

Tip Sheet for Finishing Aluminum ChromaLuxe Panels

There are several options for creating a finished look to ChromaLuxe aluminum, shearing, routing, saw cutting and sanding the edge. Here are some tips for each of these options.

Shearing:

- Want to keep the shear blade gap under 0.003"
- Blades need to be sharp and free of anything stuck to them
- Suggest shearing coating side up

Sanding Edge:

- For the initial sanding, want to keep the block with sand paper at about a 45 degree angle
- After that you can smooth the edges with a side to side motion
- Suggest using sand paper in the 150–220 grit

Saw Cutting:

- Equipment that we suggest is a Striebig compact saw
- It is important to keep the material stable and minimize the vibrations
- May want to sand the cut pieces after
- Suggested tooling is a 100 tooth saw blade

Routing:

- Equipment that we suggest is a Thermwood CNC router
- It is important to have good vacuum to hold parts in place and to keep parts stabilized to minimize vibrations created with cutting
- Suggested tooling is an o-flute straight bit
 - When using smaller diameter bits suggest single fluted tool
 - When using larger diameter bits suggest using a double fluted tool
- Want to keep an eye on tool life and condition of router bits
- Feed-rate and spindle speed are subject to the equipment used, the tooling itself and material that it is made out of, as well as what material is being machined so this document does not suggest specific information for that