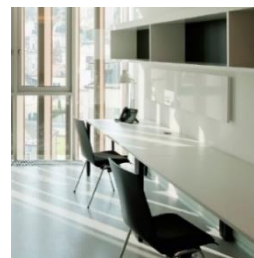


Processing instructions

EGGER Eurodekor / Eurodekor Plus



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1. General information Eurodekor / Eurodekor Plus

EGGER Eurodekor melamine faced boards (in accordance to EN 14322) are made of wood-based materials which are covered on both sides with decorative paper. They are used horizontally and vertically in furniture and interior design, for example for fronts, shelves, wardrobes or wall coverings.

EGGER Eurodekor Plus ML meets increased requirements for impact resistance through special multi-layer structures up to 1 mm thickness.

Multilayer structures are both very rigid and stable and are therefore well suited for structures with large spans. On request, an additional overlay (Plus HR) can be processed for special abrasion resistance.

With the proven EGGER quality in decor and material composites, EGGER Eurodekor offers a contemporary and aesthetically sophisticated solution.



2. Safety

At the beginning of working with EGGER wood based products the available tools, the processing instructions and the safety requirements should be known.

Personal protective equipment such as gloves, safety goggles, ear protection, dust/respiratory protection and safety shoes should be worn when opening the packaging straps and during processing.

Processing should only be carried out with proper tools and the recommended accessories. Tools must be checked for their integrity before each use and must not be left running unattended.

This product contains formaldehyde. A safety data sheet with information on general or health risks can be found at www.egger.com.

2.1 Health risk due to dust formation

Dust may be generated during processing. There is a risk of sensitization of the skin and respiratory tract. Depending on the processing and the particle size, especially when inhaling dust, there may be further health risks.

The formation of dust must be taken into account when assessing risks in the workplace.

In particular in the case of machining processes (e.g. sawing, planing, milling), an effective extraction system must be used in accordance with the applicable health and safety regulations. If there is no adequate suction, suitable respiratory protection must be worn.

2.2 Fire and explosion hazard

Dust generated during processing can lead to fire and explosion hazards. Safety and fire protection regulations must be observed.

3. Storage and transport guideline

3.1 General notes and climatisation

EGGER wood based products should be stored and processed in a closed storage/workshop space with stable climate ($T \geq 10^{\circ}\text{C}$ at approx. 50-60% relative air humidity).

Storage and processing conditions should correspond to the climate of later use.

In order to ensure optimal flat storage, it is necessary to **avoid** the following **negative impact** on the product during transport, storage and processing:

- Storage in the immediate proximity of heating devices or other sources of heat
- Direct exposure to heat and sunlight (outdoor UV light)
- Unequal air-conditioning with increased air humidity.
- Individual boards, as well as the stack's top and bottom boards react faster to changing environmental influences (climate) than boards inside the stacks.
- Prior to installation, EGGER wood based products should be conditioned for an adequate period of time in the respective rooms under the subsequent conditions of use.

3.2 Horizontal storage/stacking

Stacking should take place on load-bearing and flat ground. Joists should have a uniform thickness and their length should correspond to the width of the board stack. The distance between the foundation joists depends on the thickness of the boards.

Board thickness ≥ 15 mm: The distance must be of at least 800 mm. In any case, at least 4 joists should be used for half-format boards ($l=2800\text{mm}$).

Board thickness < 15 mm: The distance should be smaller than 800mm. The rule of thumb is "Distance = 50 * board thickness (m)".





Figure 1

In order to protect the board surface, the decor sides of two boards must always face each other, and/or cover boards must be used. Ensure sufficient edge protections if board stacks are to be fastened subsequently with steel or plastic bands. This can be achieved with the help of special paperboard or by using protection boards. In the case of several stacks stored on top of each other, the joists must be placed in a vertical line underneath each other. Protruding boards in same-format stacks must be avoided – see figure 2.

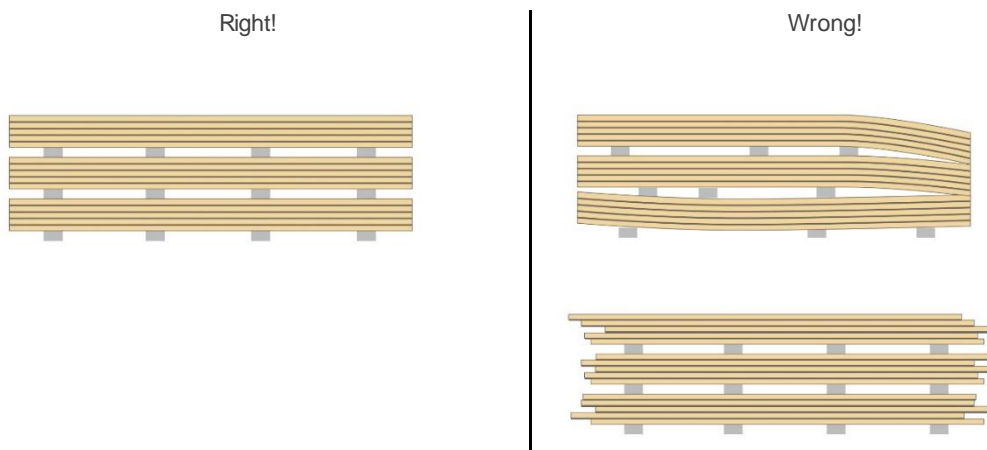


Figure 2

3.3 Vertical, upright storage

Vertical storage should only be used for a very small amount of EGGER wood based products. Horizontal storage is always preferable to vertical storage. In the case of vertical storage, special attention must be paid to secure fixing of the panels. Adequate fixing can be achieved via closed storage racks, magazines or shelves. The storage compartments should not exceed a width of 500 mm.

If open storage racks are used, the contact surface must have a minimum inclination of approx. 10°. In addition, only EGGER wood based products of the same format should be stored in open storage racks.



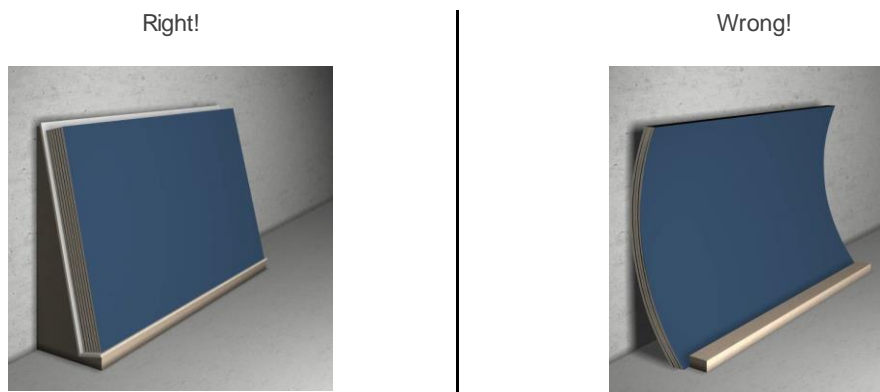
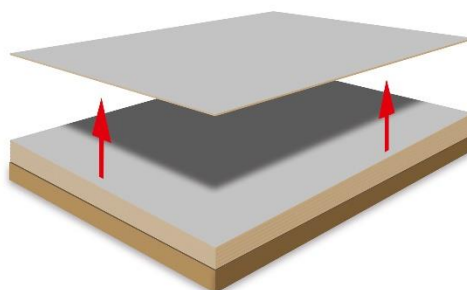


Figure 3

3.4 Handling

After removing the packaging and prior to processing, EGGER wood based products should be inspected for visible damage. As a rule, all persons transporting and / or handling boards should wear personal safety equipment such as gloves, safety footwear and suitable workwear. The boards must be lifted. The decor sides should never be pushed against one another or dragged over one another.



4. Tool recommendation

Detailed information regarding processing by milling, sawing and drilling can be found in our tool recommendations. These tool recommendations are based on various test series with the best machining results in cooperation with renowned tool manufacturers.

You can find more detailed information at www.egger.com/downloads

5. Cut-outs

Before processing, ensure that the material is supported securely so that the sawing, routing or drilling work is not likely to cause any damage. In particular, narrow board areas surrounding apertures can break or crack if the board is inappropriately handled during processing. The board cut-outs should also be secured so that they cannot break or fall out in an uncontrolled way and thereby cause injury to individuals or damage property.

Cut-out edges should be radiused (minimum radius > 5 mm) as sharp edges have an adverse effect on the material and can lead to crack formation. This applies particularly to the hob area where the frequent exposure to heat causes the material to dry out, thereby increasing shrinkage tension – see figures 4. When using halogen lighting (recessed spotlights), it must be ensured that a continuous temperature load does not exceed 50 °C.

The cut-outs should preferably be made using a portable hand router or CNC milling machine. When using jigsaws, the cut-out corners should be pre-drilled with an appropriate radius and the cut-out sawn out from radius to radius. You should cut from the underside of the board to prevent the surface layer from ripping off. The edges should be finished by means of sandpaper, filing or manual top milling to eliminate cracks due to chipping. The same finishing must be considered when using so-called "circle cutters" for halogen spotlights.



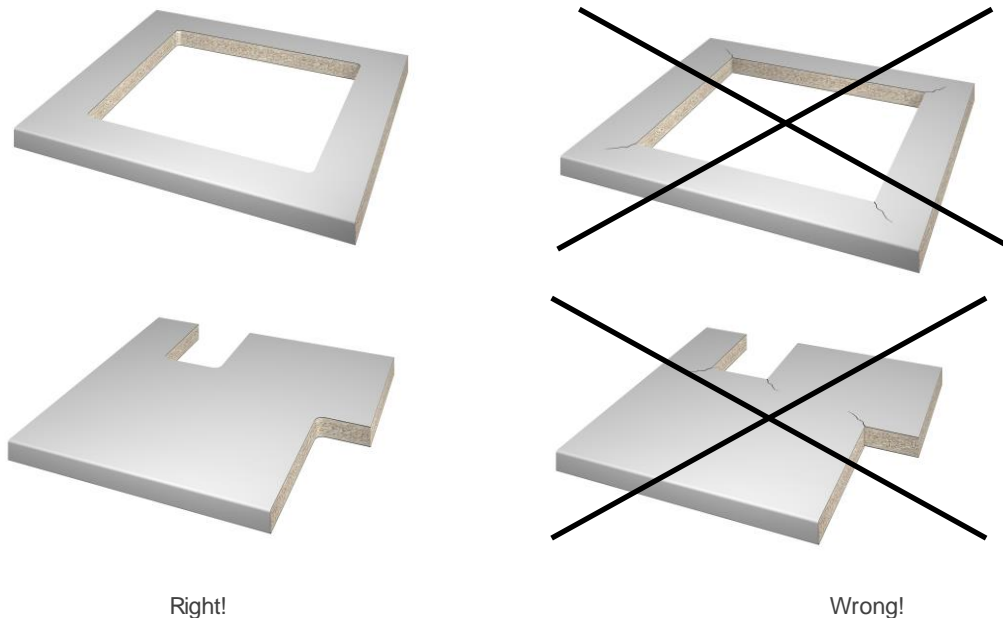


Figure 4

6. Sealing edges, cut-outs and drilled holes

Basically, wood based products used as table/work tops, fronts etc. are protected reliably against the penetration of moisture by the melamine surface coating.

Moisture and damp can still reach the substrate, however, via unprotected edges such as cut-outs, corner joints, miters, long back edges, drill holes, screw holes and fixtures. This means that the necessary sealing work must be carried out in the final installation. The best products for sealing wood based products have been found to be sealing profiles and self-curing sealants such as silicon rubber, polyurethane and acrylic. EGGER edges (thermoplastic edges) are used to seal visible cut edges.

When using sealants, you must also use a primer; either one that forms a film or a cleaning primer depending on the material.

You must follow the manufacturer's instructions carefully when using these materials.

It is absolutely essential that you clean the areas you are sealing and to allow the manufacturer's specified venting time when using primer. Apply the sealant leaving no gaps or holes and then smooth over with water and detergent. Mask off areas near joints to prevent the surface from becoming dirty. Any pipes or leads that are to be brought up through the material should be centered with a minimum distance of 2 to 3 mm on either side and carefully sealed.

7. Bonding

When bonding together wood based products, it is important to ensure that dimensional movements are not obstructed. To avoid stress, only adequately conditioned panels should be bonded together.

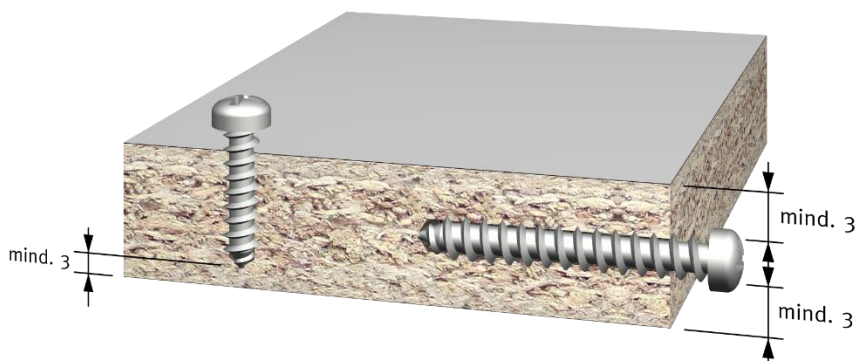
Prior to gluing, the boards have to be sanded, free of dust, grease and dirt, and pre-treated as necessary. Own material processing tests are recommended. Please observe the processing guidelines of the glue manufacturer.

8. Screw connections / Point fixing

If fittings, wall edging etc. are attached to surfaces of EGGER wood based products, it must be ensured that the surface is pre-drilled in the area of the screw connection. The diameter of the drill hole should be 1 mm larger than the diameter of the fixing device to avoid stresses in the material. Furthermore, for horizontal surfaces it is recommended to protect the inside of the screw hole by a sealing compound before screwing.

Heavy-duty connections such as: Corner and cabinet connections can be reinforced by a combination of bonding and fasteners, form-springs or grooves.

For drill holes that do not go through, so-called blind holes, the minimum board thickness that must remain is 3 mm. For drill holes parallel to the board surface, the minimum board thickness that must remain on either side of the drill hole is 3 mm.



9. Surface screw connections

Surface screw connections with trough holes must have sufficient clearance to compensate for the dimensional movement resulting from temperature and humidity fluctuations.

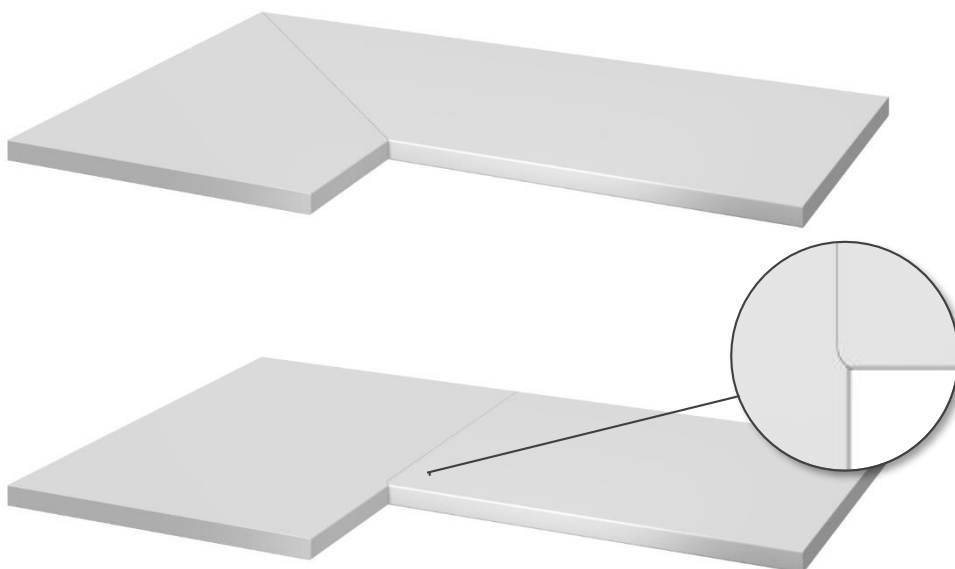
The diameter of the drill hole should be 2 – 3 mm larger than the diameter of the fixing device. In this way, tension due to the dilation and shrinking movement during changing climate can be avoided. Floating points and a fixed point are implemented on the individual elements for this purpose.

The fixed point serves to evenly distribute the expansion movement and should be positioned as centrally as possible. The bore hole diameter is equal to the diameter of the fastener.

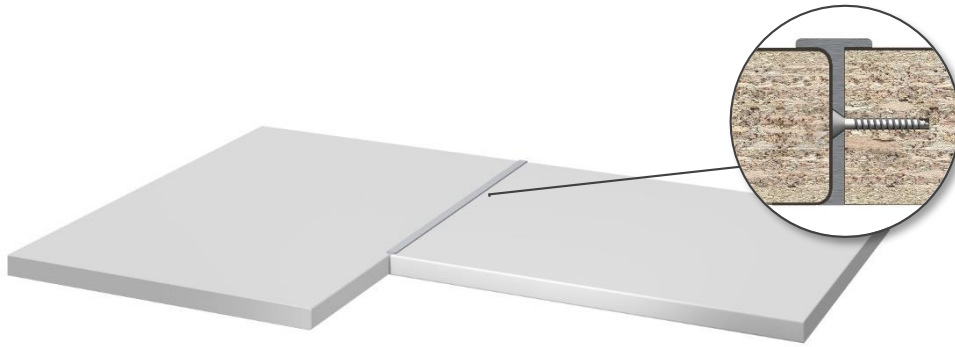
The bore hole diameter of the floating points should be 2 – 3 mm larger than the fastener. The bore hole should be covered by the head of the screw.

10. Joints and corner joints

Corner joints on EGGER wood based products are made by mitring on circular saws or routing using CNC routers and / or using special hand-held routers with the aid of templates.



Alternatively, metal connection profiles can be fitted. These profiles are easy to install but can have a negative impact on the overall appearance of the work surface, as it breaks up the decor and can also be difficult to keep clean.



11. Wall cladding

Thanks to its robustness and suitability for everyday use, EGGER wood based products are particularly well suited to interior wall paneling applications. We recommend a minimum board thickness of 8 mm for such applications. The walls and substructure should be completely dry prior to commencement of the panel installation. Always make provision for adequate air circulation behind the panels. The material should not be exposed to trapped moisture.

11.1 Substructure and ventilation

Wood based products should be fixed to a sturdy, corrosion-resistant and interlocking substructure which securely supports the weight of the wall paneling and ensures that ventilation behind the panels is provided. In dry construction applications, the attachment of the substructure and the material must be anchored to the stud framing. The selection of the fasteners has to be tailored to the substructure and the weight of the wall paneling. Different ambient conditions in front of and behind the elements can lead to warping. It is therefore essential that wall paneling installations always make provision for adequate ventilation to the rear of the panels, which allows temperature and humidity to equalize. The installation should be vented into the room.

Vertical studs generally permit air circulation. Where substructures are arranged horizontally, an appropriate construction must ensure that adequate ventilation is provided. The substructure should be vertically plumb to allow stress free mounting of the entire panel surface. Suitable substructures include vertical strips of wood or aluminum. The maximum spacing of the battens and / or substructure depends on the chosen thickness of the wall panel. It is important to ensure that air inlet and outlet areas remain unobstructed so that air circulation is not impeded. Also ensure that the moisture of the surface to be paneled does not differ significantly from the moisture of the finished wall panel.

The following are differentiated:

- visible mechanical fixation
- invisible mechanical fixation
- invisible glued fixation

11.2 Visible mechanical fixation

Fixation is done via screws or rivets on the substructure. A sufficient dilation gap and the right positioning of floating and fixed points must be taken into account. An EPDM tape must be used for decoupling when using wood as substructure.

11.3 Invisible mechanical fixation

The invisible fixation of wood based products by suspension permits straightforward disassembly and is aesthetically more appealing than visible fixation methods. Removing the boards is quick and simple. Cables and pipework installed behind the elements are easy to reach. Depending on the chosen mounting system, another advantage is that the elements can be adjusted later on. Stress-relieved mounting of the elements is also possible. For all mounting methods that involve hanging, sufficient space must be allowed to raise and lower the elements. This clearance or "suspension gap" will remain visible as a shadow gap.

Hanging by means of sectional strips

For this mounting method, a groove is cut into the horizontal substructure to hold the rebate rail attached to the wall element. For ease of fitting, the tongue of the rebated rail should be thinner than the groove. The rebated rails on the elements should not extend across their full width, they should be intermittent in order to permit vertical air circulation. Rebate rails made of plywood or metal Z-profiles can be readily used. If a secure screw connection cannot be achieved with thin wood based panels, additional gluing is also possible.

Hanging by means of metal hardware

Systems with metal hardware are also offered for mounting wall elements. The chosen system must be used according to the recommendations of the manufacturer in order to ensure secure installation.



11.4 Invisible glued fixation

Wood based products can also be mounted by gluing the panels to a rigid substructure. When using wood as a substructure, it is necessary to apply a primer as a preliminary step in order to ensure secure adhesion and moisture decoupling. Please observe the processing instructions of the glue manufacturer.

12. Cleaning and use instructions

Due to the resistant, hygienic and dense surface, EGGER melamine faced boards do not require any special form of care. As a general rule, stains and spilled substances such as tea, coffee and wine etc. should be cleaned up immediately, as the cleaning effort increases if they are left to dry. When cleaning is necessary, mild agents should be used.

Cleaning agents must in particular not contain any abrasive components, as they may adversely affect the gloss level or scratch the surface.

The following information should be observed for daily use:



Placing burning cigarettes on the melamine surface causes surface damage.

Always use an ashtray.



Melamine surfaces should not be used as a cutting surface, as this can also leave cutting marks on highly resistant melamine surfaces.

Always use a cutting board.



Placing hot cooking utensils such as saucepans and frying pans directly from the hob or oven onto the melamine surface should be avoided, as, depending on the heat exposure, a change in the gloss appearance or damage to the surface can arise.

Always use heat protection.



Spilled liquids should always be wiped or cleaned up immediately since extended exposure to certain substances can change the gloss level of melamine surfaces. Especially in the areas around cut-outs and joints, spilled liquids should always be cleaned up quickly and thoroughly.

These recommendations apply especially to matt surfaces. These have a distinctive look and feel, but have a greater tendency to show wear and tear.

More detailed information can be found at www.egger.com/downloads

13. Disposal

Any residues of EGGER wood-based materials on the construction site, as well as those from demolition measures, should primarily be recycled. If this is not possible, they must be sent for energy recovery instead of landfilling. Waste code according to the European Waste Catalogue: 170201/030105.

The country-specific laws and regulations on disposal must be observed.

These processing instructions were prepared based on the best available information and with due diligence. The information provided is based on practical experience, in-house testing and reflects our current level of knowledge. It is intended for information only and does not constitute a guarantee in terms of product properties or its suitability for specific applications. We accept no liability for any mistakes, errors in standards, or printing errors. Furthermore, the continuous further development of EGGER wood products as well as the amendment of standards and public documents may result in technical changes. Therefore, the content of these processing instructions cannot serve as instructions for use nor as a legally binding agreement. Our General Terms and Conditions apply.

