



ECONOMY ♦ EXCELLENCE ♦ ETHICS

GLOSS
Meister

GLOSS MEISTER
TECHNICAL GUIDE



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1 INTRODUCTION

Gloss Meister panels can have a Melamine faced MDF/Chipboard or Particleboard core, which combined with the innovative manufacturing technology allows for a high depth of gloss. To ensure the product maintains its performance, follow these guidelines closely.

2 PRE-FABRICATION

2.1 TRANSPORT, STORAGE & HANDLING



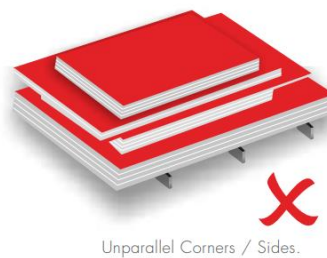
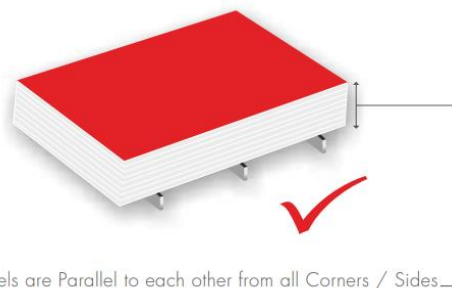
- Always lift Gloss Meister panels horizontally.



- When loading/unloading Gloss Meister panels, ensure the panels are lifted cleanly and don't scrape or slide over each other.



- While stacking Merino Gloss Meister High Gloss PU + Acrylic Panels, place a protective laminate over the top and under the bottom panel. Usually the stacking of Gloss Meister panels in supply of up to 15 boards is done with one sheet of 2mm or thicker laminate each at the bottom and similar laminate on the top. The top cover in all cases should be placed with some additional weight at appropriate places and in uniform manner.



- Merino Gloss Meister panels should be absolutely parallel to each other in the rack and should not be stored in contact with walls or the ground.



Both (front & back) surface of Gloss Meister High Gloss PU + Acrylic Panel will be covered from papers

3 FABRICATION

Gloss Meister panels are used for diverse applications where a high depth of gloss and no waviness are highly desirable elements. Unlike ordinary high gloss panels, Gloss Meister uses a Hot Coating based PU+ layer that makes the surface permanently elastic and consistent throughout the panel thickness.

This allows for easy machining, however it is still necessary to follow proper fabrication guidelines to minimize chances of warpage, waviness and other factors that are a matter of concern in high gloss materials.

3.1 CUTTING

Merino recommends cutting Glossmeister panels to size using CNC cutting process. Please follow the following

- a. Tool – preferably Sharp solid carbide tools
- b. Feed Speed – Moderate feed speed of approx 20 -25 metres / min.
- c. Cutting Speed – High cutting spindle speed of approx 20K rpmt

Another option for cutting is the beam Saw. When using beam saw to cut Gloss Meister Panels, please ensure that blade used is sharp and the following guidelines are kept in mind-

- a. Tool - preferably Sharp solid carbide tipped blades with 3 to 5 Teeth per cm
- b. Only fresh or grinded tools to be used
- c. Speed -
 - i. Main Saw - 4000 rpm
 - ii. Feed - 25 mts / min
- d. Always use scourer blade to avoid chipping at the back side of the panel.

3.2 CUT-OUTS, HOLES AND ADDING FASTENERS

Do not use square-cut inside corners, otherwise stress cracking or breakage may occur. All internal corners and cut-outs should be rounded as far as possible.

3.3 DRILLING

Some guidelines for drilling into Glossmeister panels-

- a. Use steel or carbide based drills
- b. Use a tipping angle of 100 to 120 degrees
- c. Adjust the speed to avoid overheating of the panel.

4 POST FABRICATION

Once the fabrication of Glossmeister Panels is completed, it is safe to remove the protective film. Please ensure the film doesn't stay on the surface beyond a few months as it may leave a residue on the surface that can become hard to remove with time.

5 MAINTENANCE & CARE

Merino Gloss Meister panels are a beautiful experience to behold, and truly above any other decorative high gloss material in the market. To ensure a product that lasts long and maintains its look, please use the following Maintenance & Care guidelines-

1. Normal Cleaning: Clean the surface of Gloss Meister with few drops of warm water and wipe the same with a soft cloth. If required, use a few drops of mild detergent or glass cleaner. Finish the cleaning with wiping dry with a soft cloth (micro fibre cloth).
2. Stains: Stains generated by strong dyes / colours / chemicals or fat / oil are to be removed using lot of water and if required, use normal, non-abrasive household cleaners. This is followed by cleaning with lukewarm water so that any residual soap, etc can be removed. Stains should be removed immediately and should not be allowed to dry.
3. Stubborn Stains – They should be removed using ordinary plastic cleaner or glass cleaner. Please test the cleaning product in a small area before applying in full.