

It's
PG Bison.

FABRICATING & FINISHING GUIDE



monteo+

LUXORA™

 PG BISON

BEAUTY IS MORE THAN SKIN DEEP.

Introducing Monteo+™ and Luxora™, our luxury range of melamine faced board and worktops, built on our distinctive rich, black NobleCore™ substrate.

Now, an inspiring new world of creative possibility is within reach.

PROCESS

NobleCore™ is a rich black, high-density MDF that builds on the technology and experience gained from our ever-popular SupaWood® medium density fibreboard (MDF).

Created through a finely managed process using non-toxic, water-based dyes, NobleCore™ boasts a dark, uniform colour throughout. It's made using moisture resistant (MR) resin, so can withstand the daily demands of living and working spaces.



APPEARANCE

We aim for visual consistency in the black colouration process of NobleCore™.

However, wood fibre is a natural product with a degree of variation regardless of mechanical process and controls. Colour consistency may vary slightly across batches. It can be affected by the source and type of timber fibre used as the black pigment reacts differently to fibre type and moisture content.

CONSISTENCY

For improved colour consistency in a project, use boards from the same production run.

PROCESS



APPLICATIONS

NobleCore™ is a low emission product, so it's ideal for any indoor application.

The substrate can be machined and shaped by CNC, spindle or router. Its exposed black edges are a key feature of the panel and give you the freedom to mould edges into a profile of your choice. By adding a decorative melamine face, you have the perfect canvas on which to explore decorative surface patterns through CNC or router.

Monteo+™ is recommended for vertical applications like cabinet doors and drawer frontals, decorative wall panelling, feature cladding and custom screening.

Luxora™ is recommended for horizontal applications like kitchen island worksurfaces, sleek office desks, retail counters and robust display stands.

Luxora™ has a double laminate face construction, offering greater stability and rigidity. It's rigidity makes it perfect for demanding horizontal applications.

HANDLING AND STORAGE

Your boards should arrive at their destination in the best possible condition. Your customers will be 100% happy, and it'll be easier for them to work with the products you've supplied. It's all about creating beautiful spaces with products that are in beautiful condition.

The wood fibres in our boards will adapt to their environment. To prevent dimensional changes after processing, allow boards to acclimatise to local conditions for three days before cutting or machining.

OUR RECOMMENDATIONS FOR FABRICATING AND FINISHING

CUTTING

- Use saw blades and cutting tools rated for cutting high-density fibreboard (HDF).
- Adhere to the original equipment manufacturer's (OEM) specifications and guidelines and consult your tool supplier for more information.
- Always keep saw blade teeth and cutting tools sharp, balanced and well-maintained.
- Follow the OEM and/or your tool supplier's recommendations on a regular and sufficient re-sharpening programme.
- Always position the board so that the rotation of the saw blade tooth cuts into the board's top (decorative) face and exits through its reverse side.
- Always use a saw equipped with a scoring blade. This clears the exit path of the main saw blade, helping prevent any chip out on the bottom surface.
- On table saws, always provide adequate forward and downward pressure to prevent vibration or the board moving in the wrong direction.
- Machinery must be stabilised, squared and well maintained.
- Use good dust extraction facilities when cutting to keep the environment and equipment clean.
- Keep the protective film in place on your Luxora™ boards throughout all processing.
- High speed, sharp tools and slower feed speed are the rule of thumb when working with Monteo+™ and Luxora™. The speed of the saw blade is critical to ensure a clean cut with no chip out.

See our guide on the very best way to handle and store your stock.



TROUBLESHOOTING

Burn marks may be caused by a feed speed that is too slow or by blunt blades.



MACHINING, ROUTING AND SPINDLING

- Use cutters and tips rated for machining high-density fibreboard (HDF).
- Ensure tools have an UP/DOWN cutter pattern to prevent surface chipping on the bottom surface.
- High-quality tungsten carbide tipped (TCT) cutters and tips are recommended for all machining, routing and spindling processes.
- Always keep cutting tools sharp, in good condition and well-maintained.
- Tips should be undercut (hollow ground) to facilitate heat dissipation.
- When heavy stock removal is required, use hogging or multiple passes to remove excess stock.
- Use good dust extraction facilities when machining, routing or spindling to keep the environment and equipment clean and ensure better results overall.

EDGING

No edging is required as the exposed, moisture resistant black edges of the NobleCore™ substrate are a key feature of the board.

SCREWING AND FASTENING

- Always use straight shank screws.
 - Tapered shank screws have a wedging effect and tend to split the edge of the board.
- Pilot holes are required for all screwing applications to prevent splitting.
- The pilot hole diameter is recommended to be, at least, the same size as the screw-shank diameter.
- Always drill pilot holes rather than punching them, as punched pilot holes reduce the screw-holding power of the board.
- Never over-tighten screws.
- Never use a hammer for driving in screws.

Don't use screws larger than 7mm in diameter. Use screws with a longer shank instead.

NAILING AND STAPLING

Nailing and stapling are not recommended methods for fixing or joining panels.

JOINTING

Most traditional wood working joints commonly associated with solid timber applications can be successfully used on NobleCore™.



SANDING

- It is recommended to sand the exposed and / or machined NobleCore™ edges and profiles for a professional finish.
- Begin with 150-grit sandpaper to smooth edges and profiles.
- For a premium finish, sand with progressively finer grits, with the final sanding using 300-grit or finer, depending on preference.
- Use good dust extraction facilities when sanding to keep the environment and equipment clean and ensure better results overall.

SEALING

- It is strongly recommended to treat all exposed and / or machined edges and profiles with a suitable wood oil, which should be applied after the required fine sanded finish has been achieved. This enhances the appearance and preserves the exposed wood fibres.
- Ensure the surface is completely free of dust, dirt, and sanding residue before applying the wood preserver.
- Should you require a more robust edge seal, a suitable lacquering solution can be applied with the appropriate masking of the decorative surface.
- Always follow the wood preserver manufacturer's instructions as well as their recommendations.

NobleCore™ is moisture resistant, but *not* waterproof. Do not expose the black core to excessive amounts of water.

CARE

CARE

Monteo+™ and Luxora™ panels have durable surfaces, but care should be taken when handling, machining and installing the product so as not to damage their surfaces.

To reduce the risk of scratches, never slide or rub panels or component pieces over each other during stacking and handling.

- Never use hard or abrasive cleaning products, such as scrubbing brushes, scrapers, pot scourers, steel wool, or any other abrasive tool or material or bleaching agents, as these can lead to mechanical or chemical damage.
- Some cleaning chemicals and liquids used on components during fabrication can cause staining if left on the surface for too long. These should be wiped away immediately after being applied, using a soft damp cloth.
- Ensure all chemical residue is removed and repeat the process as necessary.
- Any spilt chemicals and liquids that can cause stains must be wiped away immediately, using a damp cloth and soapy solution. Repeat this process as necessary.
- Always keep the protective film in place until installation is complete and all other service providers have finished their projects.
- The protective film on Luxora™ must be removed within 1 month of completion of the job to avoid it ageing and becoming difficult to remove.

DAILY CLEANING

- Always use a damp, soft, lint-free cloth for daily cleaning.
- For best results, use a mild soap and water solution with the soft cloth to remove daily grime. The soft cloth must be well rung out to not overly wet the surface.
- Always take care to prevent prolonged exposure to excessive moisture, especially at the exposed edges and profiles of the panels.
- Diluted name brand window-cleaning products (1 part window cleaner to 2 parts water) are great for avoiding or removing drying marks and smears on the surface.
- Monteo+™ and Luxora™ do not require any sort of furniture polish on their decorative surfaces.
- Avoid using abrasive, highly acidic, or highly alkaline cleaning solutions.



PLEASE NOTE

Subject to our standard terms and conditions of sale, PG Bison warrants only the performance properties of our products as set out in our technical data sheets. Please run detailed trials and tests to verify how your established procedure is affected before using any product contained herein in normal production.

As products, tools, machine technologies, processes and value add activities continuously develop, please always refer back to our website for changes and updated product guidelines at: www.pgbison.co.za

DISCLAIMER

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CUSTOMER SERVICE CENTRE 0860 579 196
INTERNATIONAL +27 (0)11 897 5200

pgbison.co.za



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