

Technical conditions for MELACO products

COMPLETE SKIN_LINE products

Bearing material: MDF board

Decorative material: polymer film, full gloss or matt surface is always protected with a special, transparent protective film. Due to technological reasons the surface of certain products can be not protected with a protective film.

Anti-pressure material (backside): melamine layer or other, depending on technological conditions.

1. The COMPLETE SKIN_LINE products are manufactured in dimensional standards in accordance with the current offer for the COMPLETE SKIN_LINE products or on the basis of individual agreements with a Customer.
2. Allowed dimensional tolerances:

Width	mm	+/- 0.5
Length	mm	+/- 10
Defects on the product ends, such as: folds, lack of board covering with film, film detachment or cracks, glue runs (onto 1 side or onto 2 sides in total), are allowed	mm	100
Thickness (for products coated on 1/2/3 sides)	mm	+/- 0.35
Thickness (for products coated on 4 sides)	mm	+/- 0.5
Convergence on the length of 2,800 mm	mm	2
Deflection on the length of 1,000 mm for the products with the cross-section min.16x70; for the products with smaller dimensions or planed from 4 sides the deflection is not standardized	mm	+/- 5

3. MELACO fulfils orders for the COMPLETE SKIN products on the basis of determined minimal quantities. If not agreed otherwise, the minimal ordered quantities are as follows:
 - 100 pcs./colour/dimension
 - deviations of min. +/-5 pcs. max. +/- 5% are allowed
4. The surface resistance of the COMPLETE SKIN products is in accordance with the Product Resistance Sheet.
5. The occurrence of not glued film in the grooves for key-type connection, indentations, swelling and discolouration on each plane with the diameter of 2 mm and in the quantity of 1 pc. on the length of 1 running metre and the scratches not perceptible with a nail on the length of 35 mm and in the quantity of 1 pc. on the length of 1 running metre are allowed due to technical and material conditions. The product is assessed in accordance with the control procedure described in the annex.
6. The occurrence of folds, lack of board covering with film, film detachment or cracks and glue runs are allowed on the decorative surface due to production technology. In such a case the defects are marked in a visible manner. The

metric length of useful material will be specified in sales documents. The quantity of defective product cannot exceed 30% of the nominal product length. If such defects are not marked by the manufacturer, the Customer will notify about the total metric length of defects and a corrective invoice will be issued.

7. The COMPLETE SKIN_LINE 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 when the surface is soiled 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. Prior to the removal of soils always perform a test, in order to check if applied manner of cleaning has not a negative influence upon the product.
9. The ULTRAGLOSS SUPERPOLISH preparation, offered by MELACO, should be used for the maintenance of boards with gloss surface. It is not allowed to use the ULTRAGLOSS SUPERPOLISH preparation for products with matt surface.
10. Due to technological conditions the COMPLETE SKIN boards achieve fully their physical and chemical properties after 7 days from the production. The date of manufacture is placed on the pallets' tags. The boards should not be subject to treatment before achieving optimal parameters.
11. Cutting, milling, drilling and veneering of narrow planes should be preceded by performing of tests in order to choose the most optimal conditions of treatment, tools, glues, rims, technology and auxiliary materials.
12. The COMPLETE SKIN_LINE products must be thoroughly cleaned prior to stacking. The separators used for stacking should be made of soft material, in order to ensure the surface protection against scratching, abrasion or indentation. Always test the properties of material selected for separators and choose the maximal allowed height of stack experimentally.
13. The cutting of profiles should be preceded by conducting appropriate technological tests in order to select optimal parameters of treatment and cutting tools.
14. The COMPLETE SKIN_LINE products and the products made of them must be stored and processed in heated rooms (minimal temperature 10°C, humidity 45%), without a direct influence of solar radiation on the decorative surface. If the products are stored in lower temperature or humidity, the resistance parameters of adhesive-bonded joint can be significantly limited within 7 days from the completion of the production process, and in extreme cases the so-called delamination of veneer may occur.
15. Please contact the MELACO's Sales Department in case of any questions or comments regarding the COMPLETE SKIN products.