



1. Technical Overview

Property		Value
Physical		3mm
Steel skin thickness	mm	0.25
Weight	kg/m²	6.35
Face finish	-	Digital or whiteboard coatings
Core composition	-	100% Recycled 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

2. Cutting

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

3. Remarks

This kind of coated product should not be wiped with MEK(butanone) or similar abrasive solvents, which will damage the coating layer.

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