



ECONOMY ♦ EXCELLENCE ♦ ETHICS

MATT
Meister

MATT MEISTER
TECHNICAL GUIDE



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1 INTRODUCTION

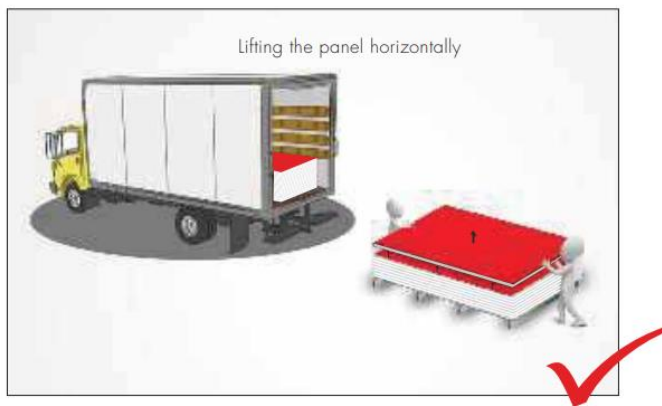
Matt Meister is a super matt surface with PU+ and multiple acrylic coating done on a melamine faced board/compact.

It is resistant to scratches as well as dry heat and is available in a variety of colours. PU+ and multi-acrylic layers create entirely new surface properties as compared to classic varnished surfaces. This technology makes the surface lastingly elastic and improves its processability as a single solid surface.

2 PRE-FABRICATION

Matt Meister panels can have a Melamine faced MDF/Chipboard or Plywood core, which combined with the innovative manufacturing technology allows for a high depth of matt. To ensure the product maintains its performance, follow these pre-fabrication guidelines.

2.1 TRANSPORT, STORAGE & HANDLING



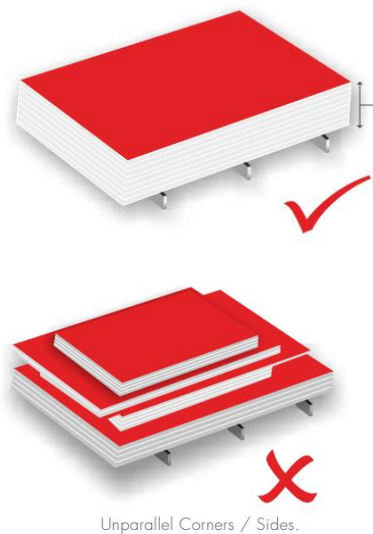
- Always lift Matt Meister panels horizontally.



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



- While stacking Matt Meister Panels, place a protective laminate over the top and under the bottom panel. Usually the stacking of Matt 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.



- Matt 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

Matt Meister panels are used for diverse applications where a high deep matt is required along with high performance qualities.

This allows for easy machining, however it is still necessary to follow proper fabrication guidelines to minimize chances of warpage or damage to the sheets.

3.1 CUTTING

Merino recommends cutting Ply Meister panels to size using CNC cutting process. The key factors to success in getting a good CNC cut are selecting the right bit, feed speed (or cutting speed) and spindle/router RPM.

During the process of CNC When selecting the CNC bit, ensure the chip load is not high, as it can lead to a poor surface finish and even damage the bit.

Merino recommends trying the following settings and adjusting accordingly as per the quality of the cut and tool productivity-

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

Another option for cutting is the beam Saw. When using beam saw to cut Matt 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

CNC cutting doesn't allow for square corners, and attempting to create square-cut inside corners using other tools may cause stress cracking. All internal corners and cut-outs should be rounded as far as possible.

3.3 DRILLING

Some guidelines for drilling into Matt meister panels-

- Use steel or carbide based drills. While TCT bits may prove to be economical due to their long life, Rectified HSS bits are sharper. Longer tool life helps improve reproducibility while sharper blades improve the quality of the cuts.
- Drill bits without a centering point or pilot point are preferred when drilling small holes. For larger holes, specialized tools with a centering point such as hole cutters, milling cutters are recommended.
- Use a tipping angle of 100 to 120 degrees
- Adjust the speed to avoid overheating of the panel. By controlling the feed speed of the drill, the panel is less likely to be damaged. A drill feed speed of 0.03-0.05mm per revolution is recommended.
- Edges of the hole should be smooth and cleaned after drilling.
- When working on a project that demands high reproducibility, drilling templates should be used. For such mass production scenarios, reproducibility may be the most important factor during machining and fabrication. Merino recommends using a stationary drilling machine with an automatic feed.

4 POST FABRICATION

Once the fabrication of Matt Meister 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 Matt Meister panels are a beautiful experience to behold, and truly above any other decorative high matt 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 Matt 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 on the surface.
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.