



# vitracore G2

NON-COMBUSTIBLE COMPOSITE PANEL / MANUFACTURED BY FAIRVIEW

## VITRACORE G2 MACHINING GUIDELINES



FAIRVIEW

DEFINING ARCHITECTURE SINCE 1963

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# PRODUCT DESCRIPTION

Manufactured by Fairview; Vitracore G2 is deemed non-combustible when tested to AS1530.1 as per the requirements as set out by the BCA.

Visually, Vitracore G2 is the same as traditional composite panel; but what makes it different is the technology of the core, which is constructed from a 100% aluminium structure rather than combustible material. While there are some slight variances to machining this product, the lightweight and rigidity make it a preferred product by many operators and installers. Please note, the guidelines for the Festool cutting and grooving technique can be used for a wallsaw also.

## MACHINING VITRACORE G2

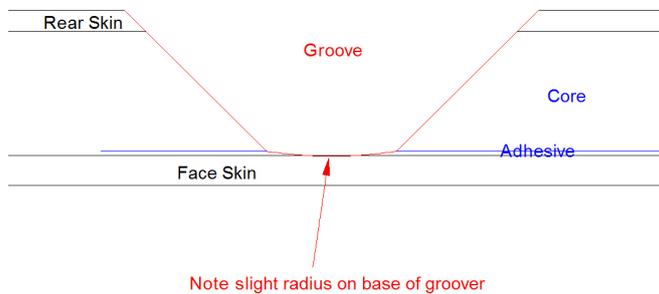
**GROOVING** - Grooving Vitracore G2 is a simple and easy process - very similar to grooving traditional ACP such as Vitrabond. Traditionally solid core ACP is grooved leaving approximately 0.3mm of core material remaining. The special profiled core of Vitracore G2 is slightly more exacting on the groove depth but does not present any issues.

For a CNC Router, the perfect depth is just brushing the rear of the aluminium face skin. The tooling is the same as that for ACP – a 90 degree V-Groover with a 3mm flat. As depicted in the diagram below, for best results the flat should be adjusted to a slight curve. This is simply done with a linisher or bench grinder. Of course, this tool still works just as well for ACP.

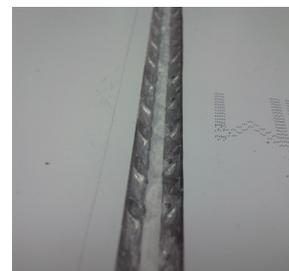
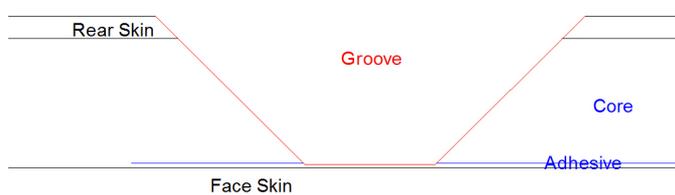
When using a Festool or Wallsaw, the grooving blade should remove all the aluminium of the core and be touching the adhesive layer on the rear of the face skin. With the Festool, the correct depth gauge roller is the Dibond4, available from Fairview. This allows the blade to cut slightly deeper than it would with the usual Alucobond4 roller. It is important that the tooling be kept sharp as blunt tooling increases heat and pressure on the panel, which in turn can reduce groove quality.

The 0.7mm face skin used with Vitracore G2 is what enables the groove depth to penetrate the rear of the face skin, while still providing the required corner strength and gentle radius on the fold. If there are concerns the groove has gone too deep and cut into the face skin of the panel, a possible solution is to glue an 'L' angle down the rear of the fold; or in a cassette panel glue the zed angle to the rear of the panel.

### CNC GROOVE



### FESTOOL GROOVE



Specific details on feeds and speeds:

	TOOLING	FEEDS/SPEEDS	COMMENTS
CNC ROUTER	Typical 90° ACP V-groover with 3mm flat. Available from most tooling suppliers.	RPM: 18000 Feed: 8-12m/min	Keep sharp. Recommended to curve the flat on the groover slightly.
FESTOOL	Standard Festool 90° grooving blade. Use Dibond 4 depth gauge roller.	Speed: 10-15m/min	Groove on a flat even surface to ensure depth accuracy.



## CUTTING

Vitracore G2 can be cut with identical tooling to that used for Vitrabond and similar ACP's. For the CNC an upspiral cutter is recommended to assist with swarf removal. There is no coolant required on the cutter or groover.

Specific details below:

	TOOLING	FEEDS/SPEEDS	COMMENTS
CNC ROUTER	6.35mm Upspiral cutter. 1 or 2 flute.	RPM: 18000 Speed: 6-10m/min	Clean panel edges if not all swarf is removed
FESTOOL	Use Festool special saw blade for aluminium.	10-15m/min	

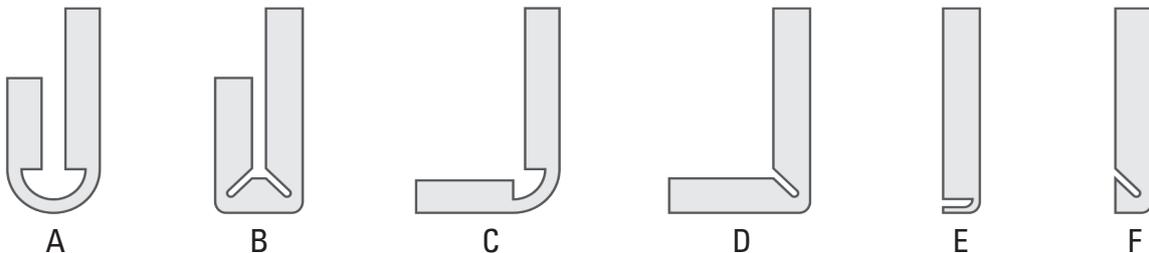


## ROLLING/CURVING

Vitracore G2 can be curved by means of a roll bending machine. It is recommended to conduct testing prior to actual production.

## EDGE CLOSE-OUT DETAILS

Vitracore G2 panel edges can be closed out as per below details:



## PROTECTIVE FILM

- Make sure no damage will occur to the panel following removal of protective film
- Remove protective film within 3 months of installation to avoid glue residuals on panel surface due to weathering
- Do not apply PVC tapes, polyurethane sealant or Silicone sealant onto Vitracore G2 protective film. The plasticiser contained in these materials can penetrate the protective film and cause a gloss change in the coating.
- Do not apply spray paint or permanent marker to the film as the colour may penetrate the film and affect the panel.

## HANDLING AND STORAGE

- Considerable care should be taken in the handling of Vitracore G2 as the panels are sensitive to impact, particularly shocks from small, hard objects, which can dent the aluminium cover sheet
- A minimum of two people should be used when sliding and stacking large sheets to avoid scratching and surface damage
- Pallets of Vitracore G2 should be stored horizontally in a cool and dry area where temperature is stable, with adequate support to prevent sagging
- Stacked pallets should be identically sized and not more than three (3) pallets high.



**FAIRVIEW**

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**AUSTRALASIA**

P / +61 2 6352 2355  
helpdesk@fv.com.au

**NORTH AMERICA**

P / +1 860 242 2711  
helpdesk.na@fairviewarch.com

**UNITED KINGDOM**

P / +01278 428 245  
helpdesk.uk@fairviewarch.com

**WWW.FV.COM.AU**