



**TESA** <sup>action</sup>®  
K O I N A H I A I S A

# **TECHNICAL DETAILS OF ULTRA VIOLET COATED PANELS (EXTERIOR GRADE)**



# UV COATED PANELS

(HARD WOOD USED FOR MOTHERBOARDS)

## **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 or 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 UV Coated Board with the BOPP film on the cutting tray.
- UV Coated MDF Board Gloss 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.

### **Technical Specifications**

- 9 Layers of High Gloss UV Lacquer – The Action Tesa Ultra Violet Coated Panels are coated with 9 Layers of UV Lacquer rendering an impervious and permanent high gloss surface.
- Exterior Grade Core – Exterior Grade Core Panel used high water resistance making it ideal for application in moisture prone areas & also used for all furniture application.
- Highly Scratch Resistant – Highly Resistant to abrasion with a UV Hardened surface.
- Gloss Level – Transparent UV Lacquer render more than 95 degree Gloss Level that does not lose its sheen with the passage of time. Increased sharpness & depth of décor.
- Environment Friendly - Environment Friendly Paneling Solution with 0.05mg/L of Formaldehyde Emission , Zero VOC & has no Benzene or lead content
- Resistant to Acids & Alkalies – Resistant to most Acids, Alkalies & Stains
- Surface Hardness – 2H - 3H
- Hard Wood – Hard Wood used for Mother Boards.

### **Best Application Concepts**

- Cupboard Shutters – Ideal for Cupboard Shutter that enriched the Interiors
- Kitchen Shutters – Ideal for Kitchen Shutters with the Ultra High Gloss that's easy to maintain , is Water Resistant, Flame Resistant & Scratch Resistant
- Toiled Cabinet Shutter – With High Resistance to Moisture / Water Resistant factor UV Coated Panels are best choice for Vertical toiled Cabinet Shutters.

- Partition Panels – Create Relief Sections in an otherwise Mundane Partition Section, It can be also used for Partition Panels for Double & Single skin Partition Panels. The High Gloss lends depth to the partitioned area.
- Furniture Embellishments – Can be used to Clad Drawer facia & Furniture Vertical Section. It's best used as Embellishments.
- Wall Paneling – Can Lend depth to with graceful Interiors

**Note – Action TESA Ultra Violet Coated Panels are best suited for any Vertical Application.**

### 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.



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