

MOSO® panel/veneer processing instructions

important notes before use

- Advised room conditions: temperature approx. 21°C. Air humidity 40-65%.
- The MOSO® 1-ply panels and MOSO® solid multilayer panels are oversized in length and width and are NOT calibrated (fine sanded).
- The MOSO® 1-ply panels and Moso solid multilayer panels have an A- and B-side. The backside (B) generally contains more colour variation than the surface side (A) and can show small seams between the strips. The backside is marked with a pencil line or sticker.
- Be sure to keep track of the A / B side if you cut the panel into smaller parts (because after cutting the pencil line/sticker is not visible on each part anymore).
- The inner layers of MOSO® solid (multi-layer) panels consist of multiple, separated cross segments, which create some small voids in these layers. This construction is made to optimize the stability of the panels. The voids normally have to be filled during further processing.
- The length positioned middle layers of solid (multi-layer) panels longer than 2440mm can have finger jointed segments.
- Please check your panel for damage/defects before use. MOSO® panels always are oversized a few mm (max10mm). If there are damages on the edges (for example due to transport) they normally can be cut off.

pressing/glueing the panels

- Calibrating the panels (reducing thickness tolerances) is required before pressing on a carrier panel to secure a good bonding between layers. This requirement needs special attention in case of cold pressing and when multiple panels are piled and pressed at the same time.
- The MOSO® 1-ply panels should be pressed with the back side on to the core (carrier) material.
- In most cases the MOSO® 1-ply panels/veneer need to be pressed on a carrier material in a "sandwich"- construction (3-ply) to maintain the balance in the total panel and avoid bending. Make sure that the type and thickness of panels on both sides of the carrier are the same.
- The glue quantity and pressing method depends on the absorption of the carrier panel. For 1ply panels normally cold pressing systems are used; for veneer hot pressing systems.
- Advised glue 1ply panels pressing: PVAC with low water content or PU glue. Elastic glues are not advisable.
- Advised glue veneer pressing: Urea Formaldehyde or PVAC glues (both hot pressed).
- When pressed under high pressure and high temperature a considerable cooling time should be taken into account before stacking the cooled (max. 60°C) panels.

finishing the panels

- MOSO® High Density® panels may contain small seams on the surface. Depending on the finishing requirements, the surface can be closed using a (color matching) filler.
- Lacquer: all lacquer systems can be used on bamboo. Dispersion lacquers can cause the bamboo fibers in the surface to raise up. This is especially the case when applying the first layer. After fine sanding and applying the second layer this should be solved.
- Oil: apply the oil very thinly. As bamboo is very dense it will not absorb the oil very fast, therefore a too thick oil layer can lead to gloss differences and long drying times. Apply at least in 2 layers.

color change due to UV radiation

- Bamboo will change in color due to UV radiation. The natural color will become slightly darker and the caramel color will get slightly lighter.

These instructions are subject to change. For the latest version go to www.moso.eu.

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