

Miter Folding KYDEX® Sheet

TB - 142-B

Introduction

When laminating KYDEX® Sheet to MDF or a similar substrate a V-groove router bit can be used to create V-groove into the substrate for the purpose of bending the material to create a Miter Fold. The procedure below describes how to create this Miter Fold.

Tools Required:

- Router capable of 18,000 RPM
- V-groove router bit (similar to this <http://www.amanatool.com/bits-fv/45705.html>)

Procedure

- 1) Place the laminated board KYDEX® Sheet side down on a spoilboard to ensure the board will not move during the routing process. Clamps may also be used to keep the board stationary, but be sure they will not obstruct the path of the router during operation.
- 2) Secure the V-groove bit into the router and set the depth to slightly less than the thickness of the MDF to ensure the router does not cut through the KYDEX® Sheet.
- 3) Turn the router on and gradually sink the bit into the substrate and slowly move the router along the desired line.
- 4) Once the cut has been made and the router has been turned off and placed safely aside the fold can be created by holding one end of the board down and folding the other end upward until the two sides of the V-groove have come into contact as shown on the right in Figure #1 below.

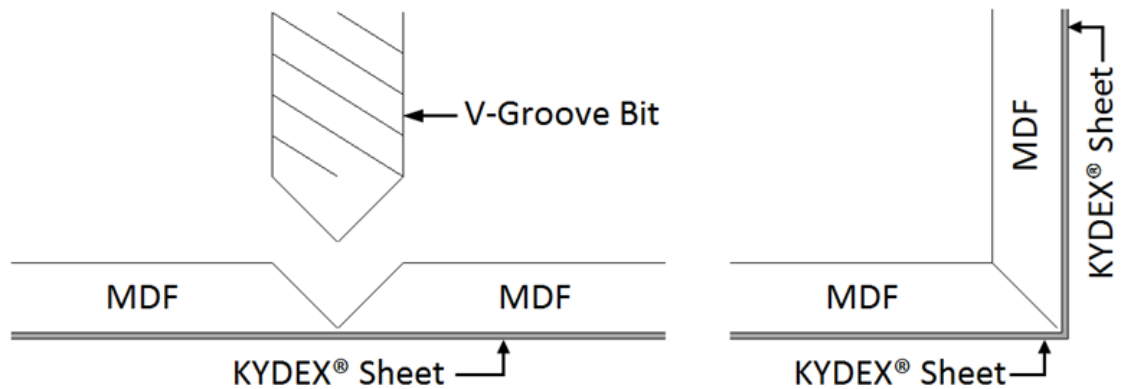


Figure 1: Miter Folded KYDEX® Sheet and MDF Panel

If stress whitening occurs after the material has been bent it can be removed by following the procedure described in Technical Brief 153-C: How to Remove Stress Whitening from KYDEX® Sheet. This procedure utilizes heat applied by a heat gun, blow dryer, or similar source to relieve stresses created by cold bending the KYDEX® Sheet.

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