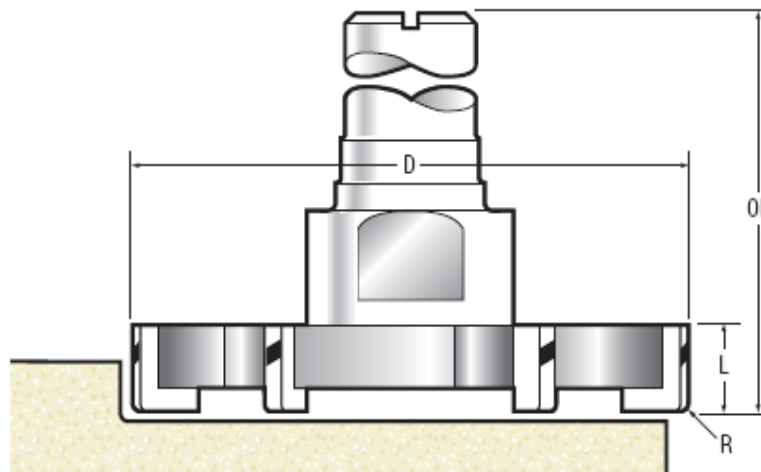
Titman cutters for Corian : bowl trimmin cutter (12 mm shank , radius 12.7)



A range of cutters for most popular bowl angles and cut lengths, including Corian bowls nos: 802, 809, 810, 871.

Titman cutters for Corian : backsplash rebate cutter

TCT Six Flute Rebate



XC401

n.max
16,000



BG-TEST
145-001

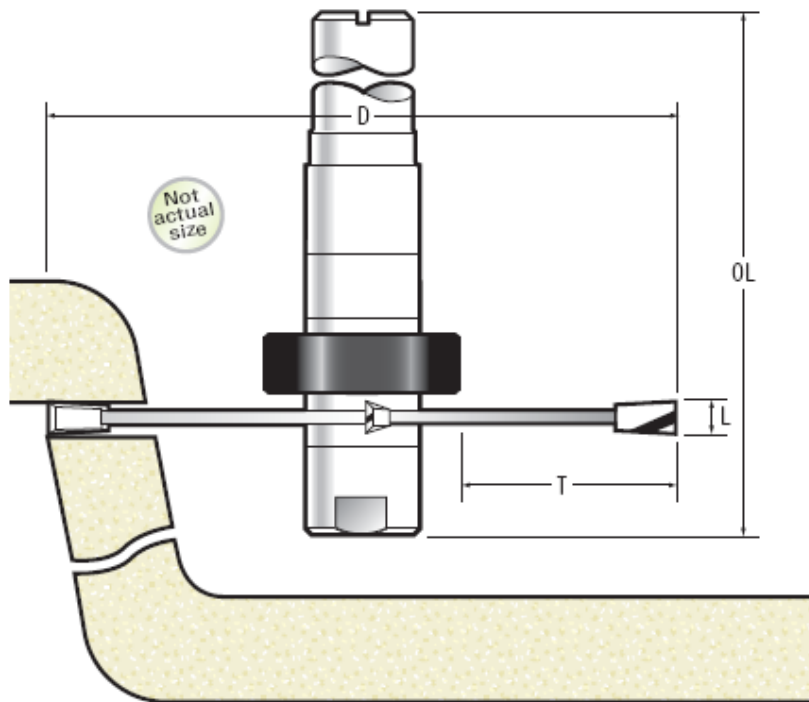
For trimming bowls, trepanning and face milling. Ideal for removing flashing and large surface areas of raised draining board channels.



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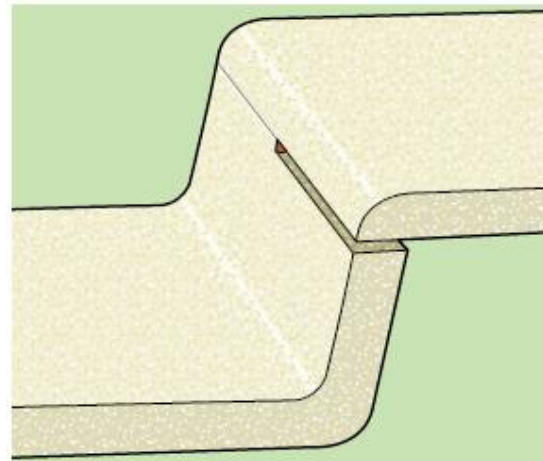
Titman cutters for Corian®: bowl cut-out

TCT Four Flute Sink Repair



XC406

n.max
18,000



Has many cutting and grooving uses in decorative and repair work. Particularly suitable for bowl replacement.

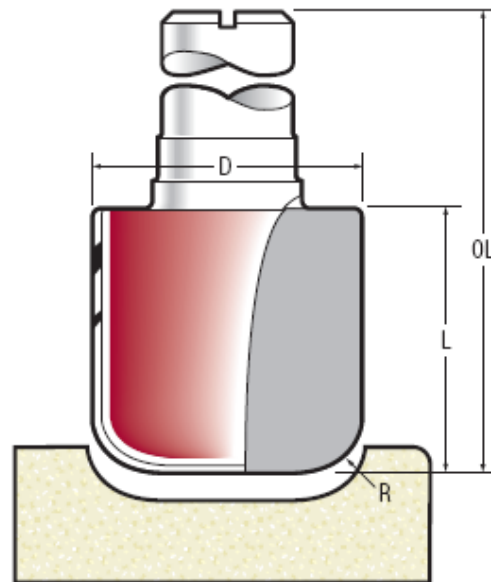
Picture to left shows method of removing bowl from worktop.



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Titman cutters for Corian®: Drain board

TCT Two Flute Drain Board *heavy duty*

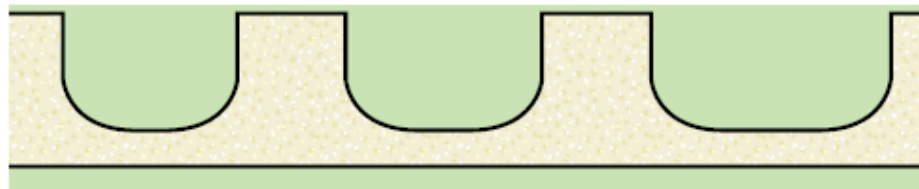


XC356

n.max
24,000



BG-TEST
145-001



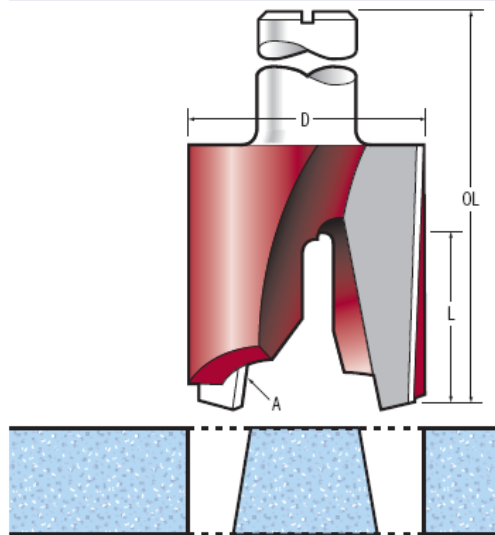
Primarily used to produce drain board channels. For window sections, designed to help displace water and moisture off window and door frames. Can also be used as soap dish cutter. For use with template and guide bush.



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Titman cutters for Corian®: repair hole and plug

TCT RPS Bevel Plug



XC906

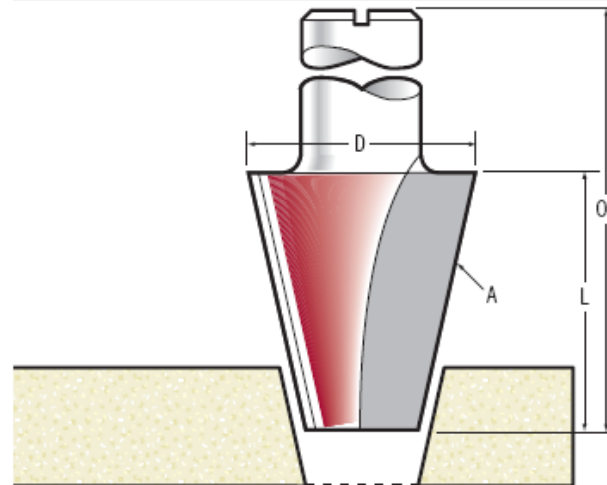
n.max
18,000



BG-TEST
145-001

To make accurate plugs which will fit into the bevel holes for repair or decoration.
XC901 cuts holes suitable for XC906-18 & XC 906-23.

TCT RPS Bevel Hole



XC901

n.max
24,000



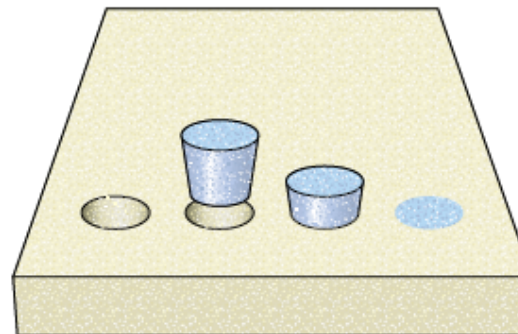
BG-TEST
145-001

These bevel hole cutters are specially developed to bevel an existing hole or to make new bevelled holes.

TCT RPS Cutter Set

Use the Titman Plug system for a perfect repair.

Specially made tooling for repair of 'wrongly made' holes and also for decorative effects using plugs in other colours.



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Titman contact data

A complete and detailed guide for Corian cutters is available in PDF format

www.titman.co.uk

Ask for more details at : titman@minderhout.nl

Handtools:

- * **Routers**
- * **Sanders**



Handrouter

Router:

Power: 1850 Watt or more

RPM: 8,000-22,000 rpm

Collet Diameter: 6 to 12 mm



Festool routers are used in our training sessions

Similar router types can be ordered via supplier website as below

www.festool.com, www.dewalt.com, www.makita.com, www.dynabrade.net

Hand machine tool : router

- - Centred copying ring clamped without tools for simple and fast change.
- - Optimised precision and no twisting of the base plate during routing through clamping of the double column.
- - Easily installed extraction adapter and impact hood with 360° rotation ensure perfect extraction.
- - Convenient router bit change with lock ensures release of the clamping collet without conversion of the spanner.
- - No reworking required thanks to the fast and accurate setting of routing depth with zero function and accurate locking.
- - Intelligent MMC electronics ensures that the routing is material-specific by maintaining a constant speed.
- - Simple change of the adapter rods through quick release and firm clamping of the stops with a clamping screw.
- - plug it-system prevents hoses and cables from entangled during tool changes.
- **Reference 574243 www.festool.com**



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Orbital Sander

- Festool sander Ro 125 order ref 571.533 www.festool.com



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Belt Sander

Specifications:

Belt size: min 100 mm width

Belt speed 1,640 ft./min.

AMPS: ± 11.0

Overall length: 13-7/8"

Possible suppliers:

www.festool.com

www.dewalt.com

www.makita.com

www.dynabrade.net



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Sandpaper



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Sanding guidelines.

GLOSS LEVEL	MATT		SEMI GLOSS		HIGH-GLOSS
	solid and veined colours		all non-solid and non-veined colours		all colours
CORIAN® COLOUR FAMILIES	Genesis, Venaro & Design Portfolio (Solid)		Sierra, Summit, Magna, Jewel & Design Portfolio (Patterns)		all families
STEPS TO FOLLOW	FILM				
Step 1	100/80 µ	80/100 P	100/80 µ	80/100 P	100/80 µ
Step 2	60 µ	120 P	60 µ	120 P	60 µ
Step 3	Maroon Scotch-Brite™ 7447 or useit™ Superpad S/G 240	180 P	30/ 40 µ	180 P	30 µ
Step 4		Maroon Scotch-Brite™ 7447, useit™ Superpad S/G 240 or Mirka Abralon P 500	Gray Scotch-Brite™ 7448 or useit™ Superpad S/G 600 or Mirka Abralon P 500	240 P	15 µ
Step 5			Paper towel	320/360 P	9 µ
Step 6				Gray Scotch-Brite™ 7448 or useit™ Superpad S/G 600 or Mirka Abralon P 500	Finesse-it™ Finish Compound
Step 7				Paper towel	



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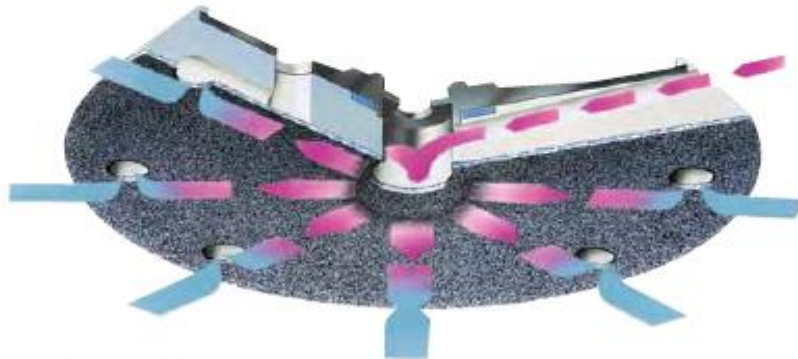
Possible suppliers.

- **Festool:** www.festool.com
- **Mirka:** www.mirka.com
- **3M:** www.3m.com



Festool Technology

Jetstream principle

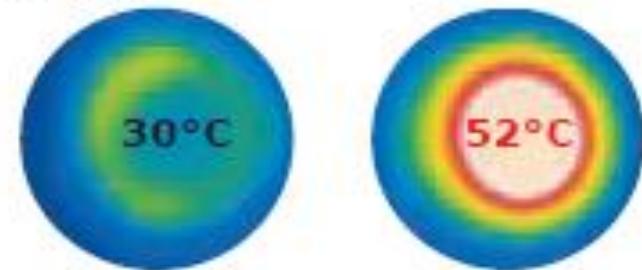


Festool abrasives and tools work with the patented Jetstream principle: an additional hole in the centre and two air ducts prevent a vacuum from forming during dust extraction.

With Jetstream | Without Jetstream



With Jetstream | Without Jetstream



With Jetstream | Without Jetstream



DU PONT

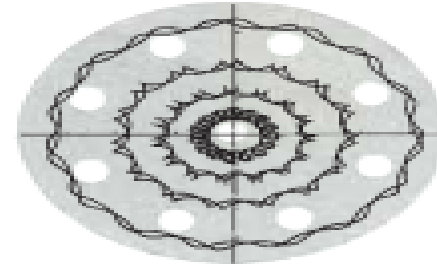


n.

Festool System

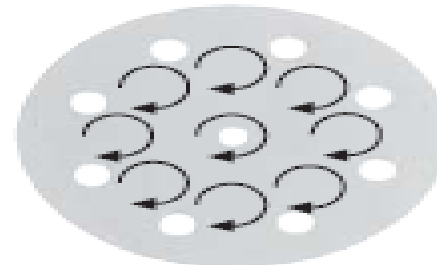
Coarse sanding/material removal

Efficient material removal and a clean sanding pattern with the ROTEX rotary motion: a combination of eccentric and rotary motion that maintains a low surface temperature.



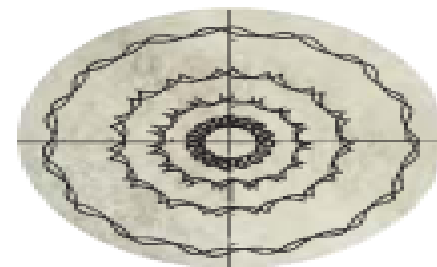
Fine sanding

Extra-fine sanding pattern thanks to eccentric motion.



Polishing

The ROTEX rotary motion produces shiny, hologram-free surfaces: a combination of eccentric and rotary motion that maintains a low surface temperature.



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Rough sanding step

FESTOOL **Cristal:** Stickfix Ø125, P100 Ref 494 045

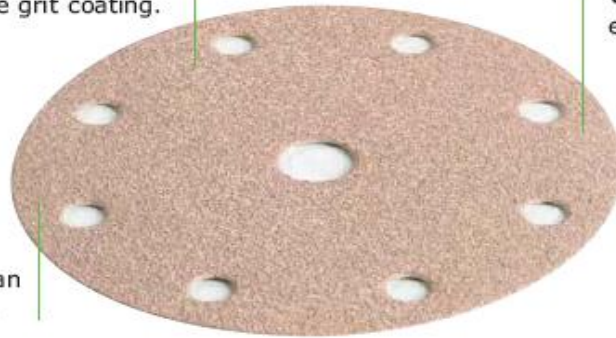
FESTOOL
Cristal

Extremely aggressive for all heavy-duty applications

High resistance to clogging and maximum material removal when coarse sanding due to sparse grit coating.

Outstanding preliminary sanding quality and an even surface finish for subsequent sanding processes.

Wear-resistant grit for an extended usable life.



DU PONT

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Finishing step

Festool Titan 2: Stickfix Ø125

P 150 REF 492 338 - P 180 REF 492 339

P 240 REF 492 341 - P 360 REF 492 344

FESTOOL
Titan 2

The all-rounder for preparation of coarse and fine sanding

Dust-repellant stearate coating for less contamination and a longer service life.

Tear-resistant, flexible resin bond prevents the abrasive grains from breaking off.

Grit made of very hard and tough aluminium oxide for long usable life and outstanding material removal.

Homogeneous abrasive grains for uniform surface finishes and less re-work.

Latex-coated support material for high flexibility and soft sanding.



DUPONT

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Final finishing step

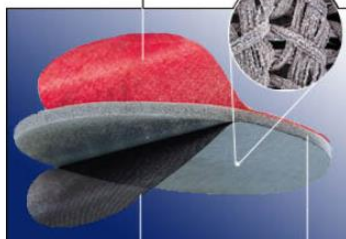
Mirka

ABRALON®



Hochfriktions-Velours (Velco)
für GRIP-Kleithaftung

Vergrößerung des Schleifnetzes
Schleifkörner haften durch eine Kunststoff-Bindung an den Netzmaschen



Schleifnetz
luft- und flüssigkeits-durchlässig

Schaumstoff
druckausgleichend
wasserabsorbierend

- A unique product for fine finishing and prepolishing gelcoat, SMC, glass fibre reinforced plastics (GRP), lacquers etc.
- Ideal for sanding contoured surfaces and moulds, for marine industry etc., especially in combination with the Mirka Interface pad.
- For high quality surface finishing demands.
- Reduces working time when finishing and polishing.



dry and damp machine or hand sanding.

Knitted fabric allows free flow of water and air and the sanding dust is removed efficiently, which gives ABRALON long life.

Optimized design.

Technical specification

Grain	Silicon carbide
Bonding	Special resin
Backing	Knitted fabric on foam
Coating	Special ABRALON® method
Colour	Grey
Grit range	P 180, P 360, P 500, P 600, P 1000, P 2000, P 4000

11/27/2008 DUPONT CONFIDENTIAL



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Final finishing step

3M Scotchbrite Ref 7447:
Solid and veined colours
UPC: 0-48011-04029-5



3M Scotchbrite Ref 7448:
Non-Solid & Veined colours
UPC: 0-48011-04028-8



www.3m.com

Dust Extraction



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Festool dust extractor CTL 33

- Power consumption 350-1200 W
- Airflow max. 3800 l/min
- Max. vacuum 23000 Pa
- Filter surface area 14000 cm²
- Rubber-insulated mains cable 7,5 m
- Container/Filter bag capacity 33/30 l
- Dimension (L x W x H) 625 x 380 x 660 mm
- Max. appliance socket connected load 2400 W
- Weight 15,5 kg



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Lamello (Optional)



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Lamello machines (optional)

For – e.g. temporary - joining (exhibitions....) lamellos can be used

Use the transparent plastic lamello as the type C20 here below

Available from www.lamello.com , pdf files on the site, select region



Seaming & Clamping



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Don't forget the glue and the glue-gun.... 😊
pick the right type from the Corian pricelist



Clamping Tools

Clamping is critical !

Comparison vs wood

=> Many of these may be needed



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Clamps

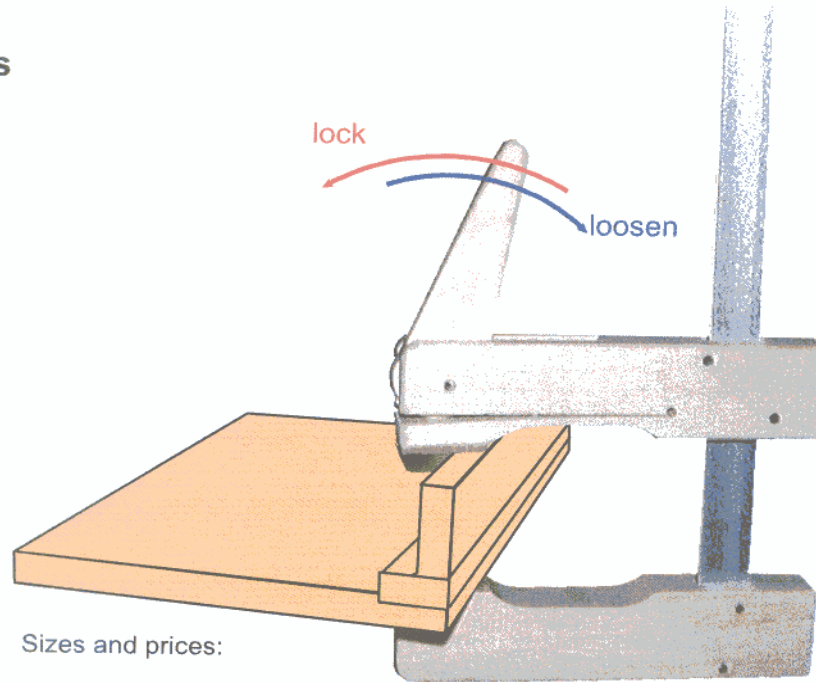
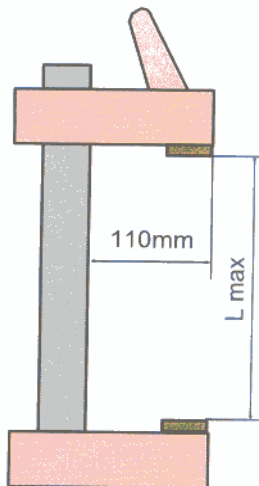


- You will need MANY clamps !!! 😊

Wooden clamps (ex from Albin Kraus)

3. Wooden clamps

- ✓ excenter technique
- ✓ cork-layer
- ✓ very quick
- ✓ stable
- ✓ different sizes available
- ✓ light-weight construction
- ✓ the economic alternative



Sizes and prices:

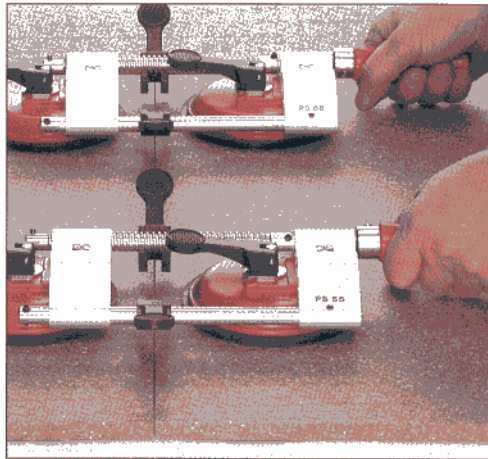
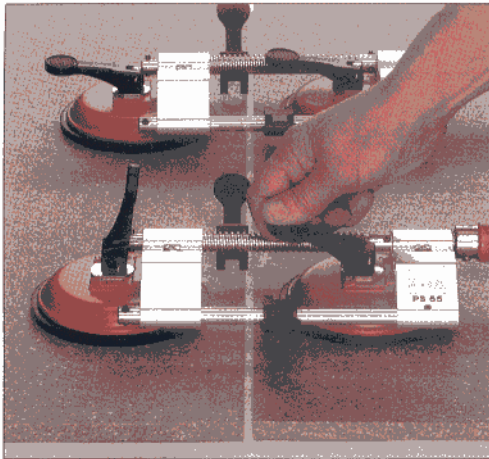
C 89.2	Lmax = 200mm
C 89.3	Lmax = 300mm
C 89.4	Lmax = 400mm
C 89.6	Lmax = 600mm
C 89.8	Lmax = 800mm

Bessey Clamps.

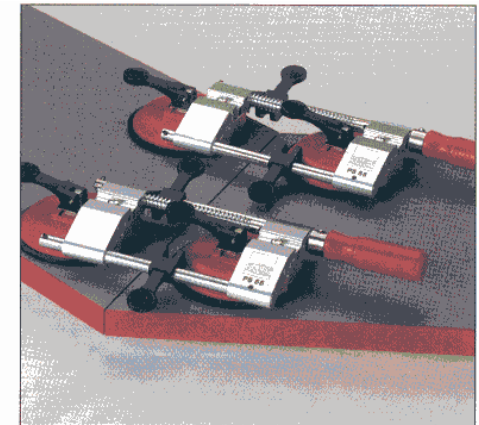
Very handy, time-saving, Bessey clamps type PS55,

Available from Bessey, www.bessey.com, info@bessey.de

Fax export ++49 (07142) 401 452 , tel ++49 07142 4010



Gegebenenfalls Höhenunterschiede der



Spannen von dünnen, beschichteten Platten

Basic Handtools & Accessoires

Handplane and Chisel

And of course,let's not forget the basics ☺

To carefully remove glue (seams...)

For easily removing hot melt glue



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Paper towel and ethanol, straight edge ...

Be sure to use a paper towel which absorbs dust but does not loose colour or fibres.

Always use ETHANOL (clear denatured alcool)

Straight edges (guides) for routing



Static Industrial Equipment



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Static industrial machine tools for Corian®

Below is a list of industrial machines you will need for fabrication of Corian. We have selected machinery from companies that

- In our experience - offer outstanding quality and service



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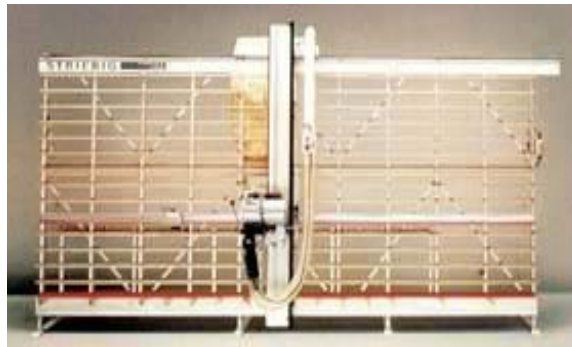
Saws some examples

Table saw:



- versatile
- most accurate
- **a must!**
- angle cutting

Vertical panel saw



- save space but needs height!
- versatile
- save lifting
- 1 man operation

Beam saw



- Lots of space but high production rate
- panel stacking
- powerful
- precise



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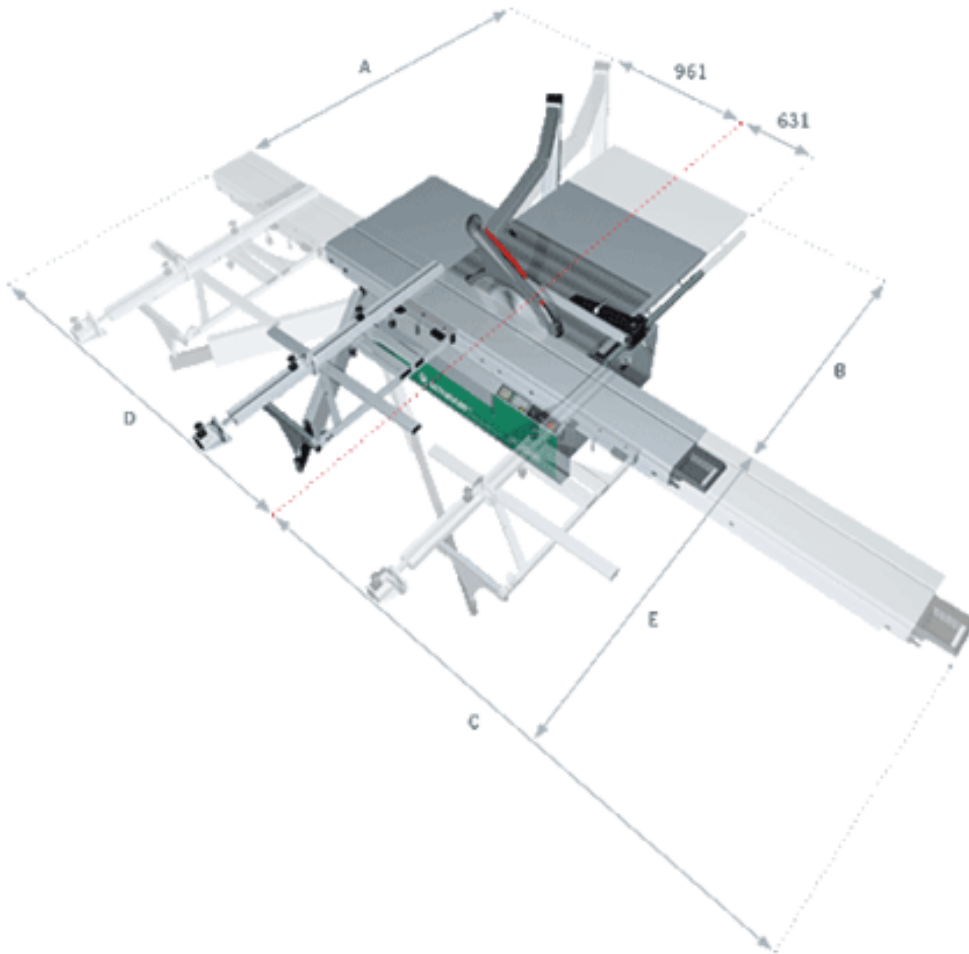
Tablesaw Altendorf

- Altendorf table saw, high accuracy, reliable technology
- Pricing : around € 22.700 (2008) , may vary depending on type and extra options
- Info : www.altendorf.com
- **A complete and detailed manual is available in PDF on the website**



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Example: Altendorf F45



- This drawing may help you to calculate the space needed in your workshop...
- Remember the wagon may roll out to as much as 3650 mm ...

Correct Saw Blades

General Guidelines:

- Triple chip grind
- Negative hook (*between -5° and -7°*)
- Heavy stock (*minimum 3.5 mm*)
- 96 teeth for 300 mm diameter
- Appropriate speed (*between 3500 rpm and 4500 rpm*)
- Feed rate on the saw should be about 3 m/min



Tip: select saw blade used for cutting aluminum



Use the correct sawblade

Be sure to use a correct *sharp* sawblade

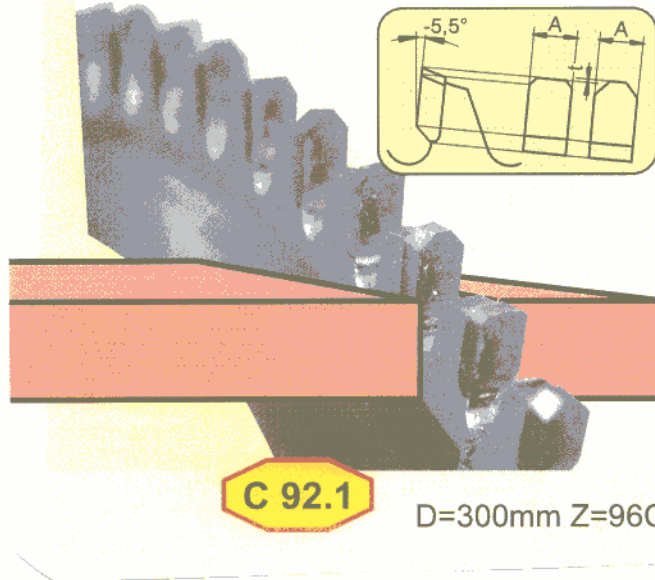
Good quality sawblades are available at

www.albinkraus.de ref. c92.1 (picture below)

www.titman.co.uk ref 1.521.300.30 or similar

www.leitz.org

Ask your dealer for a detailed description



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Spindle moulder

- **Spindle moulder**
- speed (rpm): 1400, 3500, 6000, 8000 rpm
- May help you to produce f.ex. backsplash cuts in a fast way
- quality machines available from f.ex. Guillet
- info@woodworking-guillet.com
- www.woodworking-guillet.com



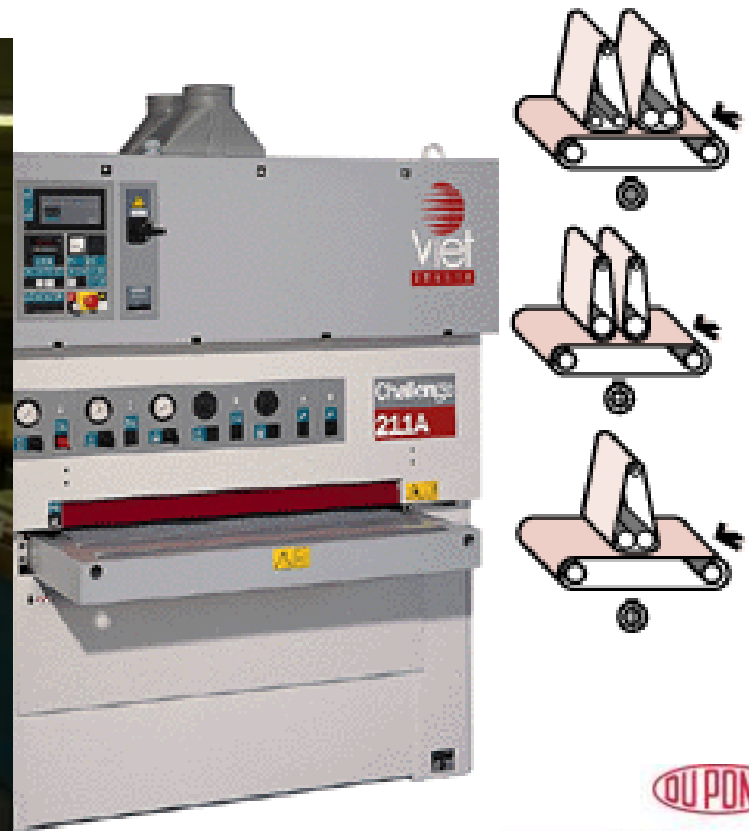
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Belt sander

Wide belt sander: for e.g. calibrating thickness

Save time and money

Below is a model from Viet Italy (www.viet.it) but of course other brands will do the same job



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Special applications for Corian : V-grooving

- Without any doubt the fastest way to produce countertops, V-grooving machines lead you to many other creative possibilities of working with Corian .
- Save on production cost, sanding time, ...
- Below is an example of Star V Machinery
- **Contact : Leslie Lengyel, starv@bellnet.ca, www.starVmachinery.com, toll free nr 800-296-6831**
- You will find interesting examples and cost justification on the website
- Tape for v-groover :
 - www.allstaradhesives.com
 - jjmurphy@allstaradhesives.com
 - 1-800-878 (7827)



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Special applications for Corian : V-grooving



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Special applications for Corian : V-grooving

Example of v-grooved backsplash and front edge downturn



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Special applications for Corian : thermoforming

- Thermoforming allows you to be more productive, creative and get the most out of your Corian. Combined heating and vacuum press tables are available from Elkom. They also offer a wide range of other applications and related tools
- Working area : 2200 x 1300 mm
- Working platen: ÖKOTHERM heating-cooling-platen
- Preheating: pre-heating station integrated with automatic opening and closing by drawer
- Vacuum-control: electronic digital meter
- Additional heating from top by infrared heating-field with 24 kw power, up to 230°C with free programmable SPS-control system
- Extremely rugged construction made of steel
- Contact elkom@elkom.de, www.elkom.de
- Thomas Schalm ++49 5731.778214



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Special applications for Corian : thermoforming



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Special applications for Corian : thermoforming,
using a press for moulds

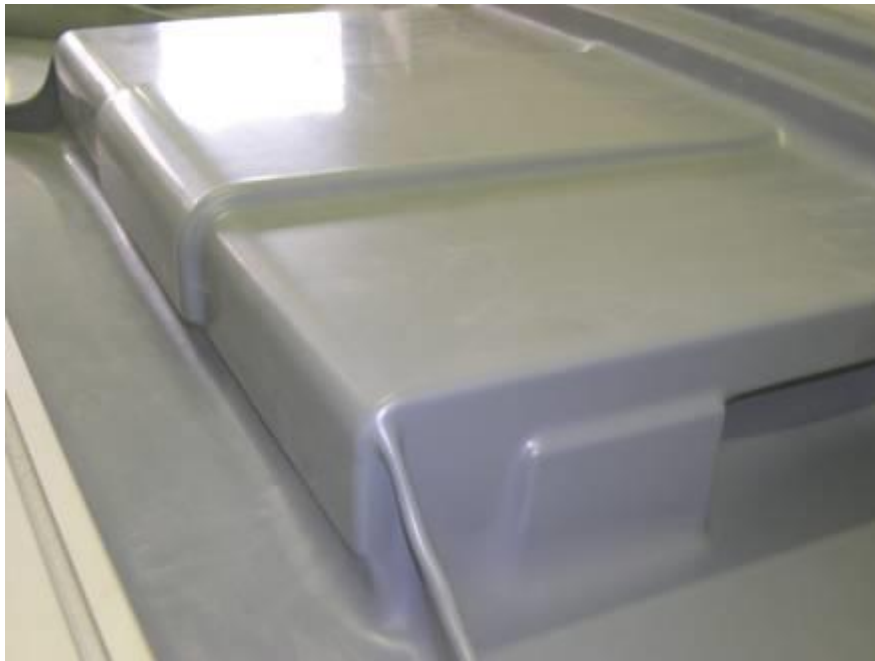
Below is an example of O M C N Italy



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Special applications for Corian : thermoforming,

Example of thermoforming , using a mould,
on an Elkom heating / vacuum table,



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Special applications for Corian : sublimation

- Sublimation allows you to print pictures on Corian, and offer you customers creative solutions e.g. in applications for lights, publicity Tables are available from Elkom. **Electronic controlled and supervised vacuum-system, electronic controlled and supervised heating platen and cooling system, automatic-program for any heating-cooling ramp, stepless temperature application from 20° C up to 200°C.**
- All info and pricelists are available in PDF on their website
- Contact elkom@elkom.de, www.elkom.de
- Thomas Schalm ++49 5731.778214



Moulds

- There are many suppliers who can make good moulds,
Here's a supplier from Germany who delivers very good quality
and has the possibility to make moulds specifically for Corian

<http://www.hanneke.com/>

Special applications for Corian : sublimation printing tools

Printing paper :

Ink :

Printer type :

Software :

- Delta Color
- Herr Brüntrup
- Bleichstrasse 40
- D-33607 Bielefeld
- 0521 / 380 930 00
- info@delta-color.de
- www.delta-color.de



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Special applications for Corian : sublimation printing tools

