

Technical conditions for MELACO products

**CSD product line**

Bearing material: MDF board or chipboard, thickness 10 - 60 mm

Decorative material: polymer film, full gloss surface is always protected with a special, transparent protective film

Rim material: PVC, PP, PET, ABS, thickness 0.3 – 2.0 mm

Glue system for wide plane: PUR HOT MELT

Glue system for narrow planes: PUR HOT MELT, transparent. On Customer's request it is possible to apply EVA in white colours for white elements and EVA for other elements

Anti-pressure material (backside): melamine layer

1. The CSD products are manufactured in dimensional standards in accordance with the current offer for the CSD products.

MELACO offers the fulfilment of orders for non-standard dimensions in the following scope:

- maximal height: 2,700 mm, minimal height 250 mm
- maximal width: 1,200 mm, minimal width 120 mm

2. Allowed dimensional tolerances:

Width	mm	+/- 0.35
Height	mm	+/- 0.35
Thickness	mm	+/- 0.35
Corner radius	mm	+/- 1
Corner angle	degree	+/- 1
Deflection of corners in the plane determined by element surface	mm	+/- 1
Deflection on the length of 1,000 mm/convexity	mm	3
Deflection on the length of 1,000 mm/concavity	mm	1.5

3. MELACO fulfils the orders for the CSD products without quantitative limitations. If the Customer does not specify other requirements, then the deviation of +/- 1 pc. is allowed in order completion, but not more than +/- 5%.
4. The surface resistance of the CSD products is in accordance with the Product Resistance Sheet (we provide it on Customer's request).
5. The occurrence of indentations, swelling and discolouration with the diameter of 2 mm and in the quantity of 3 pcs. and scratches not perceptible with nail on the length of 35 mm and in the quantity of 2 pcs. are allowed on the wide plane due to technical and material conditions.  
A partial or full covering of element with a protective substitute film is allowed due to the control actions conducted in the production process.
6. The occurrence of surface unevenness, resulting from the conditions of the veneering process and from the properties of applied rim, is allowed on the narrow edges of elements.

7. The CSD products may be applied in the vicinity of heat sources, such as heaters, cookers, microwave ovens or heating panels only in case of equipment intended for installation with limited thermal radiation emission.
8. In case of the CSD products manufactured in wood-like patterns and metallized the direction of decor is perpendicular to the element's width. Manufacturing in other direction of natural grain of wood is possible only on specific Customer's inquiry.
9. In case of soiled surface use a water solution of soap of a room temperature. It is not allowed to use any chemical agents, solvents, scrubbing agents and alcohol. Any soils should be removed immediately, to prevent them from drying up. The application of other cleaning agents is on the Customer's own risk. We propose to conduct tests prior to cleaning.
10. The ULTRAGLOSS SUPERPOLISH preparation, offered by MELACO, should be used for the maintenance of products with full gloss finish. It is not allowed to use the ULTRAGLOSS SUPERPOLISH preparation for the products with the surface finish other than full gloss.
11. The CSD products are packed in accordance with the Packing Conditions for the CSD products.
12. Due to technological progress MELACO reserves the possibility to change colours, patterns and applied milling profiles without cancelling a product line. In case when such a change occurs, the Customer will be informed immediately after placing an order. If the Customer does not accept an introduced change, the placed order will be cancelled.
13. Processing of elements: due to the intended use of elements, the machining (drilling and milling) was taken into consideration in the product's parameters. The machining operations are foreseen for the left side (laminated layer). For the right side (layer covered with decorative film) only the operations of through drilling for holders are foreseen, with the reservation that drilling should be performed from the right side. Any other processing operations should be preceded by conducting appropriate tests or agreed with MELACO company.