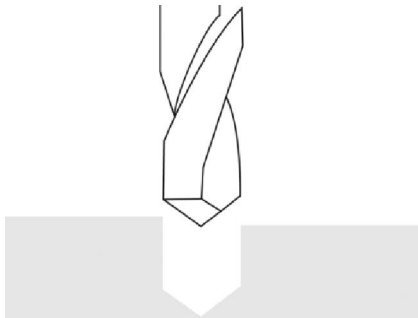

Drilling of EC-Panels with honeycomb core

Drilling



Sandwich panels can be drilled with traditional metal drills (HSS-twist drill). In case a hole diameter of more than 5 mm is needed it is necessary to predrill the panel.

If panels with non-metallic skins are drilled, a high drill speed is recommended.

In General:

The best process quality will be reached by a high cutting speed and a low forward feed.

The selection of the processing tools depends on the skin material. In case of metal skins, the surface temperature during any processing must not exceed 100°C.

When drilling you have to pay attention that there will be no peeling of the lower skin which would render the panel unusable. We recommend a supporting structure of wood.

Disclaimer

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