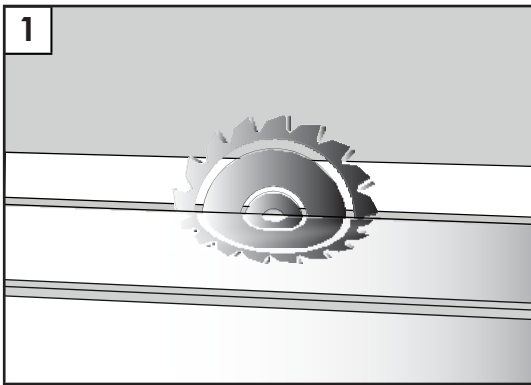


**PANEL  
OPERATING MANUAL**

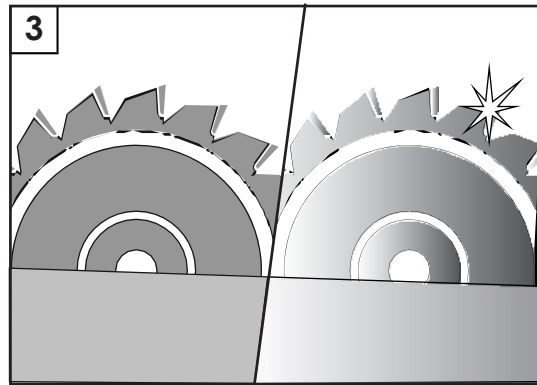


**for those who desire innovation**



**1. Buttress threaded saw shall be used for cutting.**

**2. Cutting on the cutting machine shall be performed in 90 degree vertically and in 45 degree horizontally.**



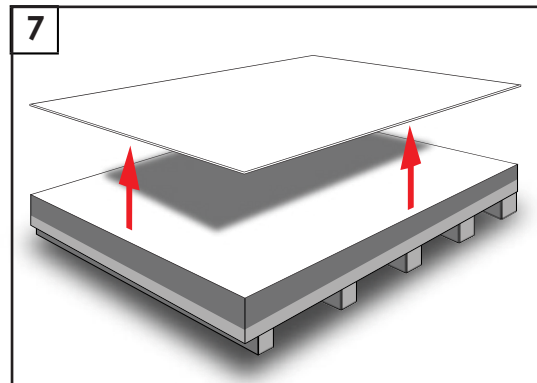
**3. It shall be ensured that the saw is ground well.**

**4. It shall be ensured that the proper cutting speed is 15 m/minute.**



**5. In order to obtain better results, jumping saw with scribe shall be used for panel cutting.**

**6. The products that are cut in 45 degree shall be transformed into cover on the same day.**



**7. The production shall be carried out in such a way that friction between two panels is eliminated in order to protect the surface.**

**8. Protective stretch film coating on panel products shall be removed after the assembly is completed. High Gloss products shall be cleaned through a wet cloth after they are kept unprocessed for 24 hours following the removal procedure of stretch film.**

**9. It shall be ensured that the ambient temperature is around 25 degree in order to let panel products be cut without any problem.**

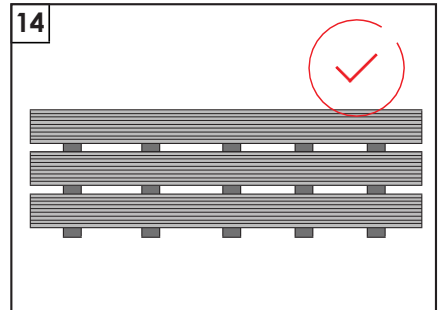
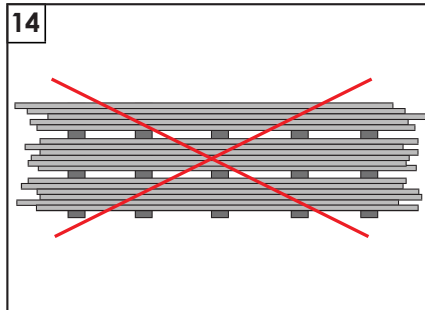
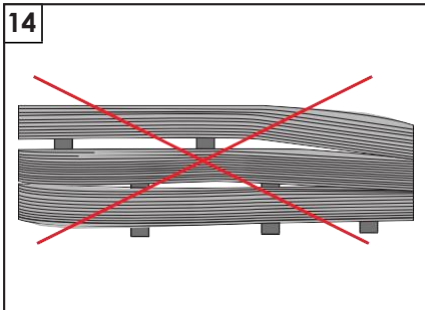
**10. Maximum 1 bump can be located per 1m<sup>2</sup> surface on the condition that the diameter of such bump is less than 5mm. 2 bumps may be located provided that they remain within the tolerance limits and the diameter of bump is less than 3mm per 1m<sup>2</sup> surface and the distance of these bumps from each other is at least 25 cm.**

**11. Production tolerance for the possible defects at the edges of product is transversely (1220 mm) 7 mm for both edges and longitudinally (2800 mm) 5 mm for both edges.**

**12. 1 collapse spot may be located per 1m<sup>2</sup> surface provided that the diameter of this spot is less than 5 mm.**

**13. Only 1 stain may be located on a panel provided that its diameter is less than 2 mm.**

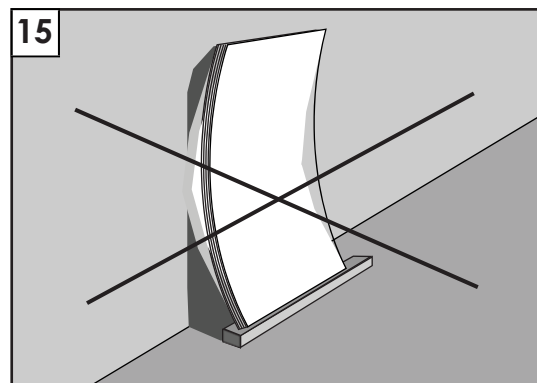
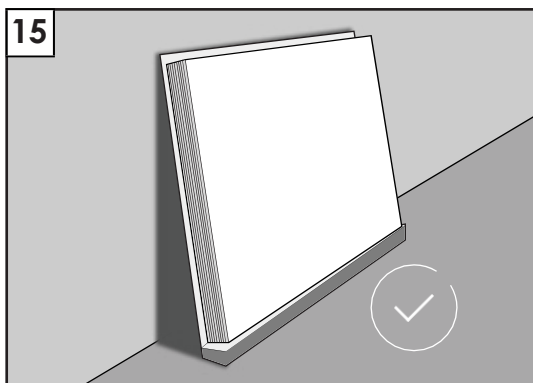
**14. When the product is stocked up horizontally at the warehouse it shall be ensured that it is stocked up on chocks at equal intervals to avoid rotation and the chocks used for superimposed stowing shall be identical.**



**15. When panels are put into process stowing shall be applied cautiously in order to prevent the formation of crushing, collapse and fracture at the edges and corners.**

**In order to prevent rotation, products shall be:**

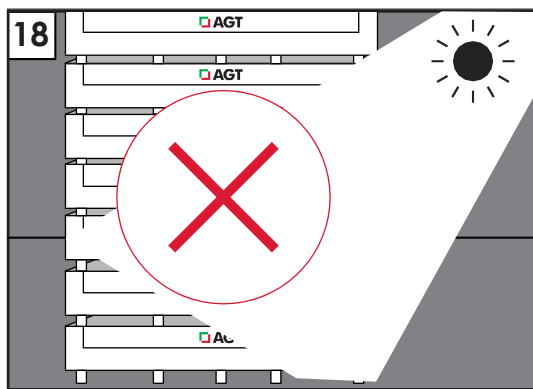
- Stocking that leans on an object shall be applied only for the products in small quantities.
- Products shall never be kept vertically!
- In case of locating by leaning on an object, the sheet shall be located by ensuring that it is safely supported.
- The air circulation of warehouse shall be minimized. Product storage areas shall be away from the doors.



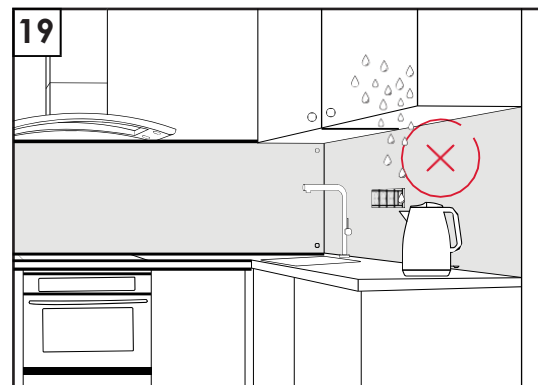
**16. Contact between the products shall be eliminated in order to avoid scratching on the surface by dusts and particles that may stick on the surface due to static electricity during the movements of products at storage area.**

17	
24 : 06 : 2019	10 : 25
24 : 06 : 2019	10 : 25
24 : 06 : 2019	10 : 24
24 : 06 : 2019	10 : 24

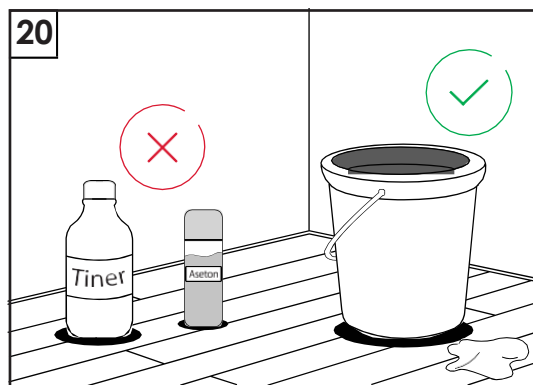
**17. Colour tones and production dates shall be taken care of for the successive works. Production dates are displayed on the backside of single-sided panel.**



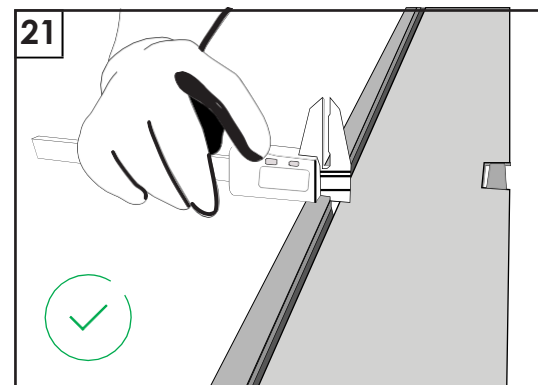
**18. Products shall not be subjected to direct sunlight.**



**19. Products shall not be used at the open spaces, gardens and places where are washed through water and where are directly subjected to steam.**



**20. Wet-cotton cloth, soapy-cotton cloth or alcohol-free fluid surface cleaning agents shall be used for cleaning the products. Alcoholic surface cleaning agents and scrubbing agents shall never be used. When you use such agents, it will cause tarnishing and scratching on the surface. Thinner and substances that contain acid shall never be used for cleaning.**

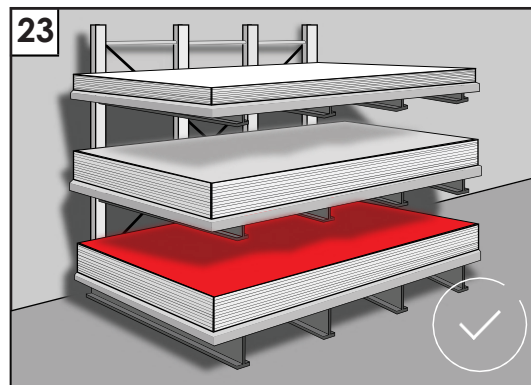
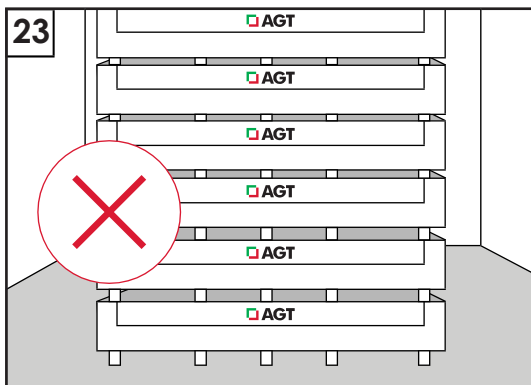


**21. The extent of rotation on the panel shall be 4mm for shorter edge and maximum 10 mm for the taller edge. This tolerance may vary for the topmost sheet since it is reversed. After the panels are dimensioned rotation values fall within useable tolerance limits.**

**Rotations, which occur as a result of situations where products are stowed improperly, temperature and humidity values of storage area are out of limit and products are exposed to air circulation that are out of limit, and therefore go out of limit values are not covered by the guarantee.**

**22. The degree of rotation of the sheet which is located on the top of pallet can be more than the degree of rotation of other products on the pallet. In such a case, it is recommended to reverse the sheet and stow it in such a way that HG surface looks toward upper side. (Since the lam surface is located on the top).**

**23. Pallets shall be stowed by placing them on shelves or on level area in such a way that maximum 4 pallets are put on the top of each other.**



**24. In order to protect the surface of sheets protecting cover shall be used. Especially raw mdf protecting cover is recommended.**

**25. While sheets are carried by hands protective gloves and shoes shall be worn in order to avoid injuries.**



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