



5224 FM 802 Brownsville, TX 78521

Phone: 888.891.4416

Email: [TigerSales@tigerdoor.com](mailto:TigerSales@tigerdoor.com) Web: [www.tigerdoor.com](http://www.tigerdoor.com)

### **Field machining of door faces – Factory recommendations**

Follow each hardware manufacturers template requirements for preparation of all face hole sizes and locations.

Please note that all through holes should be drilled first all the way through with a 1/8" pilot bit. This should be followed by drilling the desired hole diameter one half way through the door from each face. Failure to drill the door from each face may result in gelcoat face splintering.

It is recommended that all holes be machined with the following tools:

- Holes less than 1/2" in diameter – Diamond coated drill bits (40 grit) are preferred, but standard drill bits will suffice. A dull standard drill bit is highly recommended due to the tendency of a sharp drill bit to cut to aggressively into the door face leading to edge chipping around the hole.
- Holes equal to or greater than 1/2" in diameter – Diamond coated hole saws (40 grit) are preferred, but bi-metal holes saws will suffice. A fine tooth count is recommended (6 teeth per inch) for bi-metal hole saws.
- Irregular shaped holes – Round sections of holes should be performed either with a drill bit or a hole saw. Straight cuts can be performed with a jig saw our router and template guide. Jig saw blades - Carbide-grit coated jig saw blades are preferable, but a fine tooth blade meant for cutting fiber reinforced plastics will work. Router Bits – Diamond coated router bits (40 grit) are preferable, solid carbide double cut blades will suffice.

Regular hand files can be used to dress or enlarge any holes that may require it.