

DATA SHEET



Product Name : Kingdom Dyed Veneers



Material Bonafides

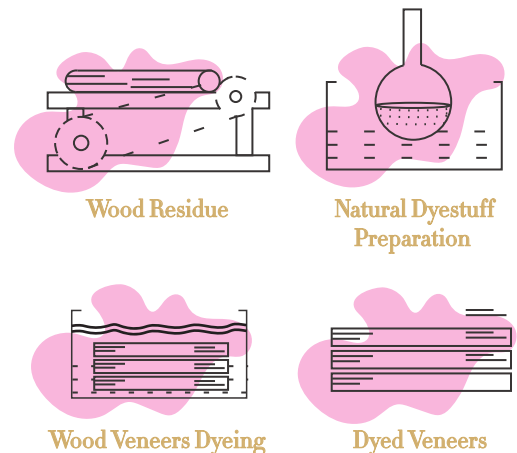
Real Natural Wood Veneer dyed throughout the thickness.



Dyeing Process

The dyeing process is done by immersion, so the color penetrates throughout the thickness and is not eliminated when sanding. The dye bath containing veneer is put into closed pressurized chambers until the wood absorbs the amount of color that is desired. When the color is absorbed, the pressure is released and the veneer is removed. The veneer is then washed with water until there is no bleeding and then dried with our continuous press drying process, resulting in highest shine on surface & lowest tolerance on flatness.

Though Immersive method results in consistent color not only on surface but also in the veins and complete thickness of the Veneer but being natural product it is not possible to have natural logs in same color tones. A certain color variation between different logs and hence different batches must be accepted.



Recommended use

The best application for the material is glued or press-bonded to substrate of your choice like MDF, Plywood, Chipboard, Fleece-back, etc. which results wood finish appearance

Using Acrylic based wood polish to apply on Dyed Veneer surface is a must. And we recommend ICA[®] and SIRCA[®] special UV resistant wood polish specially made for Dyed Veneers. Please refer Dyed Wood Veneer Protection Cycle Polishing manual (Annexure I) for the same.



Opus

Wood veneer is produced from hardwood and softwood veneer grade logs by peeling and slicing thin layers. Kingdom's dyed veneer products are dyed in water, according to the international standards.

The product's fibers are cleaned through chemical treatment process and then colour is applied which are internationally approved acid dyes resulting lowest environmental impact.



Hazardous Observations



When the wood veneer is shipped by the manufacturer, regardless of Natural / Dyed form, it is not classified as hazardous.



However, wood veneer material is inclined to chipping hence use of gloves is recommended while handling. Furthermore, downstream activities like sawing, drilling, sanding leads to creating small particles as chips or wood dust that can cause irritation to nose and throat. Hence use of dust filter mask is recommended while doing so.



The dyestuf used in our production are composed by of water-soluble powders and are not dangerous or hazardous for human health or environment. They do not cause any illness or disease merely by handling it or post application use also, with approved wood finishes.



They do not hold any cancer stimulating substance.



They do not contain any chrome, lead, mercury, cadmium or arsenium.



All the chemicals used comply with the international compliance to the health and safety norms. The chemicals are free from 11 priority group identified by ZDHC (Zero Discharge of Hazardous Chemicals) and comply with ZDHC level 3.1 standard.

Storage and Handling



Veneer must be stored in an appropriate way. Warehouses with cool, dry and well ventilated areas, having controlled humidity levels ranging within 40% – 60%, are recommended. Use of Black color non transparent film at all times covering the wood veneer from all sides is highly recommended.



Surrounding temperature should stay in the range of 14-24 degree Celsius.



Direct contact with water and exposure to sunlight & bad weather must be avoided. Failing to which leads to color variations on the veneer itself. Keep veneer stock away from sources of heat, flames, sparks or incompatible materials.



General hygiene should be followed as not smoking in the work areas. Not to eat, drink or store food in work areas.



Need to wash hands thoroughly after handling this product and before eating.



No particular handling procedure is required but use of gloves while handling is advisable.



The material to be shipped is packed according to standards. Packing procedures and techniques are to be applied taking into consideration a general optimization and safety of the goods. Use of Black color non transparent film at all times covering the wood veneer from all sides is highly recommended.



Health and Safety



Toxicity of wood veneer product pertains to the wood dust formed by machining of the raw product. Hence to minimize or to avoid overproduction of wood dust, use exhaust transport device for removing dust at the source and use dust bags for all power tools that may produce dust.



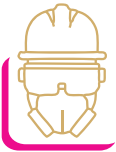
Protecting airways and mucous membranes from the sanding dust is must.



Work areas should be cleaned daily at least once and wood dust should be removed by vacuum cleaning or wet sweeping method.



Wear comfortable clothing covering full body and wear gloves.
Do not scratch or rub the skin if it becomes irritated.



In case of dusty conditions, especially if exposure to wood dust is not controlled during the polishing of the veneer, then it's advisable to get the dust filter mask.
While operating machining tools wear tight fitting glass to protect eyes from hovering chip fiber cuts.



First Aid Measures

In unlikely and unfortunate events such as:-

- + In case of inhalation of wood dust, get some fresh air for comfortable breathing and if respiratory symptoms persists then get medical advice.
- + In case of contact with optical mucous, wash contaminated eye with warm water for two minutes keeping eyelids open. If eye irritation persists then get medical advice.
- + In case if skin irritation or rashes occur after wood dust contact then wash thoroughly with warm water and mild soap for two minutes. In case of persistent rash or irritation get medical advice.



Fire Precautions

Wood is inflammable, but not spontaneously.

Wood and wood dust are not explosive, however incineration is possible in presence of free flame or temperature higher than 100 degree Celsius. Dry wood dust in high concentrations can be explosive. Burning or smoking veneer generates carbon dioxides and other pyrolysis products, typical of burning organic material.



In case of fire, evacuate the area. Use water spray, prevent dust formation and minimize the risk of explosion. Fight fire from safe distance or a protected location from upwind to avoid hazardous vapours or gases.



pH

pH between 5.5 and 7.5 (on delivery)



Moisture Content

The moisture content should be close to that of the substrate to which it is to be applied. Generally its 10-12%. Wood has tendency to swell due to its water properties, therefore the humidity factor must be closely monitored in order to avoid splitting, buckling or wrinkling of the veneers at the moment of gluing.



Concerning facts & Measures

In people's mind, major hindrance in using wood veneers, is concerns over yellowness / fading color tone over the period. But, just like all other materials, all wood veneers (irrespective of Natural, Dyed and Reconstituted) also will slightly alter in color due to exposure to Ultraviolet (UV) light, or fading, or ageing of the wood.

To limit this concern, strict avoidance of direct sunlight on veneer is must. Secondly, use of only ICA[®] and SIRCA[®] made non-yellowing finishes / coating containing UV inhibitors (especially made for Dyed Veneers) are highly recommended to resist such waning. For better understanding, kindly refer our advisory finishing manual on dyed veneer polishing.



Stability and Reactivity

Not reactive under normal condition of use.

Chemical stability is not a concern under normal conditions of use and storage.

Wood dust is incompatible with oxidizing materials.



Ecological

No known environmental effects or hazards for living organisms. It does not cause pollution or long terms adverse effects on the environment. The wood and the wood dust are biodegradable.



Disposable Consideration

Wood veneers are not normally treated with preservatives hence therefore there are Eco toxicity issues related to waste handling, or special precautions for landfill and incineration.- Dry land disposal or incineration is acceptable in most areas. You can contact local environmental authorities for approved disposal method in your jurisdiction.

DYED WOOD VENEER POLISHING MANUAL & SAFEGUARD CYCLE (Annexure - I)

We recommend ICA products for Dyed Wood Veneer polishing as they are specially made for dyed wood veneer surface protection, at best possible level. Defined application cycle of ICA, highly efforts to resist waning of color over the period.

ICA recommended Application Cycle for Dyed Veneer as below:-

■ Use following ICA products:

- | | |
|------------------------------|---|
| ★ Protect Pro (UV Additive) | ★ D1015 (Thinner) |
| ★ FAC300UVE (Acrylic Sealer) | ★ OAC301G5UVE (Top Coat with Level 5 – for Matt look) |
| ★ C200 (Hardener) | ★ OAC301G20UVE (Top Coat with Level 20 – for Glossy look) |

■ Apply Protect Pro by spraying or brushing method with area coverage ratio of 40-60gm/m² And leave it for drying for 15 minutes.

■ Application of Acrylic Sealer of 2 Coats as per below mentioned ratio :

- ★ FAC300UVE + C200 + D1015 (100 : 10 : 50) respectively
- ★ Quantity: 130 gm/m²
- ★ Drying Time: Touch Dry 23°C 50% RH – 0.6
- ★ Interval between Coats – 1-3 Hrs

■ Use Sanding with P320 – P400 grits and for open pore veneer use Scotch-Brite

■ Apply Acrylic Top Coat in Matt or Gloss level as per your choice, in below mentioned ratio

- ★ OAC301G5UVE OR OAC301G20UVE + C200 + D1015 as (100:10:50) respectively
- ★ Quantity – 120-150 gm/m²
- ★ Drying Time – 4-8 Hrs



Factory :

Kingdom Decorative Surfaces (India)
C/o Hosur Paper Mills
Sy. No.211 & 212, Sanamavu Village,
Rayakotta Road, Hosur. Post Box- 635119
Tamil Nadu-India

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