GENERAL HANDLING & STORAGE

General Handling:

1. Carrying panel is best done with two people. Position the sheet on its side (vertically) and pick up from each end.

2. DO NOT pick up the sheet horizontally (lying flat) as it will bend or warp the sheet.

3. When removing sheets from a pallet or stack, never drag the sheet as it can scratch the sheet below it. Lift the sheet clear of the remaining sheets on the stack.

4. Handling all panels with a forklift requires a pallet that is in good shape. Picking up a pallet of panels from the end of the pallet is not recommended as it could cause bowing of the sheets if the forks/fork extensions are less than 8' . It is recommended to pick up the pallet from the side to help better support the material.

Storage:

1. Proper Storage requires lying the panels horizontally/flat on a good pallet or in a proper vertical rack. If storing sheets vertically, ensure that they are straight up/down, not at an angle, which will cause bowing of the sheet.

PRINT OPTIMIZATION

Preparation:

1. Surface Preparation:

a. Our Easy-To-Peel Protective Masking ensures no residue is left on the panel, reducing cleaning time and eliminating the risk of interference with the print.

b. Always wear clean cotton gloves when handling sheets after masking has been removed.

c. If surface cleaning is deemed necessary, it is recommended to use a soft cloth and 90%+ Isopropyl alcohol.

2. Digital Printing:

a. The panel has a line of Digital Printable (DP) products, which incorporate a print optimized surface for industry leading ink adhesion.

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b. Each Digital Flatbed printer utilizes different color profiles that not only control the color and vibrancy of the ink, but also controls the density of the ink being printed on the panel. Please select the profile that your printer manufacturer recommends for ACM panels.

3. Painting:

A. Surface should be lightly abraded to provide a better coating surface. The Surface should then be cleaned of all contaminates i.e. dust, dirt and oil etc. A soft cloth with a non-petroleum based solvent or Isopropyl alcohol should be used to clean the surface area.

Material	Tool Type	Blade Recommendation	Blade Specs	Max Cutting Speed	Max Cutting Feed Rate
Steel Composite Panel	Circular Saw (Table Saw, Panel Saw or Portable Circular Saw)	Steel Cutting Blade	Ferrous/Steel Cutting Blade. Maximum number of teeth available is recommended. i.e. Diablo D0770F 70 Tooth Steel Blade was used during testing and yields excellent results.	5500 RPM	30 mm/sec

ROUTING INSTRUCTIONS

Standard CNC	
Bit size (grooving)	10mm ball nose
Bit size (cutting out)	4mm
Pass Depth	10mm
Stepover	1.8mm
Spindle Speed	12000-24000 rpm
Feed Rate	35mm/sec
Plunge Rate	15mm/sec

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