

Working with pultrusions

Pultron's finishing department performs over 50 different finishing operations using customized technology. We carry out mass production at a low cost with rapid delivery.

If you are working with pultrusions, there are a few basic guidelines to follow for the best results.

Sawing

By Hand: A hacksaw with a steel blade or preferably a tungsten or diamond gritted blade for easier cutting.

Circular Saw: Preferred option for volume cutting. Optimum cutting speed 3000mm/minute for diamond blades. A water jet reduces cutting dust.

Ceramic Blade: with water jet to avoid burn marks (slurry collection required for the sawdust) or electroplated nickel with diamond. Use water jetting for improved blade life, slurry collection is preferred. Dry cutting requires dust extraction equipment

Routing

For best results, use an electroplated diamond blade.

Shearing and Punching

Wider punch clearance is preferable. For large quantities, special punching pultrusion techniques can be formulated. If punching is required, prior consultation with Pultron is recommended.

Fastening

Self-tapping screws in pre-drilled holes or normal nuts and bolts. Crimped and/or bonded tube ends are also satisfactory.

Drilling

Normal high-speed twist drills using the same feeds and speeds as for aluminum. Special drills can be obtained for modular drilling.

Sanding

Standard woodworking machines are used. Dust extraction is recommended.

Bonding

Surface must be abraded and degreased prior to bonding. Epoxy adhesives give good results.

Painting

Stoved or unstoved paints can be used. Epoxy undercoats give the best adhesion, but polyester and polyurethane undercoats also give excellent results. Any compatible top coat can be applied.

Sheathing

Pultron can provide pultrusion protection by sheathing with polypropylene, polyethylene or other materials.