

PAPEROCK

INSTALLATION GUIDE FOR PAPEROCK SOLID & PLY

Paperock is a versatile product with many great properties. It is important to follow a few guidelines with regard to care and maintenance to ensure the product's maximum longevity. Paperock is impregnated with phenolic resin making it impervious to water. It is also stain and heat resistant up to 170 degrees centigrade.

Paperock is a handmade product with inherent imperfections giving the product its natural look and feel.

CARE & MAINTENANCE

DON'T

Although heat resistant up to 170 degrees it is not advisable to put hot implements directly onto surface.

Don't use cutting implements directly on surface.

Don't use bleach based products to clean surfaces

DO

Wipe down Paperock with water soluble, non-abrasive cleaning products.

Use a cutting board on surface, eliminating contact with knives etc.

Read our Care & Maintenance Guide for full details on how to look after your Paperock surfaces.

INSTALLATION

Please read this Installation section before fabricating and be sure to read the safety data sheet prior to fabricating.

Please inspect sheets prior to cutting to check for defects. Sheets cannot be returned once cut.

Things to note:

Paperock may possess some inherent imperfections giving slight variations from sheet to sheet.

Water marks – can be sanded out

Mottling – gives natural stone look. If not desired a tinted oil can be applied to the surface.

Paperock is not 100% UV stable, which may result in fading of the surface over time. This can vary depending on the amount of UV the area is receiving. An application of a tinted oil can assist in the rejuvenation of this if necessary.

SANDING

Due to exposure from freight and handling scratching or scuffing may occur. Please see below if sanding is required.

- It is important that the surface is not over sanded. Paperock is a hand-made product with many layers of paper. The deeper that it is sanded, the greater chance of encountering an onion peel effect through the layers and the finish becoming more polished.
- If sanding is required it is advisable to consistently sand the whole surface using a random orbital sander with dust extraction.

INSTALLATION

SANDING cont.

- It is common that the material has inherent water marks on the surface and these can either be lightly sanded out or left as a feature of the material. Over time the material may gain a natural patina.
- If needing to lightly sand out blemishes or scratches that may have occurred during fabrication it is advised to use 180 grit with no greater than 240 grit.
- Edges can be cleaned up with 40 grit, sanding up to 240 grit for a polished edge.
- Ensure sand paper is clean to avoid swirl marks occurring.
- Please ensure a respirator(mask) is used when sanding or cutting Paperock.

CUTTING

- It is recommended that "good quality" tungsten carbide blades be used for any cutting of the material.
- A Solid surface blade with 90+ teeth will achieve a clean cut.
- Do not use a ripping blade
- Paperock can be cut using a panel saw or CNC.
- Paperock is a dense product and can be likened to cutting compact laminate or well-seasoned iron bark.

JOINING

- Due to the nature of production of Paperock each sheet has a thickness tolerance in some cases up to +/- 1mm.
- Ensure thickness is checked prior to cutting to get best match for thicknesses between sheets.
- When joining it is best to make the top edge flush, using biscuit or toggle joins. That way avoiding the need for excessive sanding on the top layer. You can then pack out and sand underneath to make level if required.
- When joining please use biscuit joins or toggles or some type of bracing to avoid the join coming apart if the substrate is to move.
- Paperock can be joined in a number of ways depending on design of cabinetry

GLUING

Paperock SOLID

- With all joins we recommend using a two part clear epoxy (araldite) for gluing.
- Line edge of join with masking tape to avoid having to sand surface after.
- When bringing the joins together, allow glue to start to go off, once at a gel like consistency use a sharp implement eg. chisel to clean off excess to avoid need for sanding.
- If applying to a substrate, an adhesive such as liquid nails or contact adhesive is adequate.
- PVA glue is not recommended.
- Some form of bracing is required when gluing joins eg. toggles, biscuit joins to allow for movement in the substrate. At the very least a metal bracket screwed underneath to secure the join.

Paperock PLY

- PVA glue can be used with Paperock Ply if desired.

FINISHING

ROUTING

- Ensure that the edge finish is not extremely rough (if so, perform a preliminary sanding of the edge with 80 to 180 grit sandpaper depending on severity of roughness).
- Using a profile bit with a guide bearing, route the desired edge detail into the panel's edge (if desired edge detail requires the removal of a considerable amount of material, utilise 'step-cuts' to maintain a better edge and prevent burning). Burn marks can be easily sanded out if required.
- A pencil round or aris is recommended to take out the sharpness on the edges.

DRILLING

- All holes should be pre drilled ensuring pilot holes are the correct size to avoid screws snapping in material.
- Test on an offcut prior.
- Strongest grade screws are recommended (steel).

CNC ROUTING

- It is advisable to use solid carbide end mills with Paperock SOLID & PLY.
- Start with 'roughing cuts' in which you cut @ 10,000 RPM's and travel @ 200 inches per minute.
- Solid carbide 'compression' cutters seem to work best for this during this 'roughing cut', because it tends to reduce the amount of 'chip-out'.
- Perform 'step' cuts that are no deeper than the diameter of the tool that we are using. For example, if cutting a 25mm thick Paperock panel with a 6" end mill, we will perform 'step' cuts of no more than 6" depth at a time.
- Then perform a "finish cut" @ 15,500 RPM's and @ 185 inches per minute.
- This cut seems to come out the best when we use a 3 or 4 flute spiral cutter.
- The final pass is a full thickness cut. This is a good starting point, but all machines tend to be slightly different.

TESTING OFFCUTS

- In all cases of fabricating Paperock we recommend testing on offcuts prior to joinery. This will allow the fabricator to have a good knowledge of how to use the product.

APPLYING OSMO OIL

Please see our [finishing video on our website](#)

To finish Paperock we recommend applying [Osmo Top Oil](#) to the surface and sides to assist with durability and colour enhancement. Paperock can provide this with your order if required.

DO NOT APPLY USING INSTRUCTIONS ON THE CAN OF OSMO OIL

- Apply a light drizzle(2 caps over 1m2) using a micro fibre cloth or clean rag. **Do not use a brush or roller as it will leave streaks.**
- Use a circular motion to lightly spread the oil into the Paperock surface.
- Remove excess oil with another clean rag using a circular buffing motion, rubbing dry resulting in a consistent finish. Elbow grease is required for best results.
- It is important **NOT** to over apply, ensuring all surplus is rubbed off.
- Over application will cause the finish to scratch easily. No more than one coat is required. Leave to dry at least 24 hours ensuring good ventilation.

CLEANING

See our care and maintenance guide for full information.

- Test cleaning products on small area of surface before applying overall.
- Benches should be wiped down with water soluble, non-abrasive tools and cleaning products.
- **Bleach based products are NOT to be used on Paperock surfaces, as it will damage finish.**
- Osmo Spray cleaner is best for cleaning surfaces finished with Osmo oil. Search for Osmo Spray Cleaner in Google to find the best place to purchase.