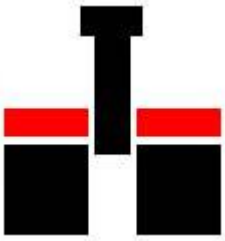
Fabricating Vulcanized Fibre

Fabrication Practices

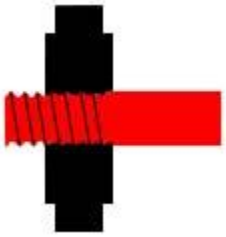
CUTTING
Thin fibre under 5 mm can be cut either with shear or rotary slitter. Thick fibre over 5mm can be cut with circular saw or band saw. Machine saw may also be used like in woodworking.

DRILLING
Use high speed steel drill of 60 angle. Higher speed than for metal working gives finer job. A bit of oiling may be recommended for better drilling for thicker fibre.

PUNCHING
Fibre can easily be punched out with an ordinary type punching press. Pre-heating (about 80C) is recommended for easier work on thick fibre over 3mm. Punching die must be of exact pitch and the guide must fit to the punch.



THREADING
Can be done by the same way as on metal by using die or lathe. Tap diameter may be 0.1-0.2mm larger than of metal and tapping can be started with second or finishing tap.



LATHE OPERATION
Lathe operations on fibre are carried on much the same as those on brass. The sake angle of tools of 20-30 degrees is recommended. Fibre can be planed on standard metal working planers.

BENDING
Fibre is resilient under the normal temperature. To bend it to a desired angle, acute, right or obtuse, soak it in water and bend while giving heat.

BONDING
Remove oil and grease substances and roughen the surface of the fibre with emery cloth or the like, and apply adhesive cement of heat curing type, like melamine and epoxy.

DEEP DRAWING
Soak the fibre in water, and draw in the heated die. Depending on the thickness of the fibre, it may be done in two steps, rough drawing and shaping.