



TESA ^{action}
K O I N A H I A I S A

**TECHNICAL DETAIL AND
INSTRUCTION MANUAL
ACRYLIC HIGH GLOSS MDF BOARD
(EXTERIOR GRADE)**



ACRYLIC HIGH GLOSS MDF BOARD (EXTERIOR GRADE)

Cutting Equipment:-

The ideal cutting equipment shall be a Panel Saw with a primary Cutting blade & a secondary scoring blade. The Cutting motor shall drive the Primary cutting Saw between 5500 RPM – 7000 RPM

Primary Cutting Blade Specification:-

Shall be with 72 Teeth with PCD / TCD Tip.

The Feed Rate :-

A Steady feed rate is essential for the perfect cut without chipping of unevenness on the edges. The feed rate shall be 18 ft per minute.

Panel Saw Preparedness before cutting:-

- The Primary cutting blade and the scoring blade have to be in perfect alignment to give a 90 degree cut edge.
- The Blade sharpness needs to be checked
- The Cutting Table cleaned out of all dust / cutting residue to avoid accidental scratches to the Panel

Critical Points to be noted

- Do not Peel Off the BOPP protective film from the board till your fabrication process is not over.
- Once the BOPP film is removed please wipe clean the surface of the board with any cleaning agent like Colin.

Best Cutting Process

- Place the Acrylic High Gloss MDF Board with the BOPP film on the cutting tray.
- Acrylic High Gloss MDF Board surface side should be facing towards Scoring Saw.

- Align the board edge to the horizontal guide for a perfect straight edge.
- Align Primary & Scoring blades.
- Set Blade Speed to 7000 RPM (Min. 5500 RPM)
- Push the board @ constant speed of 18 ft per minute.
- Ensure that the dust collector is turned on the effectively clean the work space.
- Use Protective work Gloves & Glasses while cutting the board.

Acrylic High Gloss MDF Board – Technical Specification

- Core Panel – Available in Pre Laminated MDF Board
- Type of Core Panel – Exterior Grade – 1 Water Resistant BWR Type
- BIS License (Core Panel) – IS : 14587 (Pre Laminated MDF)
- Size Available – 8'X4' (2440MM X 1220MM)
- Thickness Available – 18MM
- Finish Type – High Gloss
- Shades Available – 19 Colors as per Shade Card

Outstanding Product Characteristics

- High Gloss Level more than 110 degree
- Rich Fullness of Color
- High Surface hardness in the range of >_2H
- Good Scratch resistance
- Anti Bacteria, Anti Acid & Anti Alkali against a variety of disinfectors
- Resistant to fading
- Exterior Grade Core Panel used high water resistance making it ideal for application in moisture prone areas & also used for all furniture application.
- Hard Wood used for Mother Boards

Best Application Areas

Action TESA Acrylic High Gloss MDF Board can be used in decoration of wall / Cabinet or whole styling. House hold Decoration Furniture like Bedroom / Living Room / Wardrobe Shutters / Kitchen Shutters and Multipurpose application and many more.

Edge Finishing the Panels

- Action TESA Supplied PVC High Gloss finished Edge Band Tape which is available in 150 Meter Rolls in complimenting ranges. The Edge Band Tapes can be fixed with a thru-feed machine. There is however the option of Aluminium profiles too which can be fitted with a groove on the edge.

Note – Action TESA Acrylic High Gloss MDF Board are best suited for any Vertical Application.



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