

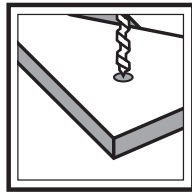
# ARIA (HPL) PROCESSING INFORMATION

## STANDARD BACKER



PHENOLIC BACK (HPL)

## PROCESSING



### SAWING | DRILLING | MILLING

With regular carbide-equipped tools. Diamond- equipped tools are not necessary.  
You can process standard backed material the same as HPL sheets

### SCREWS

Screw extraction resistance as in MDF, pre-drilling is recommended.

### CLEANING & CARE

The Aria surface must be treated like a normally veneered, painted surface. Cleaning is possible with a mist-moistened rag.

### BOND

- Commercial wood glues
- Cold pressing
- Pressure 200 kg/m<sup>2</sup>
- For the time of pressing, observe the processing notes of the glue manufacturer or the glue.
- Additions depending on foam film structure / corrugated cardboard or insulating boards.

### COUNTER-PULL

We recommend a 0.8 - 1 mm thick HPL as counter-pull. Unilateral mineral coating means that slight distortions cannot be excluded.

### PACKAGING

Lying on pallet.

### STORAGE

Store dry, interim layers with foam foil or corrugated cardboard. Protect from frost.

### RECYCLING

Product is ecologically harmless, can be recycled and disposed of in the household waste.

## EDGE PASTE INSTALLATION

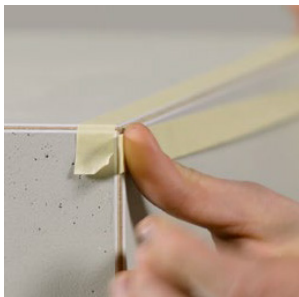
STEP 1.  
Cut the boards mitred and glue them together.



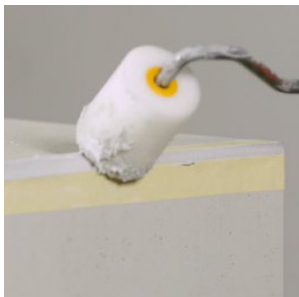
STEP 2.  
After glueing, mill cut the edges with a planer or router.



STEP 3.  
Surface to the edge has to be secured by a masking tape.

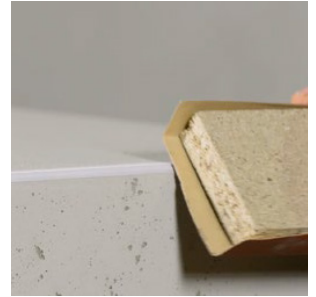


STEP 4.  
Afterwards apply thinly the coating mass #1. Drying time should be at least 4-5 hours. For thicker application allow drying overnight.



JAR #1

STEP 5.  
Take away the masking tape and make a fine grit. (150 grit).



STEP 6.  
Seal with a matte varnish.



STEP 7.  
In order to achieve the original concrete character wipe the varnished and processed area with the patina as final processing. JAR # 2



STEP 8.  
Finally, for higher load capacity, the edges should be varnished again processing.