

Front canvases SWISS KRONO LLC

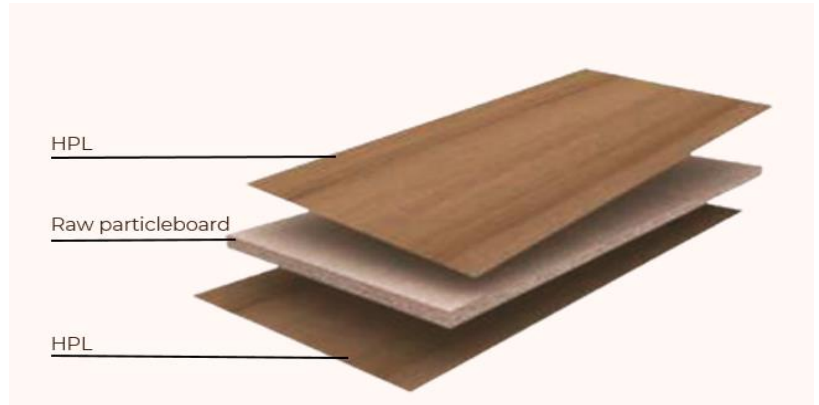
Processing, installation and usage

Instruction

Front canvases – its wood-based composite material covered with HPL from both sides.

Structure of front canvases

- ✓ core board: particleboard type P2 produced in accordance with EN 312,
- ✓ both sides are covered with HPL produced in accordance with EN 438-3



Storage and transport

- ✓ front canvases should be stored and transported in a horizontal position, in dry conditions, on a dry and flat surface in a way preventing them from getting wet, warping or mechanically damaged
- ✓ the front canvases should be stored in a dry and closed room, in stable temperature conditions above 5°C, relative air humidity from 45% to 65%, min. 1.5 m away from a direct source of heat
- ✓ while loaded and unloaded, the front canvases should be lifted, never moved on the floor or dragged along each other, or moved over the edges
- ✓ the protective film (if available) should be removed only after completion of front canvases installation
- ✓ any foreign bodies or pollutants causing friction found in the stack of front canvases, may cause dents and surface damage

IMPORTANT

Improper storage may lead to permanent deformation of the front canvases.

Preparation for processing

- ✓ Before installation, we recommend acclimatization of the front canvases to room temperature. It is recommended to season them in the room where they will be installed for min. 24 h
- ✓ before cutting the front canvases to the required dimensions, it is necessary to cut (trim) the edges of the plates at a distance of at least 5 mm
- ✓ the front canvases should be installed and used in heated, closed and ventilated rooms, guaranteeing their protection against high humidity, extreme temperatures or direct intensive operation of sunlight
- ✓ it is recommended to install the front canvases after completion of all other renovation works in the place of the target use of the canvases
- ✓ we recommend checking each front canvases in terms of its dimensions, mechanical damages, as well as visible defects and colour differences before proceeding to its processing
- ✓ front canvases may be processed on CNC machine and with the use of carpentry tools, e.g. panel saw, hole saw, router. The tools should be sharp, which significantly affects edge quality. Before proceeding to the processing, it is recommended to perform trial tests to adjust the tool parameters properly.

Cutting to size

Sharp tools should be always used for front canvases cutting.

Recommended cutting modes for front canvases:

Cutting speed 40-100 m/s

Saw speed 3000-4000 rpm

Feed speed 10-30 m/min

When cutting front canvases, the load on the cutting tool is much higher than when working with melamine fades particleboards. When milling with portable or stationary milling cutters, it is necessary to use devices with a rotation speed of at least 20,000 rpm. For high-quality milling of front canvases, it is necessary to prepare a template.

After cutting, the parts must be edged to avoid moisture from affecting the edges of the front canvases and to maintain their shape stability.

Recommendations for cleaning the surface of front canvases

Staining agents	Recommendations for cleaning
Syrup, fruit juices, jams, alcohol, milk, tea, coffee, wine, soap and ink	Cold water with sponge
Animal and vegetable fats, sauces, dry blood, dry wine and spirits, eggs	Cold water with soap or detergent with household sponges
Gelatin, adhesives of plant origin, polyvinyl acetate adhesives	Hot water with soap or detergent with household sponges
Hairspray, vegetable oil, ballpoint pen and felt-tip pen tags, wax, cosmetics stains	Alcohol*, acetone* with cottonseed fabric
Nail polish, spray varnish, linseed oil	Acetone* with cottonseed fabric
Synthetic Oil Paints	Nitro Solvent* with Cotton fabric
Neoprene adhesives	Trichloroethane* with cotton fabric
Traces of silicone	Wooden or plastic scraper*, so as not to scratch the surface
Limestone Stains	Detergents containing a low percentage of citric or acetic acid (10% max) *

Note:

*- frequent use can lead to loss of shine and destruction of the surface of the front canvases.

IMPORTANT Do not use metal brushes or sponges and detergents containing abrasive particles to clean the surface of the front canvases. The surface of the canvases can be wiped with a damp cloth, never use chemical solvents or other aggressive substances.

Occupational health & safety

While performing any works connected with the front canvases, observe the occupational health & safety principles, as well as use proper personal protective equipment (e.g.: hearing protection, dust masks, safety goggles, etc.).

Use and care

- ✓ It is recommended to use a soft, dry or damp cloth for the cleaning of the front canvases. Greater dirtiness may be removed e.g. with dishwashing liquid solution. Afterwards, rinse the front canvases with clean water and allow it to dry completely
- ✓ do not use any cleaning agents containing aggressive or caustic substances or agents containing abrasive or gloss additives - as they may permanently damage the front canvases surface
- ✓ before using any cleaning agent, read the description attached there to be sure whether it is suitable for the surface of this type (HPL)
- ✓ remove greater dirtiness, e.g.: that caused by felt-tip pen, nicotine, nail polish or shoe polish, with the use of spirit or organic solvent (e.g. acetone) and rinse the front canvases surface with clean water and allow it to dry completely.