

MATTPLUS

ACRYLIC LACQUERED PANEL

USER MANUAL



KASTAMONU



MATTPLUS extra matt panels are wooden panels with decorative extra matt surface which is obtained by application of glue and 100% UV acrylic lacquer on the surface of melamine coated MDF or Particle Board with an advanced and unique technology. High quality surfaces obtained by providing excellent distribution of light reflected by Excimer technology, brings out the perfect mattness with its natural appearance. In addition to the soft touch feeling, the products with high fingerprint resistance and easy to clean feature reveal the nobility of mattness in wood. The surfaces obtained during this process, which is based upon the principle of extra mattness and quality, are unrivaled in terms of applied processes.



**MATTPLUS
PARTICLE BOARD**



**MATTPLUS
MDF**



AREAS OF USAGE*

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

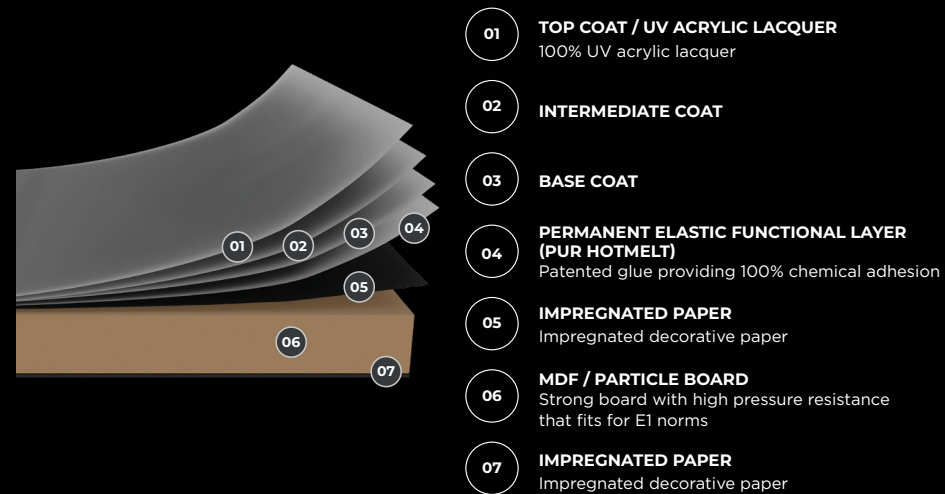
*Suitable for indoor usage.

MATTPLUS DECORS



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

MATTPLUS PANEL FEATURES



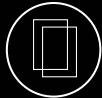
PANEL FEATURES

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	Extra matt 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 Excimer technology
REAR FACE OF THE PANEL	Impregnated paper

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

MATTPLUS ADVANTAGES



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 matt 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 colors and patterns with the Kastamonu Entegre Medelam&Teknolam...

One side of the decorative panel is matt 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...

MATTPLUS ADVANTAGES



SUPER MATT (SOFT TOUCH)

Soft Touch&perfect mattness with warm and soft feeling.



SUPERIOR SURFACE QUALITY

Minimized surface effects/flaws.



HIGH SCRATCHING RESISTANCE

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



HIGH CRACKING RESISTANCE

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



RESISTANCE TO CHEMICALS AND STAIN

Technical Details: TS EN 14323; stain retention strength Limit: 3° min, Kastamonu Entegre: 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

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



HIGH FINGERPRINT RESISTANCE

Natural surfaces with fingerprint resistance.

MATTPLUS 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	
LENGTH AND WIDTH	EN 14323	mm	± 5	
FLATNESS	EN 14323	mm/m	Only for balance surfaces which t ≥ 15mm; ≤ 2	
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 2 ≤t<3,5	
RESISTANCE TO CRACKING	EN 14323	Rating	≥ 3	
RESISTANCE TO STAINING	EN 14323	Rating	≥ 3	
CROSS CUT	ISO 2409	Class	0 or 1	
SURFACE SOUNDNESS	EN 311	N/mm ²	≥ 1	
FORMALDEHYDE RELEASE	EN ISO 12460-3	mg/m ² air	<1,75 (E0), ≤3,5 (E1), 3,5 <releases≤ 8 (E2)	E0 < 1,75, E1 ≤ 3,5 E2, 3,5 <releases≤ 8
LIGHT FASTNESS (XENON ARC LAMP)	EN 15187	Scale	Grey Scale ≥ 4 Blue Wool > 6 Suitable for pigmented products only	

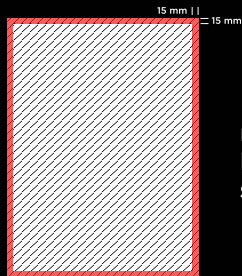
*For any detail about pigmented products resistant to UV rays, please consult the relevant "Sales Representative".

MATTPLUS

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 MATTPLUS, 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 matt 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.

MATTPLUS

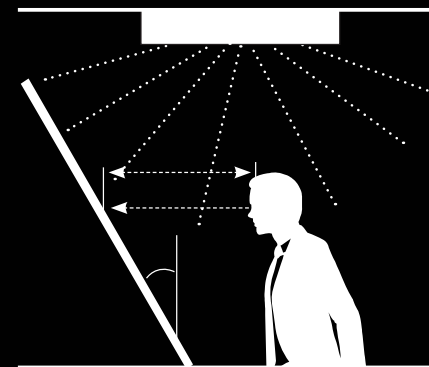
MANUFACTURING, INSTALLATION AND MAINTENANCE INSTRUCTIONS

- The matt surface placed in protective transparent foil may be faced upwards during the cutting process. There is no need to invert the panel.
- 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 panel 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 MATTPLUS 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 panels 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 MATTPLUS 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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