



Móz Designs, Inc.

IMPORTANT

HANDLER INSTRUCTIONS FOR WORKING WITH MOZ METALS

	Aluminum			Stainless		
	Polycoat	DuraFilm	TuffCoat	None (raw)	DuraFilm	TuffCoat
Protective Masking (PVC film) applied to aide during cutting	Y	N	Y	Y	N	Y
Do not use markers on protective masking; some types of inks will permeate the film. Packaging impressions from PVC film should disappear after removal of mask once material has time to breath. If impressions do not fade away a commercial grade heat gun may be used to lightly heat away any impressions.						
STORAGE & HANDLING						
<i>Protect and store metals face-to-face and back-to-back in a cool, dry area. If stacking, do not place cardboard or spacers between sheets and do not stock mixed size panels as it will leave an impression on the finish. NEVER stack more than 500Lbs of weight on painted metals as it will create deep impressions extremely difficult to remove. EXTRA CARE should be taken when handling to avoid kinking the metal or dragging metal corners on adjacent sheets. Moz Polycoat finish is polyurethane based and will scratch from metal on metal contact. Treat with care – much like a high-grade automobile finish.</i>						
CUTTING						
<i>All blades must be clean, sharp, and properly maintained. 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. DuraFilm and TuffCoat sheets require special care to ensure all edges are sanded down after cutting to avoid delamination.</i>						
• ROUTERS	Y	Y	Y	N	N	N
Must be clear/sharp multi-fluted carbide bits. Always cut decorative side up (into the decorative face). When using a CNC router to cut aluminum we recommend using Onsrud "O" Flute (1/4" diameter) upcut carbide bits, (series 63-000). Use 18,000 RPM spindle speed and approximately 55-75 IPM (inches Per minute) feed rate. Make sure finished part is cut along the "climb" side of the tool path.						
• TABLE/PANEL SAW	Y	Y	Y	N	N	N
Always use sharp carbide tip blades with 80 to 100 teeth 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.						
• SHEARING	Y	Y	Y	Y	Y	Y
Blades must be clean, sharp and properly maintained. One side will always chip due to pressure. Always sample cut first. ->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.						
• LASER JET CUTTING	N	N	N	Y	N	N
Laser Jet is never recommended on painted metal, as it will leave burn marks along edge of metal. Cut at your own risk.						
• WATER JET CUTTING	N	N	N	Y	N	N
Water Jet may be more successful using a fine cut for architectural finishes. Cut at your own risk.						
OTHER MACHINING						
• Post-FORMING is never recommended on painted metals.	N	N	N	Y	N	N
• SLIGHT CURVING (not tighter than a 2' radius)	Y	Y	Y	Y	Y	Y
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.						
CLEANING & MAINTENANCE						
<i>Only use a soft cloth for cleaning; never use abrasives.</i>						
• Mild soap & water	Y	Y	Y	Y	Y	Y
• Oil based mineral spirits or naphtha for adhesive cleanup	Y	Y	Y	Y	Y	Y
• Lacquer Thinner for adhesive cleanup	N	N	Y	Y	N	Y
• Ammonia based cleaning agents	Y	Y	Y	Y	Y	Y
• Abrasive Cleaning agents	N	N	N	N	N	N
• #6 or #9 type finishing polish or wax. For minor scuffs (hand buffed)	Y	N	N	N	N	N
• Touch Up Pens available - Classic Colors only (contact us)	Y	N	N	N	N	N
LAMINATION / ADHESIVES						
<i>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. We recommend the use of a mechanical fastening system when using Móz Perforated or Corrugated metals. Be sure to carefully follow proper storage & handling suggestions noted above in regards to STACKING.</i>						
For further assistance call or visit mozdesigns.com/specs_library for additional technical information						