

INTRODUCTION & IMPORTANT NOTES

These fabrication and installation guidelines intend to make Tekstur panels easy to work with and install successfully.

Tekstur products are made from a variety of different materials, each with their own unique technical properties, so it is important to refer to the appropriate tech data sheet for the material and color specified in your project.

For colors Ebony, Dark Chocolate, Cocoa, Caramel, Autumn, Burgundy, and Navy: refer to technical documents and data for **Richlite™ Paper Phenolics**.

For colors Warm Gray, Pewter, Greige, Cappuccino, and Soft White: refer to technical documents and data for **Abet Stratificato™**.

Please feel free to contact us with any questions.

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 in a custom crate via common carrier. If there is any damage present to the packaging, please notate. If the packaging has significant damage, then open the crate and check for damages. *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 and you need to remove tool marks, then use a random orbit or belt 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"r 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).

Apply finishes with a terry cloth buffing pad on an orbital or random orbit buffer. Apply a small amount to the terry cloth pad. In a cross hatch pattern, allow the buffer to work the buffing compound into the material.

If you apply too much of either of these solutions then 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, and is not serving to form 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.

Note: *When using Tekstur panels for exterior applications it's best to leave the material as is. The material does not need protection. When exposed to the elements you should allow the material to take on its own patina. These paper-phenolic composites do not take hard coat finishes.*

Outdoor & Wet Environments: Tekstur Richlite panels can be used outdoors and in wet environments. Please consult one of our experts for detailed information about which colors perform the best. Warning: In exterior applications, DO NOT fix the panels directly to the wall. The panel spacing and attachment must allow air to circulate around all surfaces of the panel. Not adhering to these guidelines could result in both failure of the panel system and damage to the exterior of the building.

IMPORTANT: Panel colors Warm Gray, Pewter, Greige, Cappuccino, and Soft White are not rated for exterior use!

Note on Color Shift: Colors Ebony, Dark Chocolate, Cocoa, Caramel, Autumn, Burgundy and Navy will oxidize and darken in color over time depending on the environment they are installed in. Please refer to the Richlite Patina Guide for more information.

CABINETRY & FURNITURE APPLICATIONS

Tekstur panels used as door & drawer faces in kitchen cabinets and furniture. For this application we recommend using 12mm or ½" material and a shallow cup European style hinge supplied by Blum. Because of the possibility of warping and/or cupping, we do not recommend laminating thinner Tekstur panels onto a substrate, unless you plan on balancing the laminated panel by applying the thinner Tekstur panel to both sides of the substrate.

Tekstur paper-phenolic panels can be cut and machined as structural Millwork and furniture components. It is possible to order 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

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 the wall. If there are project constraints in which the Tekstur panels need to be applied directly to the wall surface then we recommend the thinnest available thicknesses (1/8" or 4mm). Apply the panels using one of the specialty industrial tapes, along with a suitable construction adhesive. For guidance, please consult with one of our experts to discuss the specifics of the project.*

METHOD

MFTAPE SYSTEM FOR BLIND FASTENING

For 5/16" & 8mm Panel Thicknesses

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, with your top & bottom clip spaced in from the edge.

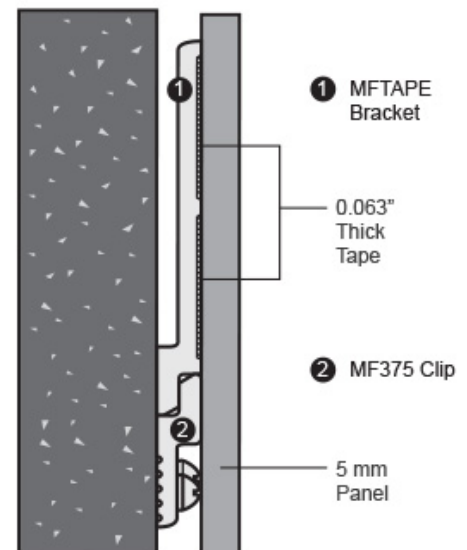
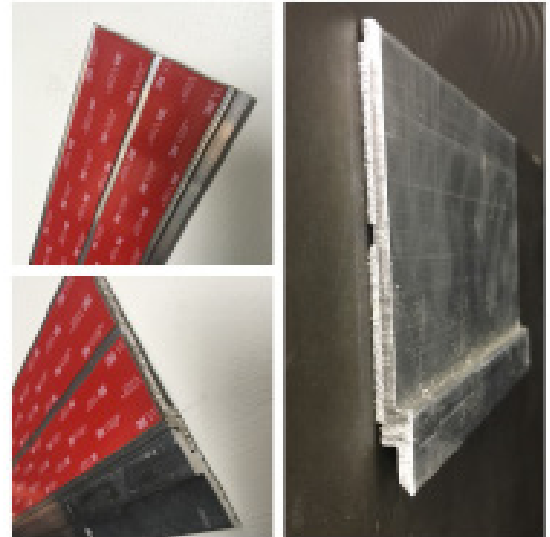
You will need to clean the back of the panel where you apply the MFTape Z-clip with 3M Primer 94. (see link below). This is basically a 50/50 mixture of isopropyl alcohol and water. Apply the primer to the area where you will mount the Z-clip. The primer acts as a cleaning agent and prepares your surface 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.

Link to Monarch Metal:

<http://www.monarchmetal.com/products/phenolic-glass-glazing-panel-hanging-system/>

Link to 3M Primer 94:

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

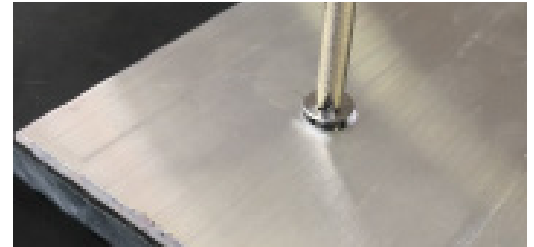


ADDING A MECHANICAL FASTENER TO MFTAPE BRACKET:

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/>



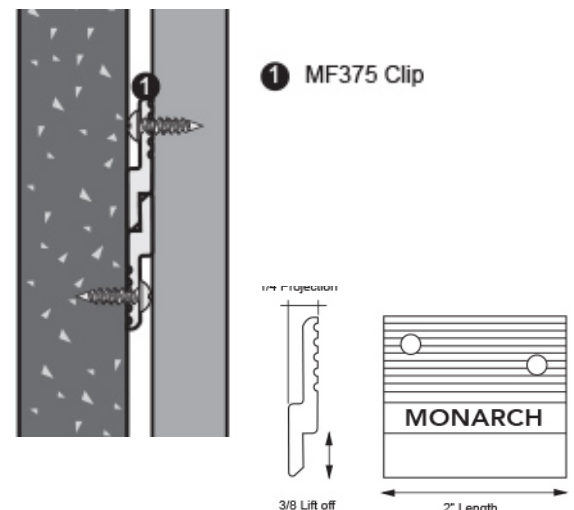
MF375 RAIL (FROM MONARCH)

- Price: \$1.50 - \$2.50 per LFT
- 6' & 12' Lengths
- Mount Rails To Wall

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.

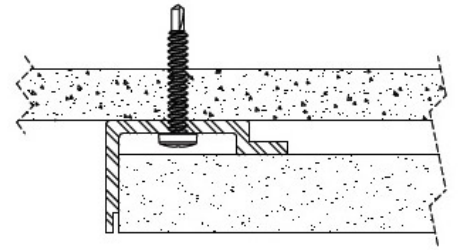


TRIM & EDGE DETAILS (FROM MONARCH)

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

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.

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



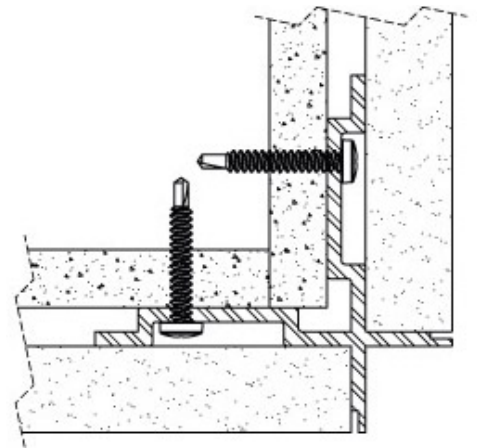
Edge Trim
EPS-H039-N ([PDF](#)/[DWG](#))

INSIDE/OUTSIDE CORNERS (FROM MONARCH)

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

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.

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



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



PANEL SEQUENCING

The patterns on all Tekstur panels are sequenced along the 4' width. We recommend an 1/8" - 3/16" spacing between panels to allow for expansion and contraction.

METHOD

LAMINATION

For 1/8" thicknesses

Laminating Thin Tekstur Panels (1/8" thicknesses) to Particle Board, MDF or Plywood

Note: *The instructions below are for the colors listed only. If these panels are not glued properly, they can move. We do not recommend laminating colors Warm Gray, Pewter, Greige, Cappuccino, and Soft White.*

For colors Ebony, Dark Chocolate, Cocoa, Caramel, Autumn, Burgundy, and Navy Only:

- For best results, let the substrate and Tekstur panels acclimate 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 and glue with mineral spirits before it cures. If excess glue 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 cabinet doors or other thin "floating" panels, we recommend applying the same thickness Tekstur panel to both sides of the substrate to achieve equilibrium and help control warping and/or bowing.

Please contact one of our material specialists if you are in doubt about which strategy is most appropriate for your application.

IMPORTANT: These are just guidelines, please refer to material technical data sheets and AWI standards for lamination details.

METHOD

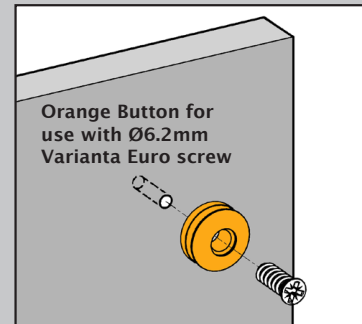
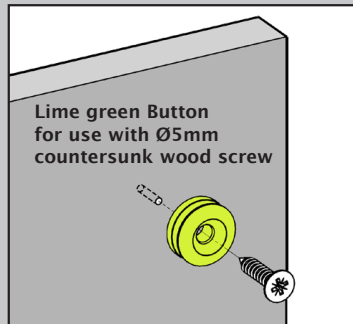
BUTTON-FIX™ HIDDEN MOUNTING SYSTEM

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).



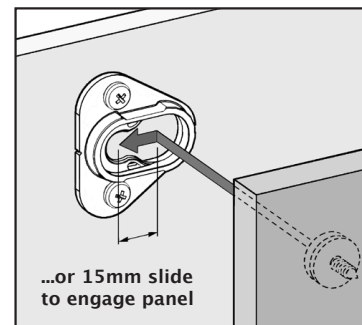
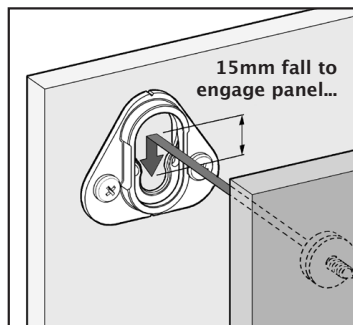
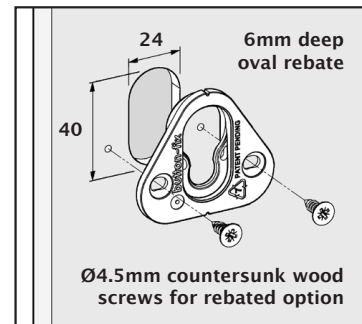
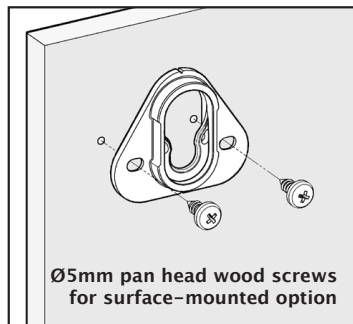
Type 1 fix

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.



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.

