

# Processing Manual

\*IMPORTANT NOTE: NEVER REMOVE PE FILM FROM SURFACES BEFORE INSTALLATION!

## CNC Routing

**CNC Routing is the most common technology to cut and shape Acrylic Couture panels.**

When considering tool options - a steel knife composition must be chosen to take into account the embedded inlays.

The speeds of these machines must be assessed to obtain a translucent sanded-look cut.

Spindle rotation speed can be adjusted from 3.000 to 25.000 rpm and the speed of cutting must not exceed 2 meters/minute.

Diamond-coated tools obtain a perfect cut and can be used with some limitations: some inlay fabrics contain steel, which will lead to a premature loss of efficiency of these kinds of tools.

## Laser Machines

Laser cutting of PMMA is possible however due to the inlays within the panels it is not recommended for processing Acrylic Couture.

## Water Cutting

Water cutting offers a nice, sanded finish cut.

No limits on this technology apply to Acrylic Couture.

## Circular & Linear Saw Machines

To cut raw panels, circular saw blades with a diameter of 300 to 400 mm can be used.

The typical rotation speed is 3000 top 5000 rpm.

Blades i.e. 350 mm in diameter should not have less than 30 teeth and no more than 80 teeth. Blade thickness is suggested to be not less than 3mm to avoid induced vibration by thick sheets.

Liquid cooling on the blade is not necessary even if recommended.

Steel blades should be used, considering both the plastic nature of the panel and the hardness of certain Acrylic Couture's fine metal fabric inlays.





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## Polishing of Edges, Surfaces

### Edges can be polished easily:

The first pass if necessary is to remove irregularities off the cut using abrasive tools such as: glass paper, abrasive discs, sand machine etc.

After this pass edges will look regular and sandy in appearance.

With a polishing paste and a cotton rotative disk, it is possible to polish the edges to a transparent glass cut.

Scratches on the surface can be removed using this same process.

Additionally, this Sanding procedure using the following grits will achieve a nice polish:

320G, 400G, 600G, 800G, 1000G, 3000G

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## Glueing

Acrylic Couture panels can be glued like conventional cast acrylic sheets (PMMA).

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## Temperature Range

Acrylic Couture panels can vary in temperatures ranging from -40°C to 70°C.

Expansion and contraction should be considered when framing and fixing the panels. (Refer to the dilatation constants of PMMA specified in the datasheet.

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## Tolerances

**Thickness:** +-0.6 mm+10% of the nominal thickness (extended UNI EN 7823)

**Sheet dimensions:** +-3% on nominal size

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## Food/Human Contact

Acrylic Couture panels are manufactured according to EU rules for food contact and EU standards for fashion accessories applied to the human body.

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