

Technical conditions for MELACO products

**COMPLETE SKIN product line**

Bearing material: MDF board or chipboard

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

Anti-pressure material (backside): melamine layer

1. The COMPLETE SKIN products are manufactured in dimensional standards in accordance with the current offer for the COMPLETE SKIN and COMPLETE SKIN EXPRES products.
2. MELACO offers two manufacture standards for the COMPLETE SKIN products:
  - flat-pressed board
  - board with the POSTFORMING-type longitudinal edges; the edge profile is in accordance with the current offer for the COMPLETE SKIN and COMPLETE SKIN EXPRES products.
3. Allowed dimensional tolerances:

Width for products with pf edges	mm	+/- 1
Width for flat-pressed products	mm	+/- 4
Length	mm	+/- 10
Thickness	mm	+/- 0.35
Convergence on the length of 2,800 mm	mm	4
Deflection on the length of 1,000 mm for boards L=2,620-2,800	mm	3
Deflection on the length of 1,000 mm for boards L<2620	mm	6

4. 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:
  - 5 pcs./colour/dimension for the COMPLETE SKIN EXPRES products
  - 40 pcs./colour/dimension for other COMPLETE SKIN products
  - deviations of min. +/- 1 pc., max. +/- 5% are allowed
5. The surface resistance of the COMPLETE SKIN products is in accordance with the Product Resistance Sheet.
6. The occurrence of indentations, swelling or discolouration with the diameter of 2 mm in the quantity of 3 pieces on the area of 1 m<sup>2</sup> and scratches not perceptible with nail on the length of 35 mm and in the quantity of 2 pieces on the area of 1 m<sup>2</sup> are allowed due to technical and material conditions. The product is assessed in accordance with the control procedure described in the annex.
7. Folds, lack of board covering with a film and film detachment or cracks are not allowed on the decorative surface. In case if such defects are found mark the product, calculate the area of useful board and inform MELACO.

## COMPLETE SKIN

8. The COMPLETE SKIN 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.
9. 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.
10. 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.
11. 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.
12. 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.
13. Both the COMPLETE SKIN boards in full commercial formats and processed form pieces must be thoroughly cleaned before stacking. The separators 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.
14. The boards should be cut in packs, along with originally supplied separating polyethylene foam which covers 100% of the board area. The contaminations (chips, laminate splinters, dust), which could damage the surface, do not penetrate between individual sheets of boards during cutting the boards in packs protected in such a manner.
15. The COMPLETE SKIN boards 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.
16. Please contact the MELACO'S Sales Department in case of any questions or comments regarding the COMPLETE SKIN products.