



GlossMAX

ACRYLIC LACQUERED PANEL

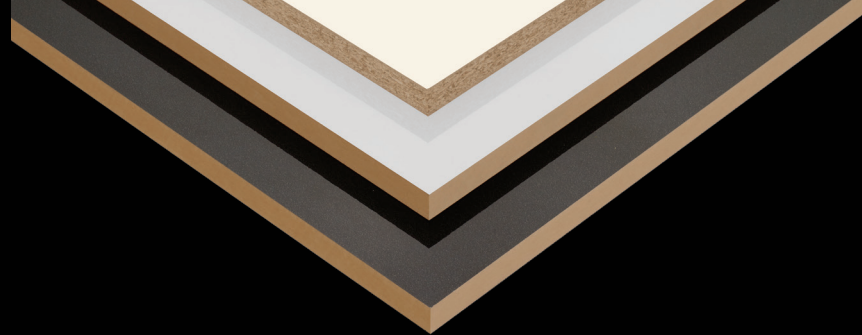
USER MANUAL



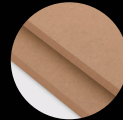
 KASTAMONU



GLOSSMAX high gloss panel is a wooden panel with a decorative glossy surface, which is obtained by applying glue and UV acrylic lacquer on the surface of melamine coated MDF or Particle Board through various industrial processes using advanced and unique technology. After the hot coating process, which provides excellent chemical adhesion to the melamine coated surface, a superior surface is obtained compared to the other glossy surfaces in terms of cutting quality and workability.



**GLOSSMAX
PARTICLE BOARD**



**GLOSSMAX
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 DECORS



D174 ULTRA WHITE
(pigmented)



D175 SUPER WHITE
(pigmented)



D129 LAC. WHITE
(pigmented)



D160 MOONROCK
(pigmented)



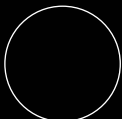
D140 STONEWARE



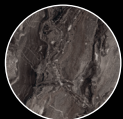
D161 DAPHNE



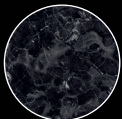
D143 ANTHRACITE



D186 PIANO BLACK
(pigmented)



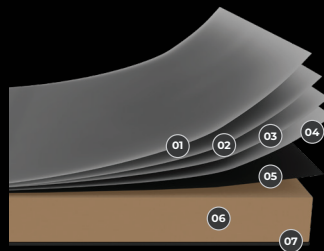
F258 COSMOS



F256 LOTUS

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

GLOSSMAX PANEL FEATURES



- 01 **TOP COAT / UV ACRYLIC LACQUER**
100% UV acrylic lacquer
- 02 **INTERMEDIATE COAT**
- 03 **BASE COAT**
- 04 **PERMANENT ELASTIC FUNCTIONAL LAYER (PUR HOTMELT)**
Patented glue providing 100% chemical adhesion
- 05 **IMPREGNATED PAPER**
Impregnated decorative paper
- 06 **MDF / PARTICLE BOARD**
Strong board with high pressure resistance that fits for E1 norms
- 07 **IMPREGNATED PAPER**
Impregnated decorative paper

The density changes due to the thickness.

PANEL FEATURES

TYPE OF PANEL	MDF-PARTICLE BOARD
PANEL THICKNESS*	8-16-18 mm
PANEL SIZE	2100x2800 mm
FRONT FACE OF THE PANEL	A bright and scratch-proof decorative surface obtained as a result of application of glue and %100 UV acrylic lacquer to the surface of the melamine-coated MDF or Particle Board
REAR FACE OF THE PANEL	Impregnated paper

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



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

High 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 protecting foam on the surface during the process.



MAXIMUM ADAPTATION

In the same color and patterns with 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

High capacity and high service quality of Kastamonu Entegre...



HIGH GLOSS

Mirror Brightness: 20° 88, Technical Detail: TS EN 14323

Limit: 20° min. 85 GU 60° min. 90 GU

Keas: 20° 89 GU, 60° 95 GU



HIGH SCRATCHING RESISTANCE

Technical Details: TS EN 14323;

Resistant to impacts and scratches up to 3.5 Newtons



RESISTANCE TO CHEMICALS AND STAIN

Technical Details: TS EN 14323; stain retention strength

Limit: 3° min, Keas Perf. 4°; TS EN 12720: 2009

(table A.1 liquids; ethyl alcohol, olive oil, water, nescafe, black tea, concentrated milk, 5° up to 24h)



EASY TO CLEAN

A moist cotton cloth for cleaning products, a soapy cotton cloth or non-alcoholic fluid glossy surface cleaners should be used.



HIGH CRACKING RESISTANCE

Technical Detail: TS EN 14323

Limit: ≥3°; Keas: 5°

GLOSSMAX

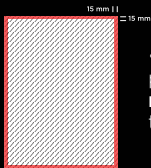
TECHNICAL SPECIFICATION

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} ≤ 0,6	<15 / ≥15 to 20 mm ; +0,5 / -0,3; >20 mm; ± 0,5 <15 / ≥15 to 20 mm ; t ^{max} - t ^{min} ≤ 0,6
LENGTH AND WIDTH	EN 14323	mm	± 5	
FLATNESS	EN 14323	mm/m	Only for balanced surfaces which t≥15 mm; ≤ 2 only	
EDGE DAMAGE	EN 14323	mm	≤ 10	
SURFACE DEFECTS	EN 14323	mm ² /m ²	point ≤ 2	
		mm/m ²	line ≤ 20	
RESISTANCE TO SCRATCHING	EN 14323	N	Class B 2st<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 ²	≥ 1	
FORMALDEHYDE RELEASE	EN ISO 12460-3	mg/m ³ 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".

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, 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.

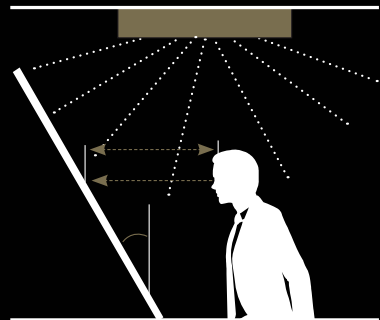
- The glossy surface placed in protective transparent foil may be faced upwards during the cutting process. There is no need to invert the panels.
- For a cleaner cut, a plotter saw must be used at the bottom side. Cutting without a plotter saw is not recommended.
- After banding the edges, it is recommended 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



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 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

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 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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