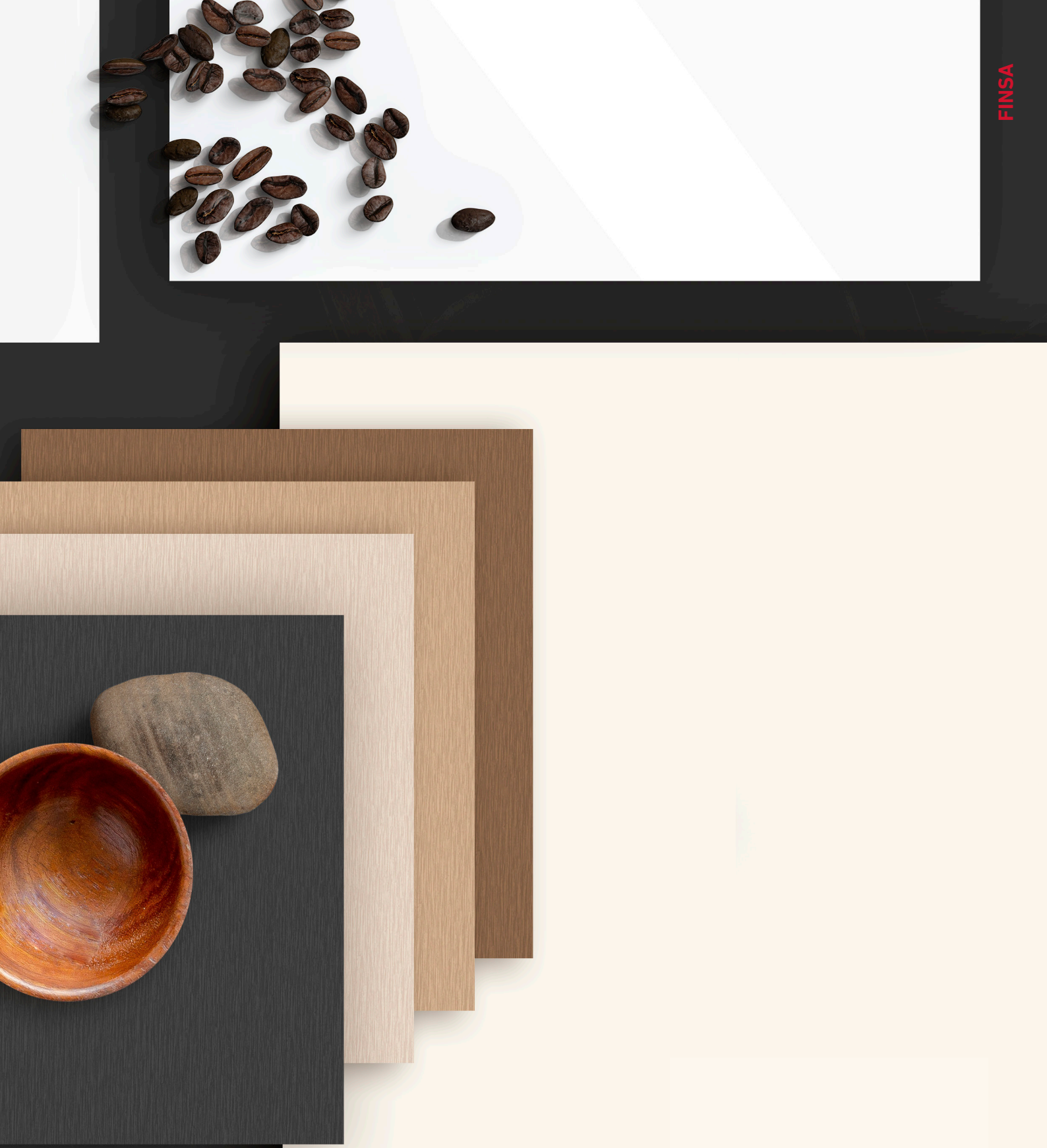

FINSA

IDEAL GLOW & MATT
TECHNICAL MATT

RECOMMENDATIONS **FOR USE**

FINSA

01 **GENERAL** RECOMMENDATIONS

02 **MACHINING** RECOMMENDATIONS

03 **EDGING** RECOMMENDATIONS

01 GENERAL RECOMMENDATIONS

01. STORAGE RECOMMENDATIONS

This product should be stored on a horizontal surface in a clean and dry environment (recommended temperature and humidity 20ºC / 65% H.R) avoiding its exposure to UV rays, heat and humidity.

In order to protect the surface from dirt, it is necessary to use a board or another protection method.

It is recommended that the product is stored horizontally. Do not stack more than 4 packs and ensure the vertical alignment of the wooden bearers in order to avoid bending and deformation.

Protective film: FINSA supplies these products with a plastic film to protect the surface from dirt and scratches. This film is for temporary protection and should be removed once the product has been installed. In any case, it should be removed within 6 months of FINSA's supply date.

In the case of IDEAL, it is recommended to keep the protection provided between boards for a greater surface protection against dragging.

02. APPLICATIONS

Ideal Glow is recommended for vertical applications according to UNE 11022-1 and UNE 11023-1 for domestic use and UNE 56875 for its use in kitchen furniture.

Technical Matt recommended for horizontal and vertical use in demanding applications according to UNE 438-2.

In both cases, it is recommended to review the product technical datasheet before using the material.

You can access the datasheets at **www.finsa.com**

02

MACHINING
RECOMMENDATIONS

These materials can be processed with standard machinery, carbide-tipped (HW) or diamond-tipped (DP). For optimal machining, it is necessary to ensure the maximum sharpness of the tools.

The following tool and machining recommendations are based on a series of tests in collaboration with LEUCO (www.leuco.com).

HOGGING PROCESS

PROCESS
rpm = 6000; feed = 30m/min

TOOL

Power Tec III Topline
ref. 183450/186451

TABLE SAW PROCESS

PROCESS
Feed = 20m/min; v c = 80m/s, v f = 5-8m/min, excess = 25mm

TOOL

DP HR nn-system DP-Flex Saw
ref. 192444

PANEL SIZING PROCESS

PROCESS
rpm = 3600; feed v f = 20m/min, v c = 80m/s, excess = 25mm

TOOL

Q-Cut G6
ref. 192883

CNC PROCESS

PROCESS
rpm = see table 1; feed v f = between 12m/min and 25m/min

N°1 High performance cutter

Ref.	Z	ø	Rpm	V_f	F_z
186120	3+3	25	18000	15	0,27

N°2 p-System shanktype cutter

Ref.	Z	ø	Rpm	V_f	F_z
184382	2+2	25	24000	10	0,20

N°3 p-System shanktype jointing cutter

Ref.	Z	ø	Rpm	V_f	F_z
184084	4+4	60	18000	25	0,34

N°4 High-performance trimming cutter

Ref.	Z	ø	Rpm	V_f	F_z
186142	4+2+4	48	18000	25	0,34

TOOL

N°1

N°2

N°3

N°4

03

EDGING
RECOMMENDATIONS

DRILLING PROCESS

PROCESS
rpm = 4500; feed v f = 1,5m/min

TOOL

High-performance drill bits with solid carbide body (VHW)
ref. 185772/185771

Topline through-hole bit with solid carbide body (VHW)
ref.185742/185741

Cylinder boring bits
ref. 172250/172254

Recommendations for edging in surfaces containing a protective film. The following recommendations are based on a series of tests in collaboration with Quivacolor (www.quivacolor.com) using our IDEAL and their product SOLFILM-795D.

The use of non-stick products:

Controls the movement of the protective film on the board.

Stops the protective film from peeling from the board.

Avoids the appearance of irregularities when cutting a material covered with a protective film.

Leaves less residue on the edge.

EDGING PROCESS WITH A PROTECTIVE FILM

PROCESS
rpm = 9000; feed = 20m/min; feed per tooth
f z = 0,74mm

TOOL

Diarex airFace ref. 186333

Smart Jointer airFace ref.185970

p-System ref. 184071

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