

INTRODUCTION

Tekstur paper composite panels are color-through & pressed at specific thicknesses - they have varied & attractive patterns milled about .5mm deep into their faces - with a balancing grid milled into the back face for stability. This fabrication and installation guide will give millworkers and installers the most important information required to perform the work required successfully. More data is available through the sales team and also on Ecosupplycenter.com - with specific information from the panel manufacturers.

Tekstur paper composites are made from two materials made by two different manufacturers - each has their own unique technical properties - so it is important to refer to the appropriate data for the material and color that is specified.

The colors **Ebony, Dark Chocolate, Cocoa, Caramel, Autumn, Burgundy, and Navy:** are made by **Richlite™ Paper Phenolics**. For specific panel limitations & behaviors please refer to **Richlite Technical Data .PDF**

The colors **Warm Gray, Pewter, Greige, Cappuccino, and Soft White:** are made by **Abet Stratificato™**. For specific panel limitations & behaviors please refer to **Abet-Laminati-Stratificato-Tech-Data .PDF**

All of these durable patterned panels will superced scratches, are waterproof & either Class A [Richlite] or class B [ABET] fire rated. Richlite panel colors Ebony, Autumn and Caramel can all be used for exteriors, and all of the rest are for interior use specifically.

Please feel free to contact Tekstur with any questions : **AlexS@EcoSupplyCenter.com 800 883 7005**

TABLE OF CONTENTS

SUBJECT	PG.
● Fabrication Guidelines.....	2
● Receiving Shipments.....	2
● Unpacking.....	2
● Storage.....	2
● Cutting & Machining.....	2
● Addressing Cut Edges.....	2
● Buffing & Applying Finishes.....	3
● Cabinetry & Furniture Applications.....	4
● Installation Methods & Guidelines.....	4
● MFTape System for Blind Fastening.....	5
● Panel Sequencing.....	7
● Lamination & Balancing.....	8
● Button-Fix™ Hidden Mounting System.....	9

FABRICATION GUIDELINES

RECEIVING

Panels will arrive strapped to a pallet in a custom crate that ships via common carrier. If there is any damage present, please note on shipping documentation - If the packaging & contents are damaged, then please refuse the shipment. *Do not sign for the shipment or let the driver go until you are certain there is no damage.* By signing the delivery slip, you are forfeiting your right to make a claim on the material.

UNPACKING

We use a multitude of packing materials to ensure no damage is done to the Tekstur panels. When unpacking, please be careful not to damage the panels with your tools.

STORAGE

Panels should be stored flat and protected from large swings in humidity and temperature. If the panels are to be staged for more than a week, we recommend placing stickers in between each panel so the panels are ventilated from all sides. If you start to see any cupping or warping on the panels, we recommend flipping them over and allowing them to sit for a couple of days.

CUTTING & MACHINING RECOMMENDATIONS

For All Colors

Blade: Carbide, Triple Chip, ATB, zero or negative rake. Most Solid Surface blades

Router Bits: Double Flute carbide

Router Feeds & Speeds: typically 18,000 rpm @ 200ipm

Recommended Bit Lubricant: Bostik Driccoat

ADDRESSING CUT EDGES

When cnc milled with proper tooling, feeds & speeds, the edges should not need much attention. Simply apply the specified edge treatment and move on to buffing. If other tools were used to cut the edges, and you need to remove tool marks- then use a random orbit sander fitted with 150 grit aluminum oxide sand paper. Be careful not to roll the sander onto the face of the material or you risk damaging the pattern on the face.

In most cases, addressing the edges will mean little more than knocking the sharp edge with sand paper or a small laminate trimmer with a 1/16" radius bit.

BUFFING & APPLYING FINISHES

Use one of the following finishes based on the application:

For colors Ebony, Dark Chocolate, Cocoa, Caramel, Autumn, Burgundy, and Navy use OSMO Poly-X Oil (24 hour Dry Time) or Richlite Professional Finish (5 min Dry Time). Both finishes are available from Tekstur & Eco Supply.

For colors Warm Gray, Pewter, Greige, or Cappuccino use Renaissance Micro-Crystalline Wax (5-10 min Dry Time) or Richlite Professional Finish (5 min Dry Time).

For color Soft White use Renaissance Micro-Crystalline Wax (5-10 min Dry Time).

Because of the shallow surface patterns and finishing issues that can develop because of them, we usually sell Tekstur Paper Composite Panels prefinished [\$75 / panel].

Apply finishes with a terry cloth buffing pad on an orbital sander or random orbit buffer. Add a small amount to the terry cloth pad [teaspoonful to a tablespoonful] and in a cross hatch pattern, allow the buffer to work the buffing compound into the material.

If too much finish is applied to the panel, you risk gumming up the surface. Remember, buffing these panels is only to bring out the inherent beauty of the material and deepen the color - it is not serving as a protective coating on the surface. It is better to be conservative and add a little more to the pad if needed then to go heavy handed with the first pass.

Interior Oxidation: Colors Dark Chocolate, Cocoa, Caramel, Autumn, Burgundy and Navy will darken & amber 10-15% over the first year after install due to UV. Please refer to the Richlite Patina Guide for more information about that color shift..

NOTES FOR EXTERIOR USE: Specific Tekstur panel colors can be used outdoors and in wet environments :

Ebony, Autumn, and Caramel colors from Richlite are all rated for exterior use. these panels are installed as ventilated rainscreens on building exteriors, so the panels experience the same environment on both faces & stay balanced. Eco Supply has documentation with drawings and resources for sourcing backup systems and color-matched screws for install as well.

Exterior Oxidation: Tekstur panels installed outside do not require finish, and they will also oxidize outside. the Ebony color oxidizes black & stays that way over many years - while the Autumn and Caramel colors will get a silver oxidation layer that slowly overtakes the native brown tone over time.

CABINETS & FURNITURE APPLICATIONS

Tekstur panels can be used as cabinetry, door & drawer faces in casework and furniture. For this application we recommend using 12mm or ½” panel thickness - please note that shallow cup European style hinges supplied by Blum will be recommended - used in combination with a 1.5mm hinge cup spacer also available from Blum.

Tekstur paper-phenolic panels can be cut and machined as structural Millwork and furniture components. It is possible to order Tekstur panels up to 3” thick*. Please consult one of our experts to discuss your design intentions.

*Only applies to colors Ebony, Ebony, Dark Chocolate, Cocoa, Caramel, Autumn, Burgundy, and Navy

Note: Because of the possibility of warpage, we do not recommend laminating 1/8” Tekstur panels onto plywood for doors or drawer fronts, etc- it would require balancing the panels by applying the Tekstur to both faces of the substrate & end up being more expensive.

<https://www.woodworkerexpress.com/cabinet-hinges-compact/#rfplist>
<https://www.woodworkerexpress.com/blum-hinge-cup-spacers.html>

INSTALLATION METHODS & GUIDELINES

It is very important that installers follow proper AWI industry techniques when installing Tekstur Panels. The quality of the fit & finish of a Tekstur panel installation relies heavily on the preparation of the sub-surface in which the panels will be mounted. Tekstur panels are rigid and will not compensate for variations in the wall surface. Make sure you are starting with walls that are plumb and level.

Note: *We discourage applying Tekstur panels directly to drywall or other materials with tape or adhesive. pg. 8 of this guide illustrates how to laminate a limited range of Tekstur colors that ARE available at 1/8” thickness to prepared wood surfaces with a vacuum press and epoxy.*

PURCHASING INFO AND METHOD

MFTAPE SYSTEM FOR BLIND FASTENING

For 5/16" & 8mm Panel Thicknesses

Monarch Metals: (631) 868-5119

<https://www.monarchmetal.com/products/monarch-z-clips/mftape/>

Link to 3M Primer 94:

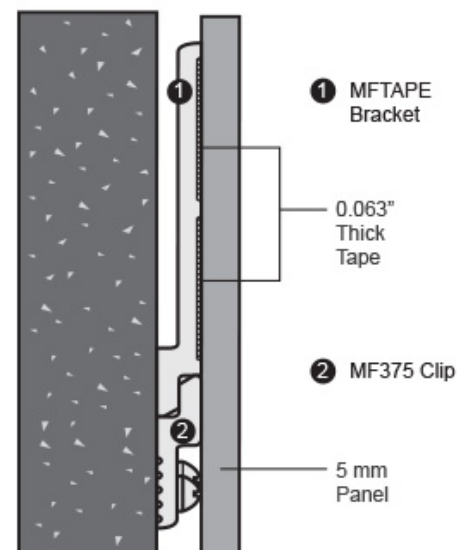
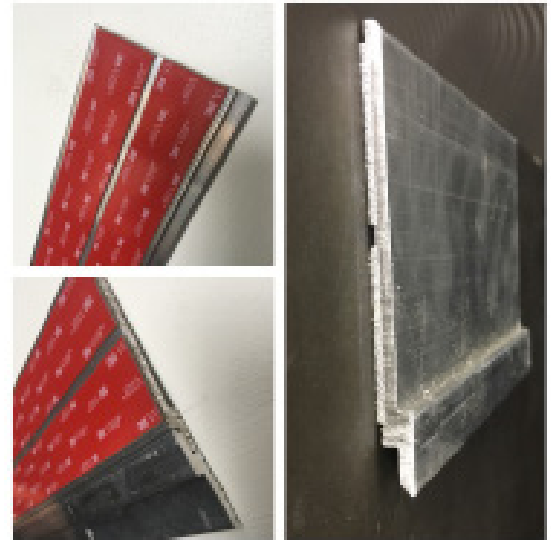
<https://www.amazon.com/3M-Primer-Pint-Wrapping-Application/dp/B0088P1LNY/>

MFTAPE BRACKET (FROM MONARCH)

- Price: \$7 - \$10 LFT
- 6' & 12' Lengths
- Mount To Back of 5/16" or 8MM Panel

We recommend the Monarch-Z MFTape system for our 5/16" or 8mm thick Tekstur panels. The MFTape-Z mounts to the back of the panel with using the 3M's, VHB Architectural Panel tape. This is an industrial strength tape that is strong enough to replace fasteners (welds, rivets, screws) or liquid adhesives. The tape comes pre-installed on the back of the Z-clip. We recommend running the MFTape Z-Clip across the entire width of the panel with no more than 24" of space between each clip vertically, with the top & bottom clip spaced in from the edge.

You will need to clean the back of the panel where you apply the MFTape Z-clip with 3M Primer 94. (see link below). This is basically a 50/50 mixture of isopropyl alcohol and water. Apply the primer to the area where you will mount the Z-clip. The primer acts as a cleaning agent and prepares your surface for the tape adhesive. Doing this will increase the bonding strength of the tape tenfold. Peel and stick the MFTape -Z to the area within 5 minutes of wiping the primer. Finish the application by applying pressure to the back of a Z-clip using a J-Roller or other pressure transferring tool.



MF375 RAIL : MF-TAPE BRACKET MOUNT TO THIS

- Price: \$1.50 - \$2.50 per LFT
- 6' & 12' Lengths
- Mount rails to wall, then panel to rails

Install the MF375 rails to the wall using the appropriate mechanical fastener. Clips should be mounted into to a structural component of the wall ie, studs or structural wood or plywood sub-wall every 18"-24".

*Do not mount the rails to drywall. Rails must be mechanically fastened through the drywall to a structural substrate or stud to prevent the clips from pulling off the wall.

The success of your installation with regards to alignment and fit & finish relies heavily on the preparation of the sub-wall and/or installation of the MF375 wall mounted clip. If these clips are not plumb and level any difference in tolerance may translate to the installed panel surface. Take care to prepare your sub-wall, shimming or fur out where necessary to insure your clips are consistent, plumb and level to each other.

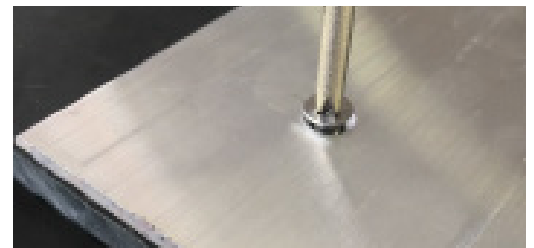


ADDING A MECHANICAL FASTENER TO MFTAPE BRACKET:

It is possible to add a mechanical faster through the MFTAPE Z-Clip if desired. With our 5/16" or 8mm thick panels, pilot and countersink a 11/64" hole through the Z-clip into the back of the panel and use a 10-32 x 5/16" flat head screw to fasten the Z-Clip to the panel. Hand tighten the screws with a screw driver.

Because the tight tolerances associated with drilling into a thin panel, we suggest using a Drill Stop Collar to prevent drilling through to the front face of the panel.

See link below to the screws you can use from McMaster Carr:
<https://www.mcmaster.com/#ms-51960-62-machine-screws/>

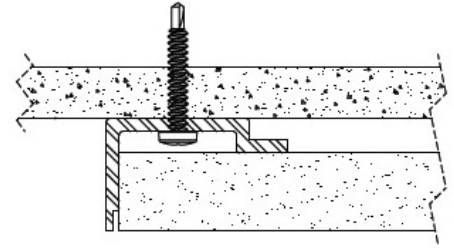


READY MADE TRIM & EDGE DETAILS FROM MONARCH METALS (631) 868-5119

- Price: \$8 -\$10 per LFT
- 6' & 12' Lengths ready to ship

<http://www.monarchmetal.com/wp-content/uploads/Monarch-Easy-Panel-System-Instructions.pdf>

If you need an outside trim detail, you can use Monarch's EPS-H039-N aluminum trim component. These will work on both vertical and horizontal edges. Visit the link below for installation Instructions and specifications.



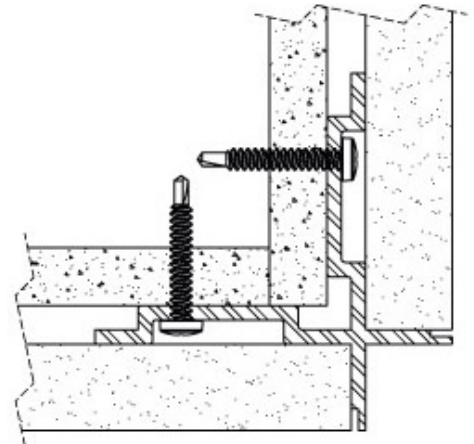
Edge Trim
EPS-H039-N ([PDF/DWG](#))

INSIDE/OUTSIDE CORNERS ALSO FROM MONARCH METALS (631) 868-5119

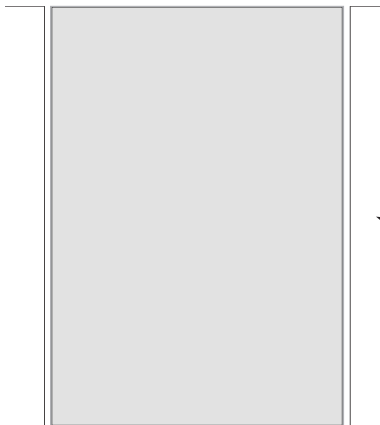
- Price: \$6 -\$8 per LFT

<http://www.monarchmetal.com/wp-content/uploads/Monarch-Easy-Panel-System-Instructions.pdf>

If you need outside and inside corner detail, you can use Monarch's EPS-OC039-N aluminum trim component. Visit the link below for installation Instructions and specifications.



Edge Trim
EPS-OC039-N ([PDF/DWG](#))



PANEL SEQUENCING

The patterns on all Tekstur panels are designed to repeat on the 4' widths and the 10' lengths.

We recommend an 1/8" - 3/16" spacing between panels vertically & horizontally to allow for building and backup system movement during seasonal changes.

METHOD

LAMINATION

1/8" thicknesses used for curved walls and specialty panels

Laminating 1/8" thick Tekstur Panels to Casework or Curved Wall Assembly

Note: *The instructions below are for these colors listed only: Ebony, Dark Chocolate, Cocoa, Caramel, Autumn, Burgundy, and Navy, and will yield a stable lamination that will perform as expected.*

We currently do not offer 1/8" panels in Warm Gray, Pewter, Greige, Cappuccino, or Soft White.

- For best results, let the substrate and Tekstur panels acclamate to the environment at least 2 weeks.
- Abrade the back of the panel with 80 grit sandpaper on random orbit sander.
- Blow off dust and clean back of panel with odorless mineral spirits or denatured alcohol.
- Spread a thin layer of SystemTHREE T-88 epoxy on entire surface of panel & substrate.
- Adhere Tekstur panel to the substrate with even clamping pressure across the entire surface.
- Depending on temperature your open working time will be 30-60min.
- Full cure time is 24 hours.

NOTE: *It is important to clean up epoxy squeeze out with acetone before it cures. If excess epoxy is left on the surface it will be very difficult to remove when fully cured.*

Balancing Lamination

Tekstur panels should be installed according to AWI standards.

If the Tekstur panels are being used specifically for passage door skins, we recommend applying the same thickness Tekstur panel to both sides of the door core- to achieve equilibrium and help control warping and/or bowing.

NOTE: *This guide is a basic introduction to these important topics. Please refer to specific material technical data sheets from the manufacturers, available from Eco Supply - and be sure also to refer to AWI standards for environmental & procedural limits & requirements.*

As always, we are available for quick consultaion or fabrication/installation advice.

AlexS@EcoSupplyCenter.com 800 883 7005

METHOD

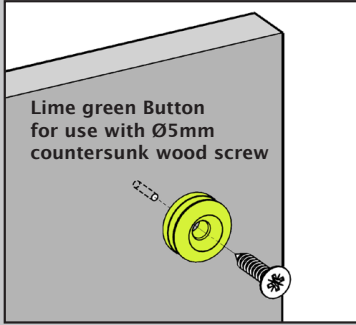
BUTTON-FIX™ HIDDEN MOUNTING SYSTEM

5/16" & Thicker Panel Thicknesses. Meant only for smaller panel sizes (max 24" x 24" recommended).

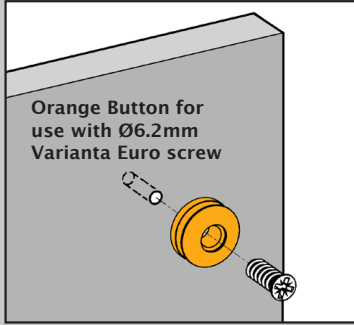
The button

Choose the Button to suit the screw type that works best with your panel material.

Use lime green Buttons with Ø5mm countersunk wood screws. Use orange Buttons with Ø6.2mm Euro screws (to fit Ø5mm pilot holes).



Lime green Button for use with Ø5mm countersunk wood screw



Orange Button for use with Ø6.2mm Varianta Euro screw

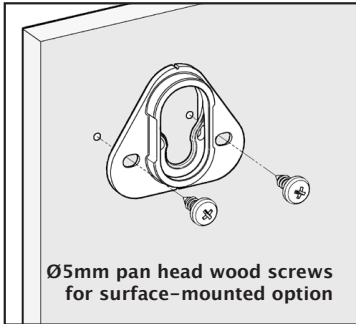
Type 1 fix

The Type 1 Fix connects parallel panels and is ideal for applications where strength and security are paramount.

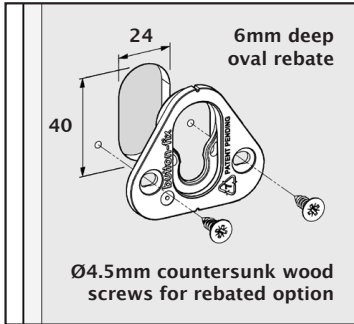
Engage the Buttons in the Fixes and slide the panel down by 15mm until Button-fix goes 'click'. The Type 1 Fix can also be configured for sideways assembly.

When surface-mounted, the Type 1 Fix creates an 8mm gap between the two attaching panels.

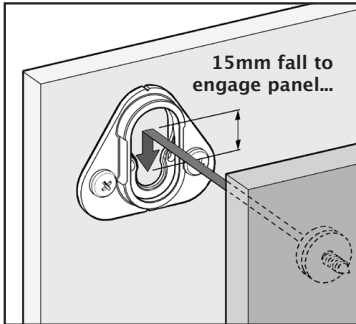
Alternatively, you can rebate the Type 1 Fix, to reduce the gap between the two attaching panels to only 3mm.



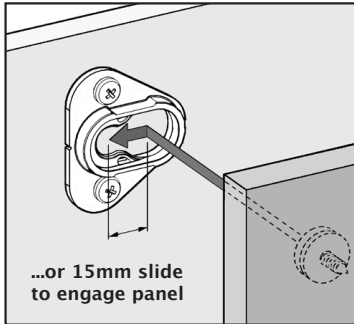
Ø5mm pan head wood screws for surface-mounted option



24 6mm deep oval rebate
40
Ø4.5mm countersunk wood screws for rebated option



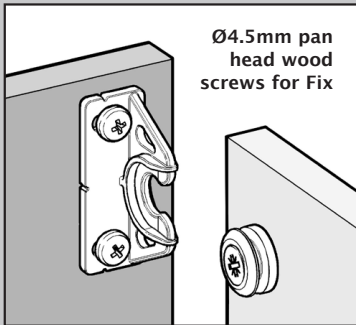
15mm fall to engage panel...



...or 15mm slide to engage panel

Type 2 fix

The Type 2 Fix connects panels at 90° with a simple push/pull fit. It is ideal for applications where the emphasis is more on ease of fit and less on strength. Unlike Type 1, the Type 2 Fix does not require a 15mm drop-down engagement.



Ø4.5mm pan head wood screws for Fix

