

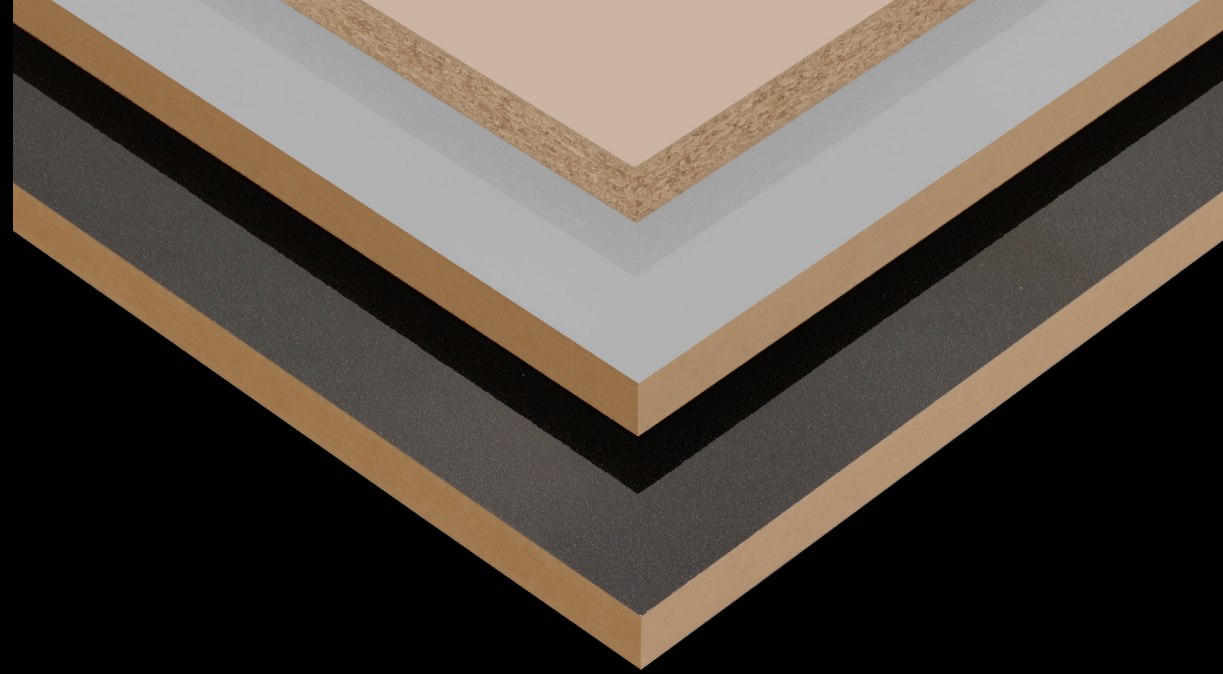


 **GlossMAX PRO**  
ACRYLIC LACQUERED PANEL

**USER MANUAL**



**GLOSSMAX PRO high gloss panel** is a wooden panel with decorative glossy surface, which is produced by applying glue and UV acrylic lacquer onto the surface of melamine coated MDF or Particle Board through various industrial processes with advanced and unique technology. Higher surface quality and an impressive glossiness has been achieved with the minimized surface effects thanks to the Calender Coating Inert technology. After the chemical curing of the Polymeric glue (hot coating) process, which provides not only physical but also excellent chemical adhesion to the melamine coated surface, a superior surface is obtained by applying lacquer with respect to cutting quality and workability compared to other glossy surfaces.



**GLOSSMAX PRO  
PARTICLE BOARD**



**GLOSSMAX PRO  
MDF**



#### **AREAS OF USAGE\***

Kitchen cabinet, bathroom cabinet, bedroom, rail cabinet, teen room, office furniture, decoration and all modular products...

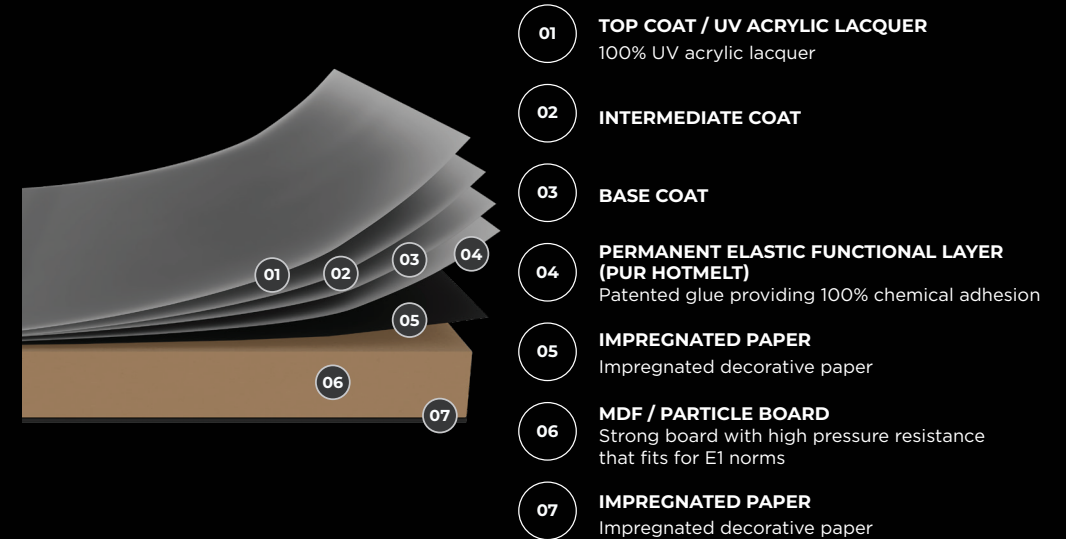
\*Suitable for indoor usage.

# GLOSSMAX PRO DECORS



The colors may vary on digital media. Please check with original sample.

# GLOSSMAX PRO PANEL FEATURES



## PANEL FEATURES

*The density changes due to the thickness.*

TYPE OF PANEL	MDF-PARTICLE BOARD
PANEL THICKNESS*	8-16-18 mm
PANEL SIZE	2100x2800 mm
FRONT FACE OF THE PANEL	High gloss and scratch resistant decorative surface obtained as a result of applying glue and 100% UV acrylic lacquer on the surface of melamine coated MDF or Particle Board, using the Calender Coating Inert technology.
REAR FACE OF THE PANEL	Impregnated paper

\*Production in different sizes within the range requires a certain order quantity.

# GLOSSMAX PRO

## PANELİN AVANTAJLARI



### MAXIMUM SIZE

**2100x2800 mm in size, far from the limited work requirement...**

The world's first 2100x2800 mm panel size provides users with an efficient optimization opportunity that offers low waste production solutions.



### MAXIMUM PERFORMANCE

**Superior gloss and surface resistance...**

With patented PUR glue application technology, it has a much better cutting and processing capability than its counterparts in the market. High protection is provided until the moment of delivery by the foil and mattress on the surface during the process.



### MAXIMUM ADAPTATION

**In the same colors and patterns with the Kastamonu Entegre Medelam&Teknolam...**

One side of the decorative panel is glossy and the other side is covered with the same colored decor paper. It can be applied to all melamine coated decors. In this way, color integrity is ensured on the rear and front surfaces of the panels. The decorative panel attracts attention with its high level of natural surface appearance. It is produced as MDF and Particle Board with rich color variety.



### MAXIMUM SERVICE

**Kastamonu Entegre's high production capacity and superior service quality...**

# GLOSSMAX PRO

## PANELİN AVANTAJLARI



### HIGH GLOSS

Perfect reflection and impressive appearance.



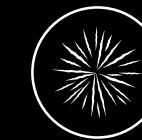
### SUPERIOR SURFACE QUALITY

An almost-perfect surface quality has been achieved thanks to the minimized surface effects. With this feature, it is an indispensable product of high prestige projects.



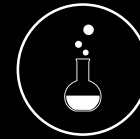
### HIGH SCRATCHING RESISTANCE

Technical Details: TS EN 14323;  
Resistant to impacts and scratches up to 2-3,5 Newtons.



### HIGH CRACKING RESISTANCE

Technical Detail: TS EN 14323  
Limit:  $\geq 3^\circ$ ; Kastamonu Entegre:  $5^\circ$



### RESISTANCE TO CHEMICALS AND STAIN

Technical Details: TS EN 14323; stain retention strength Limit:  $3^\circ$  min, Kastamonu Entegre:  $4^\circ$ ; TS EN 12720: 2009 (table A.1 liquids; ethyl alcohol, olive oil, water, nescafe, black tea, concentrated milk,  $5^\circ$  up to 24h).



### EASY TO CLEAN

Moist-cotton cloth and soapy cotton cloth should be used for cleaning the products.

**GLOSSMAX PRO**  
TECHNICAL SPECIFICATION

CONTROL CRITERIA	TEST STANDARD	UNIT OR FEATURE	THICKNESS RANGE	
			TEKNOLAM	MEDELAM
			6<t≤9 13<t≤20	6<t≤9 9<t≤12 12<t≤19
TOLERANCES ON NOMINAL DIMENSIONS THICKNESS COMPARED TO RATED VALUES THICKNESS $t$ RELATIVE TO NOMINAL VALUE	EN 14323	mm	<15 / ≥15 to 20 mm; +0,5 / -0,3; >20 mm; ± 0,5 <15 / ≥15 to 20 mm; $t^{max} - t^{min} \leq 0,6$	
LENGTH AND WIDTH	EN 14323	mm	± 5	
FLATNESS	EN 14323	mm/m	Only for balanced surfaces which $t \geq 15$ ; ≤ 2	
EDGE DAMAGE	EN 14323	mm	≤ 10	
SURFACE DEFECTS	EN 14323	mm <sup>2</sup> /m <sup>2</sup>	point ≤ 2	
		mm/m <sup>2</sup>	line ≤ 20	
RESISTANCE TO SCRATCHING	EN 14323	N	Class B 2 ≤ t < 3,5	
RESISTANCE TO CRACKING	EN 14323	Rating	≥ 3	
RESISTANCE TO STAINING	EN 14323	Rating	≥ 3	
GLOSS	EN 14323	Gloss Unit (GU)	20° min.85	
CROSS CUT	EN ISO 2409	Class	0 or 1	
SURFACE SOUNDNESS	EN 311	N/mm <sup>2</sup>	≥ 1	
FORMALDEHYDE RELEASE	EN ISO 12460-3	mg/m <sup>2</sup> air	E0; < 1,75, E1; ≤ 3,5 E2; 3,5 < release ≤ 8	
MIRROR EFFECT	TSE K 479	Observation	Min.6	
LIGHT FASTNESS (XENON ARC LAMP)	EN 15187	Scale	Grey Scale ≥ 4 Blue Wool > 6 Suitable for pigmented products only	

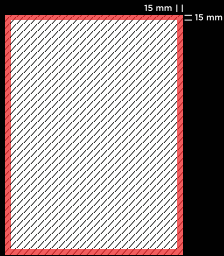
\*For any detail about pigmented products resistant to UV rays, please consult the relevant "Sales Representative".

# GLOSSMAX PRO

## MANUFACTURING, INSTALLATION AND MAINTENANCE INSTRUCTIONS

### CUTTING AND SIZING

- The protecting foam of the surface should be removed before cutting.
- The protective transparent foil coating should be removed within 24 hours after the installation is completed, latest 3 months after delivery.
- Products that are covered with protective foil (for protection purposes) minimize the damage that may occur during the production process and protect the glossy panel until the finished product. Therefore, the protective foil should not be removed until the finished product in order to minimize such damages.



- While sizing the panel, if needed after removing the protecting foam, it is required to leave a **trim size of minimum 15 mm from 4 sides each** before removing the transparent foil.

### TOOLS

For the best-quality coating of GLOSSMAX PRO, the following instrument using guidelines are important:

- Sizing can be made with standard wood working tools.
- The tools must be sharp and freshly whetted.
- Hard metal or diamond-tipped cutting edges will provide the best results.
- Use the cutting and seeding rates recommended by the authorized tool supplier.
- Perform a regular and sufficient new sharpening program in accordance with the recommendations of the tool supplier.

It is necessary to provide proper settings for the treatment of gloss surfaces, which means that all tools must be kept sharp. The machine must be stabilized, adjusted and kept in good condition. All equipment must be as clean as possible.

# GLOSSMAX PRO

## MANUFACTURING, INSTALLATION AND MAINTENANCE INSTRUCTIONS

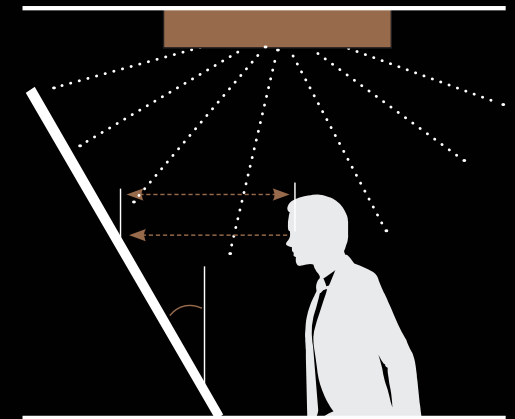
- The glossy surface placed in protective transparent foil may be faced upwards during the cutting process. There is no need to invert the panels.
- For a cleaner cut, a plotter saw must be used at the bottom side. Cutting without a plotter saw is not recommended.
- After banding the edges, it is recommended to apply a pre-mill.
- The panels must always be firmly supported and placed in the machine while being processed.
- The snapping effect of the edges must be checked during cutting. If the snap effect exceeds your tolerance, it means that the saw is blunt. The cutting must be continued with the whetted saw blade.
- Products that have been cut with 45 degrees should be turned into covers as soon as possible.
- In order to prevent the damage to the surface, the surface protection foil must not be removed until the installation is completed.

### SURFACE AND FLAW CONTROL

A micro defect that can be addressed to as a defect can be detected under the following conditions (which apply to stains or debris as well as fibers or scratches).

The evaluation is made in sunlight-like lighting(5000 Kelvin).

- Visibility at least 700 mm from the surface of the panel
- Vision time: maximum 20 sec
- Light intensity: 800-1600 lux
- Inclination angle of the product: 45 degrees



# GLOSSMAX PRO

MANUFACTURING, INSTALLATION AND MAINTENANCE INSTRUCTIONS

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## STORAGE INSTRUCTIONS

- The products are designed for interior settings. This should be taken into consideration while performing the applications.
- Panels should not be exposed to direct sunlight.
- The GLOSSMAX PRO product should be stored and processed in a suitable environment where the temperature is between 10-35 °C (and the relative air humidity is between 50-60%).
- Panels should be carefully stacked in order to avoid dents, collapses and breaks on edges and corners while processing.
- In addition to the top and bottom panels of the stack, the other panels in the package show faster reactions to the changing environmental effects (e.g. climate). Therefore, use cover panels.
- Protective transparent foil coated plates should not be exposed to direct sunlight (infrared rays).
- During the transportation process, the products must be removed without rubbing against each other.
- When the product is arranged horizontally in the storehouse, it should be stowed on the wedges at equal intervals to prevent rotation.
- While stacking on top of each other, the wedges must be aligned and the same quantity.
- Vertical stocking of a large number of products should be avoided, and support should be used in such vertical stocking.
- Color tones should be checked in successive tasks.
- Products should not be used in places that are open such as gardens, washed with water and directly exposed to steam.

Avoid exposure of the product to the following conditions during transport, storage and processing!

- Storage in the immediate vicinity of heating sources (presses/dryers)
- Exposure to heat and sunlight (external infrared light)
- Improper ventilation with increased air humidity
- Storage under direct flow

# GLOSSMAX PRO

MANUFACTURING, INSTALLATION AND MAINTENANCE INSTRUCTIONS

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## MAINTENANCE AND CLEANING

- The protective transparent foil coating should not be removed until the installation is completed.

The protective transparent foil coating on the products should be removed within 24 hours after the installation is completed and after waiting for 2 hours, the surface should be wiped with a damp cloth or wood cleaner. For cleaning, it is recommended to use a nonabrasive cloth moistened with soap and water and then dry immediately.

**IMPORTANT:** Do not use dishwashing sponges, abrasive and alcohol-based cleaners.

## PROCESSING RULES

- These rules are merely pieces of advice. They are issued without warranty and liability and do not constitute a special contract. Before using this product, the user is obliged to test whether the specifications that are specified in the “Specifications Table” are appropriate for their particular purpose or projects.
- The GLOSSMAX PRO product is continually improving as in tool and machine technologies, processes and value-adding activities. Please follow for the updates and current product regulations.





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