



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 disinfectant
- 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.

For optimal appearance under light, ensure the arrow marks on the protective film (as shown in the picture) are aligned in the same direction for all shutters installed side by side in wardrobes or cabinets.

The protective film should be removed before use, once all installation and other civil/painting work are completed.



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