

HANDLING INSTRUCTIONS

Introduction:

Please read the following handling instructions carefully. We recommend to test the reactions of the material on a small sample before processing the full panels.

Storage

- Boards must be stored on a pallet completely flat at anytime
- Protect the entire boards with a cover board from the top
- Always store ample vented, dry and moisture/frost free
- Boards with veneer surface must be sun-protected
- Do not store/transport boards standing
- Put a foam film or corrugated paper between the boards to avoid pressure marks



Processing & Screwing

- Assure adequate conditioning / time to settle before processing the boards
- During processing boards need to seat solidly with at least 50% of the direct mechanical irradiated area
- We recommend primary drilling before using screws to avoid splitting
- For boards with a repeating pattern, please consider saw notches on the frontside of the board
- Thin boards up to 4,5mm thickness can be bend to a radius of 600 mm or more



Sawing

- Use sharp hard metall sawing blades
- Work with a low sawing feed rate
- Do not set the saw blade too high
- Scoring is nonessential



Milling & Drilling

- Use hard metall tools for milling and profile cutting
- All standard drilling tools for woodworking can be used



Explanatory notes:

The given details in this data sheet are our field-tested experience. They could not consider any parameter, use case or application and they are therefore without commitment. These data does not represent guarantee of condition in the legal sense or a assurance of the characteristics. No legal claims could be derived by using the information given in these data sheets or by our free of charge technical consultants.

Edges & Lacquering

- Please follow our detailed instructions in the brochure "Edge and Surface"
- Always lacquer raw panels and lacquer both sides equally
- Boards with MDF - or particle board core always need to be edge-banded
- Missing edge-band can lead to cracks in the material
- We recommend solvent-based 2K PUR lacquer
- Never use regular wall paint on the boards
- All utilized veneers cannot be stained or oiled



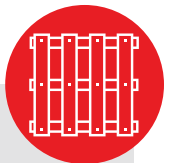
Glueing & Bonding

- Standard wood glues and adhesives can be used
- We recommend formaldehyde-free glues
- Always make sure that our material has the correspondent counter draw if glued onto another structure
- Never stick boards directly on the walls. Use appropriate mounting fittings



Packaging

- Holohedral lying on a palette
- Put a foam film or corrugated paper between the boards for protection
- For transportation boards must be evenly strapped on palette



Recycling

- Thermal/Energy recovery of the boards is uncomplicated (no PVC)



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