

# 1 First, select your coating method

There are three coating methods. Your choice changes the table frame and its dimensions.

## 1 RAW DOOR FACE PANEL



### Face coating only

The face panels are coated with PVC foil first; the door is assembled afterwards.

## 2 ASSEMBLED / EDGE-BANDED



### Face coating only

The door is assembled and edge-banded first; the front and back faces are coated separately.

## 3 ASSEMBLED / UNBANDED



### Face and edge coating

No edge banding. The first face is coated separately; the other face and edges are coated in the second cycle.

## 2 Method 1 | Raw door face panel coating

With a vertical-sided frame, a 1,000 mm outside width can accommodate panels up to 900 mm wide.

### FRAME AND DOOR PLACEMENT | TOP VIEW



VERTICAL SIDES • Panel: 4 / 6 / 8 mm; some designs 18 mm

### METHOD 1 • VERTICAL-SIDED FRAME

Outside frame width **1,000 mm**

Net internal width **920 mm**

Panel to be coated **900 mm**

Table working depth: 45 mm

### PRODUCTION SEQUENCE

1 CNC profiling

2 Adhesive spray gun

3 WP PVC coating

4 Cold press / assembly

5 Door sizing

6 Edge banding

7 Handle / lock machining

### CNC REQUIRED IN ALL METHODS

Apply adhesive to the MDF/HDF face before WP coating. Suitable remaining slit foil can be used in a frame wrapping machine.

## 3 Method 2 | Assembled, edge-banded door

A sloped frame reduces the risk of the foil bursting. Only the door faces are coated.

### FRAME AND DOOR PLACEMENT | TOP VIEW



SLOPED FRAME • Assembled door: typically up to 42 mm

### METHOD 2 • SLOPED FRAME

Outside frame width **1,000 mm**

Net internal width **850 mm**

Door to be coated **830 mm**

Table depth: 65-80 mm

### PRODUCTION SEQUENCE

1 CNC profiling

2 Cold press / assembly

3 Door sizing

4 Edge banding

5 Adhesive spray gun

6 WP: each face separately

7 Handle / lock machining

CNC REQUIRED IN ALL METHODS

The front and back faces are coated separately in the WP vacuum press. Apply adhesive before each PVC foil coating cycle.

#### 4 Method 3 | The door edges are also coated

Use a sloped frame. A 75 mm gap on every side is recommended to allow the foil to wrap around the edges.

## FRAME AND DOOR PLACEMENT | TOP VIEW



**SLOPED FRAME • Leave perimeter clearance for edge wrapping**

### METHOD 3 · SLOPED + EDGE CLEARANCE

**Door width** **900 mm**

Clearance on both sides **75+75 mm**

**Required net internal width** **1,050 mm**

**Depth: 65-80 mm. 75 mm is a recommendation.**

## PRODUCTION SEQUENCE

## 1 CNC profiling

## 2 Cold press / assembly

### 3 Door sizing

#### 4 Adhesive + WP: first face

## 5 Adhesive + WP: other face and edges

## 6 Handle / lock machining

## CNC REQUIRED IN ALL METHODS

Two separate WP cycles: first one face, then the other face and edges. Apply adhesive before each cycle.

## 5 PVC foil slitting and cost efficiency

Especially in Method 1, 1,400 mm wide foil can be slit into suitable widths for more efficient use.

**EXAMPLE · CUTTING ALLOWANCES  
EXCLUDED**

**TOTAL WIDTH: 1,400 mm**



These dimensions indicate foil WIDTH. The LENGTH unwound from the roll is determined separately.

### SLITTING

Buy pre-slit foil or use a PVC foil slitting machine in-house.

### FRAME WRAPPING

Use suitable remaining strips in a frame wrapping machine. Suitable frame profiles can also be coated in a WP press.

**IMPORTANT: Calculate foil width, net working area and the frame's foil clamping allowance together.**

## 6 How do we determine the worktable dimensions?

Select the method first. Calculate table width and length for the LARGEST door you will produce.

01

Select the coating method

02

Largest door width × length

03

Calculate the net internal area

04

Add the frame allowance

### 1 · RAW FACE PANEL

#### VERTICAL-SIDED FRAME

Net internal width / length

**Door dimension + 20 mm**

Outside frame

**Net internal + 80 mm**

### 2 · EDGE-BANDED

#### SLOPED FRAME

Net internal width / length

**Door dimension + 20 mm**

Outside frame

**Net internal + 150 mm**

### 3 · EDGE WRAPPING

#### SLOPED FRAME

Net internal width / length

**Door dimension + 150 mm**

Outside frame

**Net internal + frame allowance**

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**Send: Method 1 / 2 / 3 • Largest door width × length • Door thickness • PVC foil width**

Note: +80 / +150 mm frame allowances are examples; final manufacturing dimensions are project-specific. The 75 mm edge clearance may be reduced to suit the application.