

# **INSTRUCTION MANUAL**

## **CHOCOLATE FACTORY, BLACK ROCK AND WHITE NOISE**



In this document you will find all necessary information for working with Chocolate Factory, Black Rock and White Noise as well as bespoke materials made of polycarbonate or polystyrene. If you have any questions, remarks, changes, imperfections or suggestions please send an email to [info@plasticiet.com](mailto:info@plasticiet.com) so that we can improve the Instruction Manual. Plasticiet is not responsible for any incidents occurring when handling our materials.

Good luck, have fun!

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### **CUTTING AND MILLING**

***Safety precaution: Please wear eye protection, plastic shavings may be hot or sharp.***

All of our material has some oversize and comes straight from the mould. To make sure the material is square, start by cutting two sides as reference points.

When cutting or milling we cannot press it enough that you use sharp tools, low rotary speeds and a fast movement speed. These materials are prone to friction which might cause the material to melt if not handled properly.

A wood blade, aluminium blade and plastic blade all work well on these materials as well as mill bits for wood, aluminium and plastic.

If you cannot adjust the rotary speed of your tools or if you don't have access to sharp tools we advise you to cut the material twice to get the cleanest result.

Measure carefully and make your setup ready properly before sawing the material. Cut it in a quick, fluent and controlled motion.

When milling, it is advisory to not go all the way through the material in one go but to mill it in steps. It is important to fix the material to your working table with clamps, screws or any other method you are comfortable with. You don't want the material to move during milling as a mill bit getting caught in your project may be disastrous for the result. Prepare your milling setup properly, measure carefully and mill in a quick, fluent and controlled motion.

All of the above is also applicable when performing mitre cuts.

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### **GLUING**

**Safety precaution: Please wear gloves, eye protection and a respirator or work in a ventilated room as the solvent glue may be irritating to your skin, eyes and lungs.**

Check out the Plasticiet shop for solvent glue, or add it to your order via email.

All surfaces to be glued should be free of grease, particles and dust. We advise to use waxed paper or PE floor protector to put underneath your project, to refrain it from sticking to your work table. The to be glued surfaces should not be roughened up prior to gluing. If you use a brush to apply the glue, check if the brush fibres are natural, not synthetic.

### **End gluing**

Make sure the two surfaces facing one another are dead straight and your worktop is flat. Remove any dust or particles underneath your project. The underside of the material where the seam will be can be covered with paper tape to improve your result. Make sure you have some weights and clamps ready to put onto the surface so that it will stay in place.

Apply the glue either straight from the bottle or with a brush onto both sides of your surfaces. The surfaces should look wet. Don't leave it to dry out. Press one side firmly to the other and apply weights or clamps. Optionally apply some glue on top of the seam. The material should dry at least one full day before working with it and acquires its full bonding strength after ??? days.

### **Mitre gluing**

Make sure the surfaces facing one another are dead straight and your work top is flat. Make sure you have some clamps ready or a jig prepared.

Connect the pieces together using paper tape where the mitre joint will be. Make sure the tape is properly sticking to the material. Remove dust prior to taping to improve its adhesion. Check if the joint is properly connecting prior to gluing.

Apply the glue either straight from the bottle or with a brush onto both sides of your surfaces. The surfaces should look wet. Don't leave it to dry out. Fold your joint together and assemble it with your clamps or jig. Optionally apply some glue in the inside of the joint. The material should dry at least one full day before working with it and acquires its full bonding strength after ??? days.

### **Laminating**

When laminating it is of utmost importance to clean your material to remove any dust or grease. You will also require a press, many clamps or a roller to which you can apply weight. Make sure that the surfaces you are laminated cannot slide out of position after gluing.

Lay out all the pieces you are going to laminate so that they are easily accessible. Generously apply solvent glue to both sides of the surface. Your material should look wet, and make sure it does not dry out. Apply the two wet surfaces to each other, and then apply pressure with a press, many clamps or a roller. If you are going to laminate multiple layers then either wait 4 hours or laminate all your surfaces and clamp when finished. The material should dry at least one full day before working with it and acquires its full bonding strength after ??? days.

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### **HEAT BENDING**

***Safety precaution: Please wear heat resistant gloves to refrain from burning yourself and preferably a respirator or work in a ventilated room to protect your lungs.***

Heat bending applies to Black Rock and White Noise only.

You can use an oven, infrared panel or heat gun to heat up your material. Prepare your work by cutting it in oversize, the edges of your material might curl up slightly, so these should ideally be removed after bending but can also be sanded flat. When using a bending mould, it is best to pre-heat that as well. The maximum advised bending radius is 5cm.

An oven should not be heated to more than 120`C or 248`F. Heat blowers should preferably be set rather lower than high as the heat needs to penetrate throughout the thickness of your material whilst not melting it. Heat up your part until it collapses under its own weight, at that point it is ready to bend. Bend it into the preferred curve and secure it with straps, tape, clamps or any solution you work with comfortably. When it is cooled down, the material bends back minimally but take into account that it might bend back slightly.

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### **SANDING AND POLISHING**

**Safety precaution: Use a vacuum cleaner or wear a respirator as breathing dust is harmful to your lungs.**

Chocolate Factory, Black Rock and White Noise are standardly finished with 240 grid sanding paper.

#### **Sanding**

Preferably with a random orbital sander, slowly and evenly move over the surface of your material, covering the entire surface. Always keep your sanding machine in motion. Sanding can best be done by someone with experience.

At Plasticiet we move our sanding machines roughly at 10cm per second. Especially Black Rock and White Noise are prone to melting due to friction, so adjust the speed of your sanding machine accordingly. When sanding for a polished finish, work your way up to ??? grid.

#### **Polishing**

After sanding your project to ??? grid, clean the surface your are going to polish thoroughly. There should be no dust at all on your surface. Use a liquid polishing agent and move your machine in a fluent motion. Again, especially Black Rock and White Noise are prone to melting due to friction. Use plenty of polishing liquid and some water and adjust your movement speed or speed of your polishing machine accordingly.

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### **MAINTENANCE**

**Safety precaution: Treat your material with care so that it will last a long time.**

#### **General info**

Chocolate Factory, Black Rock and White Noise are all relatively scratch resistant from regular use. Refrain however from scratching the surface with hard or sharp materials such as keys, knives or rocks. Rocks will beat Black Rock as well as the others indefinitely.

#### **Daily use**

We advise you to not directly place any hot items such as pans, a percolator or candles onto these materials as well as items with a sharp or uneven bottom. Always use a coaster for these kinds of objects. Use a cutting board when performing hand labour or when preparing food on your Plasticiet surface.

#### **Cleaning**

Cleaning can best be done with a soft sponge, microfibre cloth or a cotton rag. Use the soft side of a sponge, not the abrasive green side. Apply some water and soap to your surface and wipe it off, then dry it with a cotton cloth.

Chemicals such as acetone and ethanol should be avoided by any means. Also avoid any aggressive cleaning agents and cleaning agents containing citrus or other acids. Check the label to be sure your cleaning product does not contain any of the aforementioned.

#### **Care and repair**

If your material starts to wear and you would like to fully rejuvenate it once again, follow the steps provided in the Sanding tab.

Small scratches can be sanded out using a 240 grid sanding paper and light pressure by hand. For the best result, use a random orbital sander and 180 grid sanding paper. Always keep your sanding machine in motion. Sanding can best be done by someone with experience. Deep scratches can be repaired with a filler which matches the colour palette of your product. Sand it when it's hardened out.

#### **End of life**

Should the day come that you do not want to keep your Plasticiet product anymore then please try to find a new owner by gifting or selling it. If you cannot find a new owner you can either return it to us or dispose of it following your local plastic recycling principles. Please inform us, before returning anything to us.

Good luck and enjoy your product!