MELAWOOD

SUPAGLOSS

TECHNICAL DATA SHEET

PG BISON

www.pgbison.co.za

Choose MelaWood® SupaGloss™

- ✔ Gloss level > 101 GE (20°)
- ✔ Durable, UV hardened gloss surface
- ✔ Standard wood working tools can be used
- ✔ Protective film shields gloss surface during handling and processing
- ✔ Trusted MelaWood® decor on a quality SupaWood® core
- ✔ Consistent quality and colour in a stylish range
- ✔ Available in 2750mm x 1830mm for better yield and less waste
- ✔ Cost effective and value for money
- ✔ Matched edging available locally
- ✔ Manufactured locally to European standards by PG Bison

MelaWood® SupaGloss™ makes use of world-leading, patented technologies to produce a desirable and hard-wearing high gloss decorative board.

A hot coat polyurethane (PUR) is applied to MelaWood® with a SupaWood® core and cured using ultraviolet (UV) light. This innovative process creates a durable, high gloss surface with good wear and scratch resistance.

MelaWood® SupaGloss™ also gives you a gloss surface with consistent stability and visual depth, so you can work in confidence knowing your end product will look superb.

Manufactured locally to European standards by class leading PG Bison gives you the assurance of a dependable, readily-available product, consistent in colour and surface finish. You never have to worry about one batch of MelaWood® SupaGloss™ not matching the next.

MelaWood® SupaGloss™ is supplied with a protective film to shield the gloss face during handling and processing. The reverse side comes in a matching décor with a matt finish. Your end product will arrive on site looking as good as you intended.

Put PG Bison's **MelaWood® SupaGloss™** to the test.

Processing Guidelines

These guidelines are recommendations only. They are provided without warranty or liability and do not constitute a special contract. The user is obliged to test the suitability of this product for their specific purpose or project before use.

Machining

Normal sizing and edging processes can be used for **MelaWood® SupaGloss™**.

The environment must be suitable for the processing of high end, high gloss surfaces. This means all tools must be kept sharp. Machinery must be stabilized, squared and well maintained. All equipment must be as clean as possible and a close watch must be kept on all details.

The following points should be noted for better processing:

- The user should always test and prototype in detail to ensure suitability of the product
- A keen eye for detail and good operator skills are essential in the production of high gloss components
- Use adequate dust extraction to keep the environment and equipment clean
- The gloss surface, with its protective film in place, should face upwards during cutting
- Use a scoring blade on the underside to achieve a cleaner cut
- Use and operate the scoring blade the same way as for MelaWood® cutting
- The board should always be firmly supported and positioned during machining
- Use the tool / machine supplier's guidelines for cutting speed and feed rates
- Use top end adhesives, and no filler material where possible, in the edge banding process for best results
- Pre-milling is strongly recommended to eliminate visible joins in the edge banding process
- The product must be correctly stored through all stages of processing
- Storage and processing conditions should correspond closely to the climate of final installation

Tooling in General

For the best quality finish of **MelaWood® SupaGloss™**, the following tooling guidelines are important:

- New tooling or sharp, newly honed tools are an essential requirement
- Tungsten carbide or diamond tipped cutting edges will provide the best results
- Use the recommended cutting speed and feed rates as per the authorized tool supplier
- Keep to a regular and sufficient re-sharpening programme in accordance with the tool supplier's recommendations

Storage

HORIZONTAL STORAGE | STACKING

- Always stack on flat, load-bearing ground
- Use joists | dunnage of uniform thickness and with lengths corresponding to the width of the board
- The distance between the joists | dunnage depends on the thickness of the boards
  - For board thickness ≥ 15mm, use 800mm spacing or a minimum of 4 joists for 2750mm board
  - For board thickness < 15mm, use spacing smaller than 800mm. The rule of thumb is "Distance = 50 x board thickness (m)"
- Use cover boards to protect the board surface
- Protect the board edges if board stacks are to be fastened with steel or plastic bands, by using corner protectors
- Where stacks are to be stacked on top of each other, make sure to vertically align the joists | dunnage to prevent deforming the boards through uneven pressure
- Avoid protruding boards in stacks
  - For board thickness < 15mm, use spacing smaller than 800mm. The rule of thumb is "Distance = 50 x board thickness (m)"
- Use cover boards to protect the board surface
- Protect the board edges if board stacks are to be fastened with steel or plastic bands, by using corner protectors
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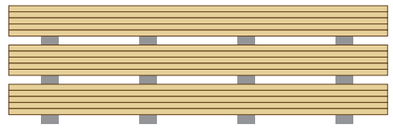
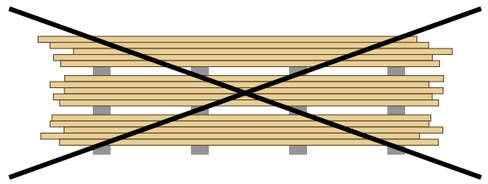
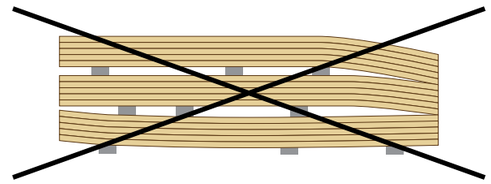
Right



Wrong





VERTICAL STORAGE

- Only ever stack a small number of **MelaWood® SupaGloss™** boards together vertically
- Horizontal storage is the preferred method of stacking, especially for large volumes of board
- The gloss surface makes slippage easy, so ensure safe fastening of **MelaWood® SupaGloss™** boards when stored vertically
- Sufficient fastening can be achieved with closed storage locations, stacks, or shelves
- The storage surface should not exceed a width of 500mm

General Notes

- **MelaWood® SupaGloss**™ should be stored and processed in a stable climate where temperature does not fluctuate outside of 10 to 35 °C (and relative air humidity 50-60%)
- Storage and processing conditions should correspond to the climate of final installation
- For optimal flat behaviour, avoid exposure to the following during transport, storage and processing:
  - Storage in the immediate proximity of heating sources (presses / dryers)
  - Direct exposure to heat and sunlight (outdoor UV light)
  - Unequal air conditioning with increased air humidity
  - Storage in direct draft
- Individual boards, as well as the stack's top and bottom boards react faster to changing environmental influences (climate) than boards inside the stacks, so use cover boards
- **MelaWood® SupaGloss**™ should be conditioned for an adequate period of time in the respective rooms under the subsequent conditions of use prior to installation
- The protective film on **MelaWood® SupaGloss**™ should be removed as soon as possible after processing, but never later than 5 months after delivery, to ensure a clean and problem free removal
- Boards covered with the protective film should not be left in direct sunlight (UV light)
- **MelaWood® SupaGloss**™ is intended for vertical applications only and is not suitable for high traffic horizontal applications, in particular work surfaces.
- This information should not be taken as freeing the user of their responsibility to check the suitability of **MelaWood® SupaGloss**™ to their conditions and processes before use

Products like **MelaWood® SupaGloss**™ are continuously developing as are tool and machine technologies, processes and value add activities. Please always refer back to our website for changes and updated product guidelines.

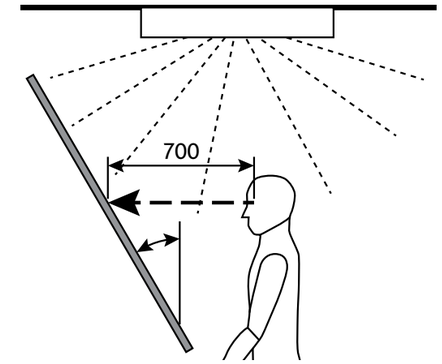
Technical Data Sheet

Product Features	Test Method	Measure Values
Gloss-Level	DIN EN 13722	> 90 GE (60°)
		>101 GE (20°)
Scratch resistance	EN 15186	> 0,6 N, Process B
Abrasion resistance	EN 15185	> 300U
Chemical resistance	DIN 68 861 T1 / IHD-W-460/ ISO-MAT 0066/ FIRA 6250	passed
Surface defects	EN 14323	2mm² each 1m²
Longitudinal error	EN 14323	20mm/m

Conditions for defect assessment:

For a micro-imperfection to be defined as a defect, it must be detectable under the following conditions (this applies to spots/dents as well as fibres/scratches):

- Assessment is under daylight-like lighting (5000 Kelvin)
- Viewing distance of at least 700mm from board surface
- Viewing duration: maximum 20 seconds
- Light intensity: 1000 to 2000 Lux
- Inclination angle of product: 30° to the vertical



Care and Cleaning Instructions:

After removing the protective film, the surface is ready for daily use, but an additional polishing is recommended. For general cleaning, a light soap solution is sufficient.
Important: Do not use scouring pads or abrasive and corrosive cleaners or cleaners with alcohol.

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