

Drilling

Through-Hole Drilling

Through-hole drilling is very similar to drilling into wood or MDF. Speed rate should be set to avoid burning or polishing the inside of the hole. Holes drilled completely through Richlite should consider tolerances of overall parts being fabricated. Part assemblies that are casework construction, attached to metal or wood, or exterior applications such as cladding should have oversized holes to accommodate the expansion and contraction of the materials. Richlite is very stable and strong and the other materials can be damaged if not considered for movement.

Pilot Hole for Tapping

Richlite is able to be drilled and tapped and has very good screw holding ability with this process. Plastic expansion inserts are not recommended as they tend to be engineered for soft compressible material and will not grip properly in Richlite. Standard tap drill specifications for metals can be used on Richlite.

Pilot Hole with No Tapping

Drill a pilot hole that is slightly smaller than the screw thread. Because of its density, Richlite is nearly impossible to screw into without a pilot hole. The pilot hole should be slightly longer than the screw. You may not be able to penetrate the hole further after your screw reaches the end of the pilot hole, and there is a possibility of damaging the product or pushing through the other side.

- Pilot holes for pan head sheet metal screws:
- #8: 9/64" – 5/32"
- #10: 11/64" - 3/16"
- #12: 7/32" - 1/4"

Equipment

- For small holes use titanium or cobalt bits
- Step drilling up from smaller sizes to larger will insure accurate hole dimensions and location accuracy.
- Hole saws are not recommended for use on Richlite. Due to its density and heat retention, hole saws do not remove enough material to work effectively before wearing out.