

FOAMALITE®

MACHINING

- Thin FOAMALITE® sheet can be cut with a strong-bladed utility knife.
- Vertical cutting machines are a very good method of carrying out cutting work on FOAMALITE® sheet without causing scratching.
- Shearing with guillotine cutters will lead to compression and some one-sided rounding at cut edges.
- FOAMALITE® sheet up to 5 cm thick can be die-cut with steel rule dies on a cutting plate. Ambient temperature should not be below 20 °C.
- FOAMALITE® sheet must not be laser cut.
- Circular saw blades made of alternatively arranged flat/trapezoidal tungsten carbide tipped teeth are best for FOAMALITE® sheet.
- FOAMALITE® sheet may be drilled with standard twist drill bits and on CNC machines best machined with single-edged tools.

SHAPING AND FORMING OPTIONS

■ FOAMALITE® sheet performance and characteristics may vary depending on the direction of extrusion. Sharp corners and deep notches should always run at right angles to the direction of extrusion to minimise risks of breakage.

■ FOAMALITE® sheet up to approximately 6 mm thick can be subjected to cold bending at room temperature. Care must be taken to observe the minimum bending radius (cold bending radius) of approximately 100 times the sheet thickness (e.g. 300 mm for a 3 mm thick sheet).

■ Thick FOAMALITE® sheet can undergo thermoforming by heating the sheet to approximately 130 °C. Cooled to a rigid state, the component retains the formed shape. When FOAMALITE® color is subjected to hot folding, the folded areas may appear lighter in colour.

■ FOAMALITE® sheet can be fully formed and even embossed by vacuum forming. The temperature of the sheet should be approximately 130 °C: the minimum temperature is 120 °C and maximum 160 °C. Stretched areas in FOAMALITE® color may appear lighter in colour.