

PROCESSING RECOMMENDATION

Duropal flameprotect compact
Duropal flameprotect compact IMO

MACHINES AND TOOLS

- Machining must be carried out on a flat, solid surface. All vibrations and any movement of the board must be avoided. Sharp tool edges and smooth running of the tools are essential for good results. If unsuitable tools are used, this will lead to chipping, splintering and bulging.
- Due to the hardness of the material and the thickness of the sheet, tool wear can be higher. Depending on the quantities to be processed, it is advisable to carry out a trial run to select suitable machines and tools.
- Horizontal pressure beam saws are ideal for sawing compact panels: The workpiece is fixed and the feed is automated.
- Machining can be carried out on all common machining equipment and processing apparatus.
- Diamond tipped tools are suitable for machining and processing.
- Sawing:
 - cut-to-size saw
 - cutting speed: 65–75 m/sec
 - infeed: up to 10 m/min for single cuts, up to 7 m/min for pallets of boards
 - saw blade projection: 15 – 30 mm
 - sizing circular saw
 - cutting speed: 65–75 m/sec
 - infeed: up to 10 m/min for single cuts, up to 7 m/min for pallets of boards
 - saw blade projection: 15 – 30 mm

INSTALLATION AND ASSEMBLY

- Please always ensure proper machining and installation according to the current available technology. Special attention must be paid to the material properties given its high mineral content.
- Duropal flameprotect compact has no constructive properties.
- Sufficient conditioning is required prior to installation. The premises themselves need to be air-conditioned according to the future use.
- A "normal" climate condition is one in which the room temperature is between 18 – 25 °C and a relative humidity of 50 – 65 % for the majority of the time (e.g. for furniture, bathrooms, toilet cubicles).
- Ensure good rear ventilation and climate equilibrium on both sides in the installed condition. For adequate air circulation the void should be at least 20 mm. It is important to interrupt horizontal substructures as well as the top and bottom ends of the wall panelling so that vertical rear ventilation is possible.

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- The substructure must be protected against corrosion and must be made of non-combustible materials.
- The base may not be moist or unstable. Please make sure that minimum carrying capacity and stability correspond to the usage.
- Newly built walls (made of brick or concrete or plastered walls) contain considerable amounts of moisture. Before covering them with panels they must be completely dried out.
- Ensure that there is an adequate area of “play” for the panel after installation; drill holes should be over-sized by a minimum of 0.5 mm and must be deburred.
- It is essential to ensure that the expansion area of all installed boards is not impeded. When combined with different or the same materials, the potentially different expansion coefficients must be taken into account in the event of climatic changes.
- The material must not be exposed to heat influences by light- or heat radiation which will increase the surface temperature to more than 70 °C.
- Direct, permanent moistening of the surface should be avoided.
- Please also refer to the current building inspection regulations.
- Especially for large applications, we recommend paying attention to the colour and texture uniformity of the boards and cut products used when further processing and installing and that the production direction is taken into account.

EDGING

- It is generally recommended to seal the edges. If required, you can find further information from the fire protection sub-standard DIN EN ISO 1716.
- EVA and PUR hot melts with low dosage are recommended for edge adhesion.
- The narrow glue surface must be absolutely dust-free or pre-treated with a primer.
- In the case of deviating right-angled format cuts, trial edging is mandatory.
- The edge strength test should only be carried out after a few minutes, not immediately after starting.
- Based on our own experience, we recommend dispensing with the pre-milling cutter and the scraper in the edging machine.
- If necessary, manual finishing of the front edge is advisable.

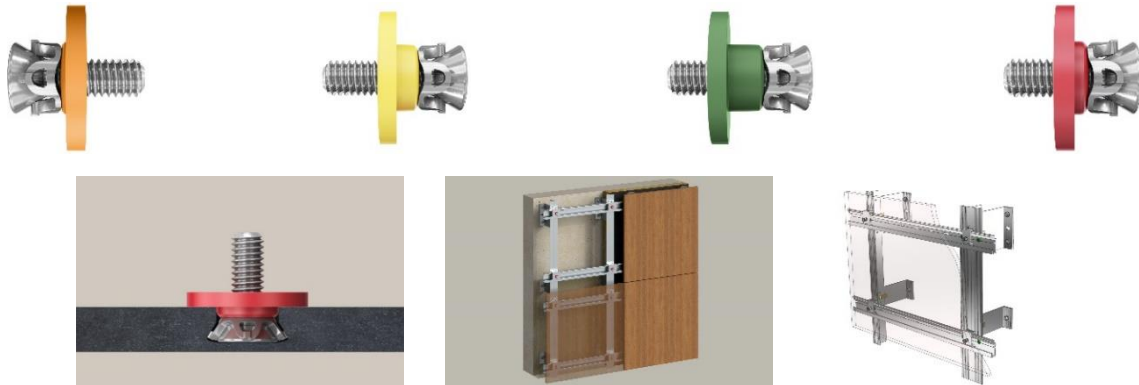
FITTING TECHNOLOGY

- All conventional removable and non-removable fittings for wood materials, compact laminates and mineral boards are suitable.
- Under the general building inspectorate approval, connections and fastenings with adhesive systems are not permitted for applications.
- Appropriate fittings or screws that are suitable for a maximum panel thickness of up to 15 mm must be used for furniture production.

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- Company Fischer Deutschland Vertriebs GmbH
Suitable for invisible panel fastening solutions - e.g. undercut anchor technology
Zykon Plattenanker FZP II T PA for HPL compact panels and mineral material panels
www.fischer.de – here you will find the technical data / specifications

www.fischer.de/de-de/produkte/fassadensysteme/zykon-plattenanker/zykon-plattenanker-fzp-ii-t/zykon-plattenanker-fzp-ii-t-pa



Source: Fischer Deutschland, Waldachtal

STORAGE, HANDLING AND TRANSPORT

- Panels are always stacked in stretch film packaging for delivery at the factory in order to avoid dirt and climatic influences during transport and storage as far as possible.
- Panels must be fully and horizontally stored with edges flush on a flat and clean base covered with plastic foil. Cover the top panel fully with foil and a cover board.
- All panels should be stored in closed storage rooms, not near doors/gates, under normal room climate conditions with temperatures between 18 - 25 °C and a relative humidity of 50 - 65 % protected from moisture, humidity, direct sunlight and the influence of draughts / heating fans and air conditioning outlets.
- Storage in the stretch film packaging supplied by the factory or in the individual cardboard packaging is ideal, always lying fully flat on a suitable, level surface.
- The film wrap as well as the use of the top cover board should be maintained or restored, if possible, even after removal of individual panels.
- Foreign bodies or impurities in the pallet of sheets can lead to impressions and damage to the surface of the board.
- Sheets / boards must not be moved against each other; they should be moved individually by hand or with suction equipment.
- Panels must be sufficiently conditioned before processing and installation, and any protective transport films should be removed on both sides at the same time.
- In principle, the climatic conditions of later use must be taken into account during planning and construction. Good conditioning can only be achieved in a normal room climate (see above).

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- Ensure that sufficiently large and sturdy bases, e.g. pallets, are used for the transportation of stacked sheets. The sheets on the pallet must be secured against slipping.

HEALTH AND SAFETY

- Before beginning work, employees should be familiar with the available tools, the processing recommendations and the safety requirements.
- Personal protective equipment such as gloves, goggles, ear protection, dust / respiratory protection and safety shoes must be worn and body parts should be fully covered when working on panels. We recommend the use of a dust mask.



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- Only authorised individuals may enter the work area.
- All tools must be grounded to protect against electrical shocks and static electricity.
- All adjusting spanners and other spanners must be removed from the machine.
- The work area must always be kept clean and orderly.
- The workpiece must be secured and fixed in place with screw clamps if necessary.
- Only undamaged tools and the recommended accessories may be used.
- Tools must be reviewed before each use to ensure they are intact and may never run unsupervised.
- Provide adequate ventilation and fresh air supply.
- Dust production should be reduced by using tools equipped with a vacuum or suction device – please do not blow.
- Provide adequate extraction when splitting / sanding.
- Panels are heavy. These should always be moved with the help of suitable carrying aids / handling systems such as vacuum lifters or similar. When carrying out further transport activities on site, be aware of steps and tripping hazards.
- When working with materials that emit vapours, work areas must always be well-ventilated for health and safety reasons.

DISPOSAL

- When machining large quantities, we advise using a separate saw dust extraction. Offcuts and large amounts of saw dust are to be collected and disposed of separately.
- Waste code for disposal: 030199

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PM HPL / Elements / Lacquered boards

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