

# Bills Board Factory Ordering Help

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## “Finished” vs “Cut” Sizes

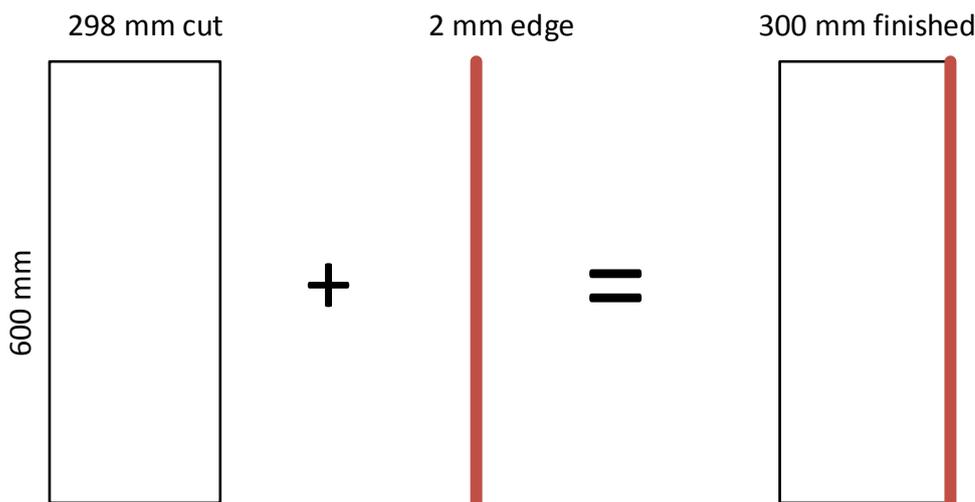
We prefer you to send us your FINISHED sizes.

BBF uses computer software to generate the quotations, panel layouts and sizes our machines will use to cut and edge panels from your order. In the old days, we'd ask you to give us the sizes to cut, to which we would apply the edge you wanted – **this is not necessary anymore.**

When you are designing your job, you are normally only interested in the finished size of the piece for your assembly, complete with its edging. If a panel has no edging its 'cut' and 'finished' sizes are the same and our software will determine that for you.

For example:

You want a shelf 300 x 600 finished with a 2mm edge along one long side. You tell us **300 x 600 1L** (1L = one long). We cut 298 x 600 and apply a 2mm band to the long edge. You get 300 x 600 1L.



## Edge-Banding Terminology Demystified

Various conventions exist in the industry for nominating panel edging. We use the 'long – short' side method, which describes the length/width dimension to edge-band. You will use this style on our downloadable ordering spread sheet (see next section). When the panel is square, this terminology can still be used without confusion.

**0S/1L = one long side only**

**1L/1S = one long and one short side**

2S/0L = two short sides

2L/2S – two short sides and two long sides – sometimes called ‘Edged All Round’ (EAR)

... and every other combination is possible from selecting the ‘banding’ drop down box.

## The Bills Board Factory Ordering Spreadsheet

Available from the link below (on our website ordering page) :

<http://billsboardfactory.com.au/docs/bbf%20web%20ordering%20spreadsheet.xls>

ASSEMBLY (OPTIONAL)	PART #	DESCRIPTION	QTY	THICKNESS	LENGTH	WIDTH	MATERIAL	BANDING	E/B TYPE
900 floor unit / 2 off		1 ends	4	16	767	560	White HMR P/B- Texture	2S/1L	1.0 mm
		2 shelf mid	2	16	868	446	White HMR P/B- Texture	0S/1L	1.0 mm
		3 shelf bottom	2	16	868	560	White HMR P/B- Texture	0S/1L	1.0 mm
		4 rails	4	16	868	80	White HMR P/B- Texture	0S/2L	mm
		5 back	2	16	868	735	White HMR P/B- Texture	0S/1L	
		6 doors	4	18	765	448	Melamine Colour 16/18	0S/2L	
450 floor drawer unit		7 ends	2	16	767	560	White HMR P/B- Texture	1S/1L	
		8 bottom	1	16	560	418	White HMR P/B- Texture	1S/2L	
		9 rails	1	16	418	80	White HMR P/B- Texture	2S/0L	
		10 back	1	16	735	418	White HMR P/B- Texture	2S/2L	
								none	

This spreadsheet is for you to download, complete, save and send to us. We send this to the optimising software when we receive it and produce a layout and parts list which we then usually send to you for confirmation, along with the pricing, and any other relevant information.

There is an example spreadsheet (pictured above) which should give you an idea of how the system works and what is required.

## Special Case (mixed) Edging

Sometimes you might want a different colour or thickness (or both) of edging on the same panel. The vast majority of jobs, however, have the same edge of a given thickness and colour on the panel. Our downloadable spread sheet does not give you the option for nominating mixed edging.

If you need special mixed edging we ask that you supply clear and neat drawings showing what you require.

## Finished Size tolerance with fractional edging

As we cut to the nearest whole millimetre, edging that is fractional like the Standard 0.4mm or some 0.5 mm bands is ‘rounded’ by the optimising software. While most of this results in insignificantly small variations in tolerance it is something we would like you to be aware of.

For example, if you order 300 x 600 1L with 0.4mm white Standard ABS banding, you will get a finished panel precisely 300.4 x 600 mm. If it was 300 x 600 2L you would get 298.8 x 600. Rarely is this an issue, as most edgings like this are shelves, but if they are doors that will be hung in a row (like you would find in a kitchen) they will be 0.1 to 0.2mm undersize. This is practically insignificant except that if you are working to a neat 2.00mm clearance in your hung door panels you will be grateful that we do this!

The popular edgings these days are 1.0 & 2.0 mm and these thicknesses avoid rounding variations.

### Special Edge treatment

We can machine a 3.0 to 6.0 radius on your panels if you need it. Just note that on the 'info' column. 18mm board is preferred if you have hinge holes as you very close to the hole on thinner boards.

### Special Cuts

Please provide drawings for mitres and angled cutting

### Hinge Holes

We can drill these for you at 35mm dia. Nominate the number of holes and the centres from the outer edge in the info column.

### Grain

Some panel finishes have grain, like timber veneers and patterned laminates that we sell. This has implications for your design and our optimising layouts. If the product has no grain we will allow the optimising software to rotate the panel for a better fit and lower waste.

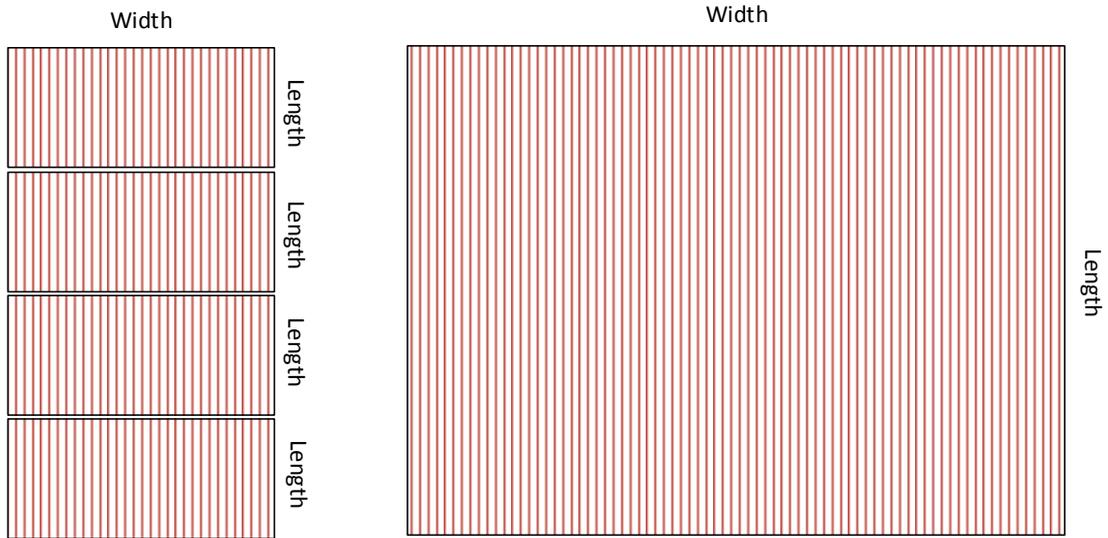
In the software that we use, the term **length** is defined to mean the dimension that runs in the same direction as the grain. **Width** runs across the grain.

If you need grain to run a particular way, always ensure that it agrees with the **length** dimension.

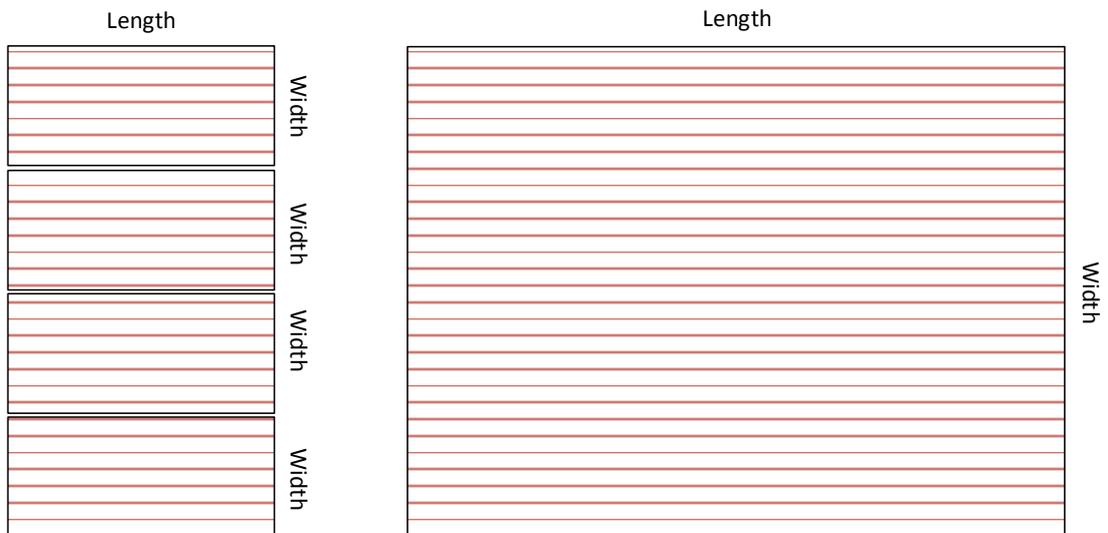
Consider the following example (grain direction shown in red):

You require some grain matched drawer fronts and a panel.

### Drawer Fronts & Panel (grain matched) – Vertical Grain



### Drawer Fronts & Panel (grain matched) – Horizontal Grain



Note how the length and width is labelled to reflect the direction of the grain. We tell the story like this to the software and check that the layout matches the grain across the drawer fronts that we cut.

[Anything Else?](#)

Call us 😊