



Móz Designs, Inc.

IMPORTANT

HANDLER INSTRUCTIONS FOR WORKING WITH MOZ METALS

	Aluminum				Stainless		
	Standard	Polycoat	Durafilm	TuffCoat	None (raw)	Durafilm	TuffCoat
Protective Masking (PVC film) applied to aide during cutting	Y	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 heat gun may be used to lightly melt away any wrinkle impressions.							
STORAGE & HANDLING							
<i>Metals should be protected and stored face up in a cool, dry area in a completely supported flat position. Edge storage is not recommended. Extra card should be taken when handling. TREAT WITH CARE. Moz Metal Finishes have lacquer based finished topcoats and are susceptible to scratching and marring with heavy contact. Although durable, the finish must be treated 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.</i>							
• ROUTERS	Y	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 it is best to use the mister add-on to spray vegetable oil on the router bit to aide in cutting.							
• TABLE/PANEL SAW	Y	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	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	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	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.							
• SLIGHT CURVING (not tighter than a 2' radius)							
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	Y
• Oil based mineral spirits or naphtha for adhesive cleanup	Y	Y	Y	Y	Y	Y	Y
• Lacquer Thinner for adhesive cleanup	N	N	N	Y	Y	N	Y
• Ammonia based cleaning agents	N	Y	Y	Y	Y	Y	Y
• Abrasive Cleaning agents	N	N	N	N	N	N	N
• #6 or #9 type finishing polish or wax. For minor scuffs (hand buffed)	Y	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.</i>							
For further assistance, please call or download our FIELD WORKABILITY GUIDE from our online Spec Library at www.mozdesigns.com							