

MACHINING OF HPDL FACES

This bulletin is to provide guidance when face machining on plastic-faced doors requires radius corners and when the corners will be squared. These guidelines are based on the shrinkage potential of the plastic laminate when exposed to drying conditions. They also take into account how solid the surface is beneath the laminate to produce a clean cut without fractures.

Corners must include a radius when the face machining is:

- wider than 3", or
- deeper than 1/4"

Corners may be squared when the face machining is:

- 3" or less in width, and
- 1/4" or less in depth

This means openings through the door for lites, louvers and similar accessories must include a radius. Machining for faceplates and edge guards will be squared.