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## Technical Information for Móz Metals

Móz Designs, Inc., 711 Kevin Court, Oakland, CA 94621  
Tel: 510.632.0853 • Fax: 510.632.0852 • www.mozdesgins.com

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### GENERAL WARRANTY

Due to the production process, no two sheets are exactly alike. Some surface irregularities as well as color and pattern variations will appear. We recommend that you inspect the material before cutting or mounting by simply lifting up the edge of the protective mask and laying it back down. If any material proves to be defective, Móz Designs will be liable for the cost of that material only. In order to prove material defective a sample must be provided to Móz Designs for review. No other warranty is expressed or implied.

### DESIGN CONSIDERATIONS / APPLICATIONS

Móz Metals are available in a variety of special finishes to allow these metals to be used both indoor/outdoor as well as in low to high traffic areas. Take a look at the section on Special Finishes as well as the Special Finishes guide to learn more about recommended applications for each finish. Please request a sample or contact Móz Designs regarding any uncertainty regarding the use of our products in application.

**MATERIALS** Móz Metals are most commonly produced from solid core aluminum, which is an easy and lightweight product to work with. Refer to the section on LEED to see how the use of Aluminum can contribute to LEED credits for your project. Móz Metals can also be produced on Stainless Steel to offer more structural integrity and substance. Colors can vary on stainless steel and when paired with our DuraFilm or Tuff Coat special finishes will offer maximum durability.

**PATTERNS** Móz Metals are available in both directional and non-directional patterns. All directional patterns run parallel to the length of the sheet. For an additional fee you may also specify one of our directional patterns to be done in *Crossgrain* so the pattern runs parallel to the short side of the sheet. Móz patterns are expertly handcrafted. Therefore, no two sheets are alike which makes exact book matching difficult especially on directional patterns. Most non-directional patterns, and some directional patterns, will seam easily with minimal visual disturbance. Adding the use of reveals or seams can help diminish the visibility of the patterns at joints.

**COLORS** Proper lighting elements can add a compliment to any Móz Decorative Metal pattern/color. Darker colors should be given proper lighting to avoid the loss of pattern/color visibility. Tuff Coat finish can also change appearance of color due to it's matte texture. Colors vary from lot to lot so it is always best to obtain an actual sample of a finish before specifying, and providing a submittal sample to the factory as a control if a variance could become an issue.

### SPECIAL FINISHES & DURABILITY

Móz Metals are available in a variety of special finishes to suit your projects needs. See Special Finishes Guide to compare the various finishes available to see which one suits your needs. Please contact Móz Designs regarding any uncertainty regarding the use of our products in application. See Special Finishes Guide.

### FIRE RATINGS

Móz Metals **DO NOT** require Fire Rating certification due to the fact that we utilize solid core aluminum which is a non-combustible material. Please contact Moz Designs if further documentation is necessary.

### LEED CONTRIBUTION

Móz Metals are created from 80% post-industrial Recycled Aluminum which contributes to LEED 2.0 MR Credit 4 - Recycled Content.

*"Aluminum is recycled extensively from both post-consumer and post-industrial sources and provides the most valuable component for most municipal recycling efforts. A survey in late 2003 indicated that the recycled content of domestically produced, flat rolled products for the Building and Construction market was approximately 80 - 85%\*. In addition, at the end of their long, useful life, aluminum roofing and siding panels can be repeatedly recycled back into similar products with no loss of quality." -Aluminum Association Technical Information Service*

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\* This number refers to a total recycled content, including both post consumer and manufacturing scrap.



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### SAMPLING PROCESS

Móz Metal samples are readily available in 5"x7" size for all standard pattern/color combinations in our standard finish. Perforated, Corrugated, Stainless & Special Finish samples have limited availability in a random pattern/color combination. Samples can be easily requested through our website at [www.mozdesgins.com](http://www.mozdesgins.com) Boxed Sample sets can be purchased for \$50 for your library. The box includes: a 5"x7" sample of each pattern, a 2"x3" sample of each color, a sample of each Special Finish, and a sample of each standard perforated material available in Moz Finishes.

### ORDERING PROCESS

All Móz Metal sheets are made to order. Typical production lead-time is 2-4 weeks (plus transit) at a minimum, pending current production workload at time of order. Best to call for current production lead times. Rush orders will be considered at the time of purchase. There is a 2 sheet per color order minimum for all standard options. Custom orders must meet a minimum of 5 sheets. Exterior and/or Corrugated orders must meet a minimum of 10 sheets. All orders must be approved in writing prior to production. See also section on crating/shipping.

### STORAGE & HANDLING

Stacking or adding significant weight to the material is not recommended as it may create impressions in the finish. Móz Metals should never be stored in high moisture areas, even when crated. Special care should be given in hot and humid marine and tropical environments as prolonged humidity could cause problems with the adhesive from the protective masking. Storage temperature should not exceed 85°F or go below 50°F for long periods of time. Optimal storage conditions are room temperature (70°F to 75°F) and 50-60% relative humidity. Do not expose the materials to sun-light or heat for long periods of time, which may cause difficulty in removing the protective mask.

To prevent edge damage, dings, and scratches, material should be handled by two people and transported face up. Móz Metals have a painted finish, which can be scratched/marred with heavy contact such as metal on metal. Although durable, the finish must be treated with care; much like a high-grade automobile finish.

### PROTECTIVE MASK

All material (excluding the DuraFilm, Tuff Coat, and Corrugated products) come with a protective peel coat mask to offer added protection during transportation, machining, and installation. Masking may be clear or transparent. Care should be taken while handling the product even with the protective masking. Do not use markers on protective masking; some types of inks will permeate the film and mark the material surface.

It is recommended to leave the protective mask on the product during machining/installation. However, quality checks should be carried out on the sheets beforehand by simply lifting up the edge of the protective mask and laying it back down. Any premature, partial, or total removal of the protective masking will expose the metal to possible damage through unfinished manufacturing or through installation in unfinished building sites.

During transit the protective mask may shrink due to moisture and cause wrinkle impressions on finished product. These are just packaging impressions that should disappear after removal of mask once material has time to breath. If impressions do not fade away a heat gun may be used to lightly melt away any wrinkle impressions. See also section on Storage & Handling.

### CLEANING & MAINTENANCE

Clean with a soft cloth using mild soap and water. Do not use abrasive or ammonia-based cleaners. For heavy cleaning and removal of grease, use oil based mineral spirits or naphtha. Mild household cleaners that do not contain ammonia may also be used. Do not treat with rubbing compounds or lacquer thinner as this may dissolve or etch any clear coatings. Minor scuffs can be polished out by hand with a #6 or #9 type finishing polish or wax. Ammonia based cleaning agents can be used on DuraFilm & Tuff Coat products only.

### CRATING & SHIPPING

All materials are shipped flat in a wood pallet for optimal protection during transit. Due to pallet size, all material must be shipped by air or ground freight. Materials cannot be rolled into a tube for common carrier express shipping such as FedEx



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or UPS. All shipments will be dispatched by Móz preferred carriers and sent FOB Destination. Upon receipt of goods, client must visually inspect packaging for any visual damage and note any such damage on delivery receipt. Failure to do so may result in an inability to file a shipping claim and any replacement material will be at the purchasing party's expense.

NOTE: If you choose to use your own carrier, you are responsible for providing all necessary items such as Bill of Lading, scheduling of pick up, and insurance during transit. Móz Designs is not liable for damages to shipments during transit that are not paid for and secured by Móz Designs.

### LAMINATION / ADHESIVES

Móz Metals can be applied using most contact adhesives, cements, panel adhesives, or in some cases double-sided adhesive tapes depending on the substrate and actual application. Always check with your adhesive supplier to make sure the adhesive you select is suitable for your application. In all cases, the adhesive manufacturer's instructions should be followed as to the use of the adhesive and substrate preparation.

It is helpful to prep Móz Metals prior to lamination by scuffing the backside with 80grit sandpaper.

Proper substrates must be used and careful bonding procedures must be observed. Substrates should be of good quality plywood, high-density particleboard or high quality fiberboard. The more resistant the substrate is to dimensional change (shrinkage and/or expansion from changes in humidity and temperature) the better the long-term results will be. To prevent warping, in environments where temperatures may fluctuate drastically or high humidity is present, it is recommended to apply an equal strength material to the back of your substrate to seal off access to moisture.

Use only oil-based naphtha, or mineral spirits for adhesive cleanup. Do not use ammonia, abrasive cleaners/pads, or harsh solvents like lacquer thinner. It is recommended that you test your adhesive system and/or cleaning agents with a sample piece of metal.

We recommend the use of a mechanical fastening system when using Móz Perforated or Corrugated metal products.

### CUTTING

All blades must be clean, sharp, and properly maintained. Dull cutters create excessive chipping and burring and reduce the quality of cut. Sand down cut edges with 220 grit sand paper. Files may also be used to debur sharp edges. Always file down on the decorative surface. Before cutting material it is always best to test cut first to confirm results.

ROUTING Sharp multi-fluted carbide cutters are necessary when cutting aluminum; the larger the diameter of the cutter the better the results. The speeds recommended are the same as those used in standard woodworking practices. It is important to use a router having adequate horsepower to maintain cutting speeds. It is also important that the cutter travel direction is against the cutter rotation. Always cut decorative side up (into the decorative face). When routing, the less material removed the better. It is also important that the face of the material be protected from the base plate of the router. For edge trimming, high-speed trimmers should be used (approximately 22,000 RPM) and will produce smooth burr-free edges. When using a CNC router to cut aluminum it is best to use the mister add-on to spray vegetable oil on the router bit to aide in cutting. Refer to your CNC manual for optimal settings when cutting aluminum.

SAWING (table & panel saw) Always use sharp carbide tip blades with 80 to 100\* teeth. Blade should be 8" to 12" in diameter, and at 0 degree rake for best results. It is always best to cut into the decorative face with the blade to minimize burring and edge distortion. Do not force material through saw. A constant feed rate will produce smoother cuts. Blade wax will promote better cuts.

SHEARING Blades must be clean, sharp and properly maintained. Due to pressure, one side will always chip. To avoid chipping take special attention to placement of decorative metal face as follows: for chip free cut to material on operator side feed thru decorative face down. for chip free cut to material on drop side feed thru decorative face up. Shears used to cut stainless may be dull and unreliable for precision cutting. Always sample cut first.

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\* Use 100-tooth blade when cutting metal without a backer board



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LASER & WATERJET CUTTING Laser Jet is **never recommended** on painted aluminum, as it will leave burn marks along edge of metal. Water Jet may be more successful using a fine cut for architectural finishes. CNC routers are typically preferred. It is recommended to sample test first.

### OTHER MACHINING (BENDING/FORMING/WELDING)

Móz Metals are **not post-formable** beyond their natural tolerance. It is not recommended to form/curve Móz metals beyond a 2' radius as surface cracking or de-lamination may occur. All bending/forming, beyond this tolerance, must be done by the factory prior to the application of Móz colors and patterns. Welding is **never recommended** under any circumstances, as it will destroy/discolor the decorative finish in the welded area.

### GENERAL

The user of Móz Metal products must ultimately determine the suitability of products for any particular purpose and use, including the establishment of their own procedures for fabrication and installation of these products. The information supplied is a general guideline and a supplement to tool manufacturers' recommendations as to proper use and capabilities of their equipment. This information is believed to be reliable but no warranty is expressed or implied

### WARRANTY DISCLAIMER, LIABILITY

The information in this Technical Information Sheet and all related documents released by Móz Designs is believed to be reliable; but Móz Designs disclaims the creation of any expressed or implied warranty including the warranties of merchantability and fitness for a particular purpose with respect to Móz Designs products. In all cases, users must determine the suitability of such products for any particular use and shall assume all risk and liability whatsoever in connection herewith.

Since we exercise no control in handling, storage, application and use of these products or the products of others with which they are used in combination, no warranty, express or implied, is made as to the results and effect of their use. User must also establish his or her own procedures and verify the finish of any product to be as ordered before use. We recommend testing all procedures before beginning production or installation. Buyer's exclusive remedy for a loss or claim resulting from the use of Móz Decorative Metal products shall be replacement of product proven to be defective. In no event shall the Seller be liable for any special, incidental, consequential or exemplary damages.

### IMPORTANT:

This information is intended to be a general guideline. For further information please contact:

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