



**Melteca® Acrylic Soft Touch is a durable soft touch super smooth surface bonded to Lakepine medium density fibreboard (MDF MREO) to provide a double faced, pre-finished decorative panel.**

**Melteca® Acrylic Soft Touch is available in a range of 8 matte colours, with matching Laser and ABS edgetape. The sheets will arrive with a protective film.**

## COMPOSITION

Melteca® Acrylic Soft Touch panels are manufactured on a durable MREO (Moisture Resistant Zero Emission) Medium Density Fibreboard substrate providing an ideal platform for a matte decorative finish.

The decorative surface comprises of a 0.8mm acrylic laminate sheet which provides a full depth of colour to the finished panel.

Sheets are identified by Melteca® Acrylic Soft Touch branding, including colour and other manufacturing details.

## USES

- Vertical Interior use
- Kitchen, bathroom and laundry cabinets
- Furniture – commercial and residential
- Wall units
- Bar fronts
- Shop fittings and displays
- Wall linings in dry areas

For uses other than those specified in this section, and for use in the construction industry, please contact Laminex New Zealand on 0800 303 606.

## SPECIFYING

When specifying Melteca® Acrylic Soft Touch include the following information:

## PRODUCT CHARACTERISTICS

<b>Colour</b>	White Linen, Meringue, Blue Night, Pitch Black, Metallic Iceberg, Sky Scraper, Metallic Dune, Metallic Coal
<b>Finish</b>	Soft Touch Matte. Faced two sides
<b>Sheet size</b>	2800 x 1220mm
<b>Thickness</b>	18mm nominal
<b>Substrate</b>	Lakepine MREO
<b>Matching Edgetape</b>	All 8 colours are available in 22 x 1.2mm Laser ABS & 22 x 1mm ABS edging

## DESIGN CONSIDERATIONS

### Choosing colours

Melteca® Acrylic Soft Touch is no different from any other material in that darker colours will always show scratches and superficial wear and tear more readily than lighter colours.

Note: Any exposed substrate must be sealed before service

### Batch matching

We recommend ordering all panels for one job together to avoid any slight colour variances that may occur between production runs.

### Directional metallic colours

As a result of the manufacturing process, the metallic flakes in all metallic colours have a directional orientation along the length of the sheet. This means that sheets will reflect light in a different way depending on their orientation. All metallic colours have a directional label on the sheet to indicate this direction. It is important that as each panel is cut from the sheet, the direction is recorded

on each individual component.

This will make it easier to keep the appearance of all panels consistent when they are installed on the project

### Visible defects

Melteca® Acrylic Soft Touch is produced to very high quality standards. Some very minor visual defects < 1.0mm in size are allowed, a maximum of one defect per side. These defects are identified on the panel, which will allow the defects to be placed in a place where they will not be visible, (such as on the inside face of a cupboard door) or for the defect to be cut around.

### Effects of heat

Precautions must be taken to ensure the Melteca® Acrylic Soft Touch is kept clear of heat sources, such as freestanding fire places and space heaters, wall ovens and hot plates etc. The structural life of the substrate may be impaired if temperatures exceed 50°C for prolonged periods. Melteca® Acrylic Soft Touch can withstand short term exposure to temperatures of 65°C above ambient temperature without fear of ignition.

Manufacturers of heat appliances, referenced above must be consulted to ensure that correct clearances and ventilation are provided for.

## PERFORMANCE DATA

Properties	Test method	Test results
<b>Resistance To wear</b>	Taber Abraser ISO 4586-2 (6) Din 53799(4.66) AS/NZS 4266.20	8 colours > 250 cycles
<b>Resistance to scratching</b>	AS/NZS 2924.2 Part 14	3.5N
	EN 438-2 Part 25	Rating 3
	Dur-o-test	17N
<b>Resistance to staining</b>	Liquid Agents for 16 hours ISO 4586 (15) DIN 53799 (4.14.2) AS/NZS 4266.25	No visible marks
<b>Resistance to cracks</b>	70°C oven for 24 hours ISO 4586.2 (24) DIN 53799 (4.7.3) AS/NZS 4266.24	No cracks
<b>Resistance to steam</b>	Steam for 30 mins ISO 4586.2 (24) DIN 53799 (4.11.2) AS/NZS 4266.23	No effect
<b>Resistance to UV</b>	Exposure to Xenon Arc UV Light for 306 kJ/m <sup>2</sup> AS/NZS 2924.2 Part 16	Pass

## LIMITATIONS

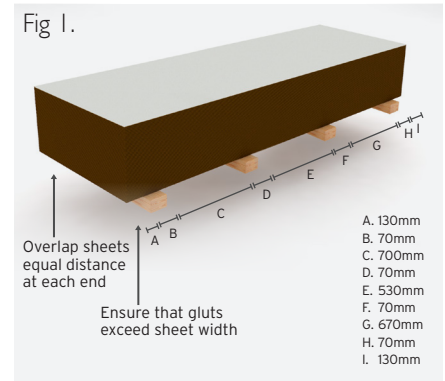
- Melteca® Acrylic Soft Touch is not intended for use in an exterior situation.
- Do not use Melteca® Acrylic Soft Touch in constant wear situations such as sink benchtops, high use shop counters, bar tops or restaurant tables.
- Melteca® Acrylic Soft Touch must not be used in high humidity or wet areas such as saunas or showers.
- The Melteca® Acrylic Soft Touch substrate must not come in contact with any liquid. Failure to keep dry will affect the performance of the panel.
- Health and Safety Precautions (Refer Health and Safety section of the document).

## STORAGE AND HANDLING

- Melteca® Acrylic Soft Touch is a high quality product and must be handled accordingly.
- Care of the panel is essential to protect the surface.
- To avoid damage to the sheets, lift rather than drag or slide panels over each other or across sharp or gritty surfaces.
- Leave protective film on panels intact, until installed and ready for use.
- Melteca® Acrylic Soft Touch must be stored away from moisture, heat and sunlight.
- Sheets must be flat stacked on aligned bearers or gluts.

- Bearers or gluts must be of uniform thickness and must extend across the full width of the stack. See Fig 1.

Melteca® Acrylic Soft Touch must be protected from the weather, dampness and direct wetting and must be stored inside.



## Durability

When stored, handled, used and maintained in accordance with this document, Melteca® Acrylic Soft Touch will meet the durability requirements of NZBC B2.3.1(c) for 5 years. Laminex

New Zealand have established a 10 year warranty for Melteca® Acrylic Soft Touch.

Laminex New Zealand will not be liable to any person for any product failure if

the conditions as to storage, handling, use and maintenance of Melteca® Acrylic Soft Touch as outlined within this document are not complied with.

## Dimensions

<b>Thickness (mm)</b>	18 (nominal)
<b>Weight (kgs/m<sup>2</sup>)</b>	13.7
<b>Sheet tolerances (mm)</b>	
<b>Length and width</b>	+/- 2.00
	+ 0.30/-
<b>Thickness</b>	0.00
<b>Squareness (maximum difference between diagonals)</b>	2.00
<b>Straightness (maximum deviation in plane along the edge)</b>	1.50 per metre

## WORKING RECOMMENDATION

### Machining

To obtain the best results when machining Melteca® Acrylic Soft Touch, avoid excessive speed rates.

### Guidelines for Cutting Melteca® Acrylic Soft Touch

Saw diameter (mm)	250	300	350	400
<b>Saw RPM</b>	4600	3800	3300	2900
<b># of teeth</b>	80	96	108	120
<b>Rim speed (m/sec)</b>	47	56	66	75
<b>Max feed rate (m/min)</b>	7	8	9	10

These are guidelines taken from various tooling manufacturers. Machines fitted with a scribing saw or hollow ground saw blade will produce the best result

directly from the sawing equipment. This will eliminate further work prior to edge finishing. Please consult with your tooling supplier to ensure safe operating speeds

and the right style of blade is used for your equipment at the material being used.

Panel Cutting		
Cutter Type	12mm Spiral Cutter	4mm Spiral Cutter
Cutter Speed	23000	18000
Max feed rate (m/mm)	20	10

Panel Boring			
Cutter Type	20mm Forstner bit	8mm Brad Point	5mm Brad Point
Cutter Speed	4000	4000	4000
Max feed rate (m/mm)	1.5	4	4

## FASTENING

### Selected screws

Always use screws specifically designed for use with medium density fibreboard e.g. Twinfast-screws or Super-screws. Drill a pilot hole slightly beyond the full

depth of the screw penetration. Do not over-tighten screws. A drop of adhesive applied to the screw thread will increase holding power.

### Face Screwing

To avoid surface lifting, screws must not penetrate more than two thirds of panel thickness, e.g. 18mm panel = 13.5mm maximum penetration.

### Pilot Hole Diameters for Lakepine MDF

Screw gauge	3	4	5	6	7	8	9	10
Pilot hole diameter in mm	1	2	2.4	2.6	2.7	3.0	3.3	3.5

## EDGE FINISHING

It is recommended that all edges of panels be edge finished. The most common Melteca® Acrylic Soft Touch edging options are:

- Melteca® Acrylic Soft Touch Laser ABS Edge Tape
- Melteca® Acrylic Soft Touch ABS Edge Tape

### Melteca® Acrylic Soft Touch Laser Edge Tape

A co-extruded edge tape, applied using a highly efficient laser or hot air edgebander that melts a colour-matched functional layer on the reverse side of the edge tape and welds it to the decorated board.

Minimal visible glue line once applied to board giving a clean seamless look.

Permanent and almost invisible functional bond to the board gives improved heat and water resistance when compared to conventional edge tape technology

Care must be taken when applying around tight curves.

## CARE AND CLEANING

Regular cleaning requires only a wipe down with warm soapy water, follow up with dry cloth.

Common household detergents can be used in conjunction with the instructions provided. A soft cloth should always be used. Do not use scouring pads or abrasive cloths or cleaners (e.g. steel wool) as these can damage the surface. Cleaning solutions are to be immediately rinsed from the surface by wiping with water.

### NEVER USE ANY OF THE FOLLOWING ON MELTECA® ACRYLIC SOFT TOUCH FOR ANY REASON:

Abrasive cleaners, such as:

- Jif®
- Ajax®
- Chemico®
- Brasso®
- Mr Muscle® cleaner
- Vim®
- Neat Janola®
- Wire wool
- Scourer pads
- Sand paper
- Oven cleaner
- Silvo®
- Acetone

### The following must not be used:

Strong acid/Alkali solutions include but not limited to: caustic soda/oven cleaner/NaOH, hydrochloric acid, sulphuric acid.

Abrasive materials include but not limited to: abrasive creams (Jiff, brasso, toothpaste), scouring pads (even if marked non abrasive), steelwool/goldilocks, hog/hard nylon bristled brushes, sand paper.

Concentrated solvents include but not limited to: Methyl ethyl ketone/MEK, cleaning solvents at greater than 10% concentration (e.g. meths, turpentine, kerosene).

The removal of dust from the surface can be easily achieved with the use of an electrostatic dusting cloth.

Refer to Laminex New Zealand Customer Services for any more information on 0800 303 606.



### **FIRE PERFORMANCE**

Melteca Acrylic is categorised to DIN 4102-B2 as normal flame resistance. In case of fire, no toxic substances such as heavy metals or halogens are released. The same fire fighting techniques can be used as for construction materials containing wood.

### **HEALTH AND SAFETY**

Health and Safety precautions must be taken when working with wood panel products.

Exposure to wood dust and/or formaldehyde may cause irritation to the eyes, respiratory system and skin, and may cause sensitisation resulting in asthma and/or in dermatitis.

Wood dust is classified as a known carcinogen. Repeated inhalation of wood dust over many years may cause cancer. Formaldehyde has been evaluated by the International Agency for Research on Cancer (IARC) as a group 1, carcinogenic to humans.

Storage areas containing large quantities of Melteca® must be adequately ventilated.

Work areas must be well ventilated and kept clean. Sawing, sanding and machining equipment must be fitted with dust extractors to ensure that dust levels are kept within standards laid down by Occupational Health and Safety New Zealand, or the specific country of use. If not, a dust mask conforming with AS/NZS 1715 and AS/NZS 1337 must be worn.

Offcuts, shavings and dust must be disposed of in a manner which avoids the generation of dust and in accordance with the requirements of local waste authorities.

In end use applications all product surfaces exposed to occupied space must be sealed.

### **TECHNICAL SUPPORT**

As not all product use options can be described herein, additional end use and specifying information is available as a complimentary service.

For further information, please phone **Laminex New Zealand® Customer Services on 0800 303 606.**  
**[www.laminexnewzealand.co.nz](http://www.laminexnewzealand.co.nz)**

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