

INSTRUCTION FOR TREATMENT AND USAGE OF HPL COMPACT BOARDS

Treatment

Boards are worked in the same way as hard wood or laminated fiberboards. TCT or PCD tools should be used for machining. The boards may be:

- cut,
- milled,
- drilled.

The protective foil should be removed from HPL compact boards right after installation.

Overheating should be avoided while using sharp tools for cutting, milling or drilling. Boards may be also tapped or treated with self tapping screws.

Please follow obligatory construction law.

Boards cutting should start on decorative side of the board. Sharp edges should be smoothed with glass-paper.

Recommended treatment parameters:

Saw blade requirements

Shape of teeth:	trapezium flat teeth or replace a bleteeth
Material:	TCT or PCD teeth
Cutting angle:	45° entrance angle

Diameter	Number of teeth	RPM	Board thickness	Blade clearance over board
[mm]		[nr/min]	[mm]	[mm]
300	72	6000	3,4	30
350	84	5000	4,0	35
400	96	4000	4,8	40

Drills – HSS drills, cut 60-80°

Diameter	RPM	Entrance speed
[mm]	[nr/min]	[mm/min]
5	3000	60-120
8	2000	40-80
10	1500	30-60

Transport

Boards have high resistance characteristics, but there is a risk of board or board's surface harm. Special attention should be paid to prepare boards for safe transportation.

- Boards should be secured for transportation in a way, which does not allow them to move against each other.
- Pallets should be cleaned prior to stacking.
- A maximum of eight pallets may be stacked vertically.
- Protective foil should be used to protect boards against dirtiness.

Deliveries

Check reception documents and compare with deliver quantity. In case of transport damage, it must be recorded on the delivery documents and

signed by the driver.

- While unloading, both pallets and boards cannot be moved against each other.
- Boards should be placed on flat, stable surfaces.
- Special attention should be paid to cleanness while placing boards.
- Boards should be always picked up vertically. They should not be pulled or moved against each other.

Storage and installation

Following rules should be followed.

- Boards should be stored on flat, stable, dry surfaces in normal climatic conditions and should be protected from contact with water.
- Boards' edges should be aligned.
- There should be flat base material put under.
- Top board should be covered on it's whole surface by covering board.
- Boards stacked on a pallet should be packed in plastic foil.
- A maximum of eight pallets may be stacked vertically.
- Humidity should be avoided also at application (montage) place. Cover boards with foil.
- Boards cannot be leaning against walls for any reason. This may result in irreversible distortion.

Cleaning

Boards are easy to clean. Areas of light dirt contamination can be cleaned with a towel, hot water or standard, non-abrasive cleaning agents. Areas of heavier dirt contamination may be cleaned with standard solvents. Always start by cleaning a small area first whilst observing for any changes in appearance.

Special cleaning instructions for boards with UV-protective foil

HPL COMPACT BOARDS with special UV-protective foil may be cleaned with alcohol resolvers (isopropylalcohol). Any abrasive cleaning means should not be used in general. General cleaning may be done with help of pressure tools/equipment. The boards should be cleaned from bottom to top, crosswise. Rinse with pure water after cleaning. Distance from board during cleaning should not be less than 20-30 cm. Water temperature not higher than 90-100°C. Working pressure maximum 100 bar.

Attention:

Do not mix boards in different production sizes on same side of the building.
Do not mix boards from different production batches on same building.

