



TECHNICAL INFORMATION AND TREATMENT RECOMMENDATION FOR WASA UNIPLAST®

→ Adjustment to the block machine:

After changing from any other type of boards to **WASA UNIPLAST®** vibration settings will need to be adjusted and optimised. This ensures that you can use the better vibration transmission properties of **WASA UNIPLAST®** boards.

→ Supporting bar for small moulds:

The mould width should be appropriate to the vibrating table. For small moulds, supporting bars should be added to the moulds to ensure that the unsupported ends of the board cannot vibrate excessively. This avoids any possible high amplitudes of vibration and possible resonance which may cause damage.

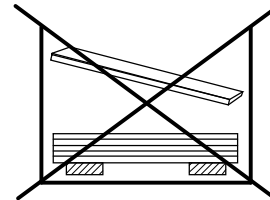
Ensure that the static bars and vibrating table bars are flat and evenly set to the block machine manufacturer's specifications and smooth so that the board rest completely on the bars.

The vibrating motors must set to the right rotating direction.

Machines using a split vibrating table the motors should be set to compulsive or synchronized action. Vibration power – speed and amplitude – should be set to suit the mould and product weight.

→ Board magazine (if available):

The boards must not drop down more than 200 mm into the board magazine of the block machine. A deeper drop down may damage the boards.



→ Cleaning:

It is essential that a rotating steel brush be used and maintained in correct adjustment. We recommend: 0,4–mm-rippled-wire (uniformly bristled), sweep diameter 200 mm rotating at approx. 106 rpm or 250 mm rotating at approx. 85 rpm. A system using self adjusting downward pressure would be an advantage.

→ Spraying:

Under normal circumstances spraying with mould oil is not necessary. If treatment is required please heed the supplier's recommendations. (Mineral oil is NOT permitted)

→ Storage:

Do **not** store **WASA UNIPLAST®** boards in the sun. DANGER OF WARPING!

Weight:

Please note the higher weight of **WASA UNIPLAST®** boards compared with softwood and plywood.

General remarks:

The use of hydrophobic release agents or similar agents may cause the wood cell structure to close. This causes the wood to dry out and crack. When using such release agents, a material build-up will become noticeable on any kind of boards (whether wood, plastic or steel) will be monitored. This buildup can only be removed with great effort. The use of special cleaning devices can become necessary (steel brush, scraper, cleaning roll). If the boards are not cleaned well, this will cause damage on the board surface and the moulds as well.