

## 1. Introduction

This manual is designed to provide specific guidance for on-site fabrication of EQUITONE [coloura] and EQUITONE [inspira].

## 2. Fabrication workflow

EQUITONE [coloura] and EQUITONE [inspira] panels are delivered with fully finished edges which are rectified and chamfered from the factory.

For on-site fabrication, to achieve similar edge finishing the following procedural process should be adopted.



Cut ----- Chamfer ----- Clean

## 3. Cutting machines

A rail guided plunge saw is the recommended tool for on-site cutting..

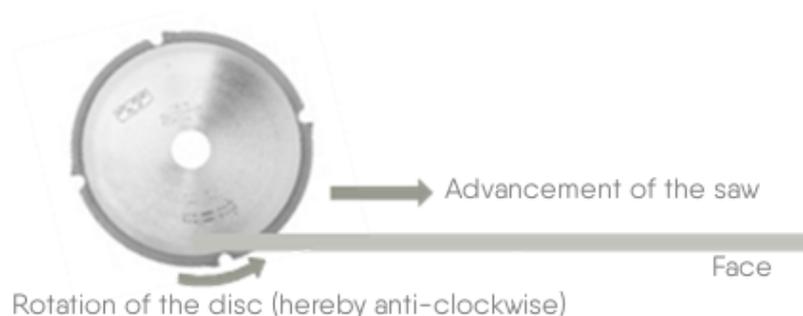


We recommend a fibre cement blade with a cutting speed of 4000-6000 RPM with an external disc diameter of  $\varnothing 160$  mm.

- E.g:
- Makita Specialized PCD, 165 x 20 mm, 4 T B-33685.
  - Bosch Expert FiberCement  $\varnothing 160$  x 2,2/1,6 x 20mm.

The depth of the blade should project at least 5mm underneath the panel.

Whether the panel is facing up or down **depends on the rotation direction of the blade**. The blade's teeth must bite first into the front surface of the panel. Therefore, if the blade cuts upwards then the panel should be face down.



Do an initial test with any new machine or blade on a waste piece of material.

## 4. Finishing the panel edge

The cut edges **must be chamfered** on the front side. This reduces the risk of damage when handling and also improves the appearance.

Manual or machine finishing are both possible alternatives:

### Machine finishing

Panel edge chamfering can be achieved by using a router with a specific milling bit.

E.g., Makita router trimmer RT0702C with a chamfer router bit.



### Manual finishing

Use 80 grit sandpaper affixed into an angled groove cut in a timber block, approx. 40 x 40 x 300 mm in size. Using a smaller timber block will result in uneven sanding.



## 5. Removal of cutting dust

Remove cutting dust immediately and completely or it may become attached to the finish of the panel.

Always use a clean dry microfibre cloth to remove fine cutting dust, these must be replaced regularly.

A special cleaning tool set (EQUITONE care kit) is available from Etex.



## 6. General points of attention

### Gloves

Dry clean, soft leather or cotton gloves must be used to prevent greasy fingerprints on the panels. Gloves should be of a type that ensures good grip and are easily cleaned. Make sure the gloves are waterproof and will not cause any risk of cement dust reaching the skin as this may cause irritation.



At times when working with white EQUITONE panels wearing cotton work gloves prevents staining.



Make sure gloves are always clean.

### Dust extraction

When cutting or drilling any cement-based material, the debris will be a fine dust. Therefore, having an effective dust extraction system is a requirement.

It is strongly advised that all EQUITONE panel Material Safety Information Sheets are read, understood and available to the operatives in the workshop.



## 7. Additional Information

Information on the different applications can be found in the Etex Façade application guidelines. They can be found on the local website or can be obtained from local support. Information about external suppliers can also be downloaded from your local websites.

## Information



Please visit [www.equitone.com](http://www.equitone.com) for contact details and further information and technical documents.

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