Technical Details

MULTISHIELD

galvanised steel composite sheets

MADE IN BRITAIN

A double-sided composite panel offering greater strength and rigidity, Multishield's galvanised steel sheets have two different coatings and are also receptive to magnetic media. Now available in either digital/digital or digital/whiteboard finishes.

Property		Value
Physical		3mm
Steel skin thickness	mm	0.25
Weight	kg/m²	6.35
Face finish	-	Digital or whiteboard coatings
Core composition	-	LDPE
Thickness Tolerance	mm	+/-0.2mm
Sheet Flatness Tolerance	0 – ≤2mm across any measured point of the panel perimeter from a flat surface	

Fire classification	
Standard	
EN13501-1	C-s2-d0

Sheet sizes and tolerances			
Width	Tol	Length	Tol
1220	-0 +2mm	2440/3050	-0 +3mm

General Fabrication guidelines	
Bit size	4mm
Pass Depth	10mm
Stepover	1.8mm
Spindle Speed (Steel rpm needs to be lower than on aluminium)	12000-24000 rpm
Feed Rate	35mm/sec
Plunge Rate	15mm/sec

LKH Tools Recommended Fabrication guidelines (tested using Crown Norge Tools)	
Bit size (grooving)	10mm ball nose
Bit size (cutting out)	3 or 4 mm
Spindle Speed	12000-18000 rpm
Feed rate	3m/minute (50mm/sec)
Plunge rate	0.5m/minute (8mm/sec)
Recommended tools	B1-10.0/-10-10-50 MP B Superior - grooving tool S1-3.0/6-6-50 MP Superior - 3mm cut out tool or S1-4.0/6-6-50 4mm

MULTISHIELD can also be cut and v-grooved with no sparks or dust by using the steel composite cutting head specially developed by Keencut for use on their SteelTrak cutters

www.multipaneluk.co.uk

UK Head Office +44 (0)1392 823015 USA Office +1 718 841 9940

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RB-1000 Roller-coating Paint

1. Material: Modified polyester resin

2. Speciality: Easily cleaned, fit for white board pens of various brands

3. Application: Interior use only

4. Performance (white paint):

TEST ITEM	TEST METHOD	STANDARD
Appearance	No bubble, pinhole or dent visually	smooth without defects
Adhesion test on checkerboard pattern	1mmX1mmX100	100/100
Gloss	60° angle gloss-meter	>80°
Pencil hardness	Mitsubishi UNI pencil	>H
Impact resistance	1/2'' Φx500gx50cm	No fracture
Bending resistance	Bending strength and 90° bending	No crack
Solvent resistance	Wipe 200 times back and forth by MEK, 1KG	PASS
Salt spray resistance	5% NaClx35°C x 500 hours	PASS
Boiling water resistance	98±2°C x 2 hours	PASS
White board pen cleaning	Prints written by white board pens of four brands can be cleaned after being placed at 25°C room temperature for 24 hrs.	PASS
Endurance	After erasing 5000 times with 1KG load, prints written by white board pens of four brands can be cleaned after being placed at 25°C room temperature for 24 hrs.	PASS
Endurance (alcohol wipe)	After wiping with alcohol soaked cloth, 5000 times with 1KG load, prints written by white board pens of four brands can be cleaned after being placed at 25°C room temperature for 24 hrs.	PASS

5. Items needed for making sample

a. Alloy: chromodized aluminium(0.1mm-0.5mm) ; galvanized steel
b. Coating: RB-1000 white paint
c. Diluent: S-R104 specific one
d: Coating viscosity: 70±10 seconds (FORD# Cup 4, 25°C)
e: Standard coating layer: primer 6-8μm, top coating 18-20μm
f: Drying condition: P.M.T 216-241°Cx70-100 seconds

Remarks

This kind of coated product shouldn't be wiped by MEK(butanone) or any other kind of solvents, which will damage the coating layer.

The life time of whiteboard panel will vary, depending on the different usage frequency.
Prints written on the board should be wiped within 1 week.

MULTIPANELUK LTD
a multitude of applications
www.multipaneluk.co.uk
UK Head Office +44 (0)1392 823015 USA Office +1 718 841 9940