

# WORKING WITH KIREI BOARD: Finishing Information

Kirei Board is worked using standard fabricating techniques applicable for wood-based products.

### **Cutting:**

Prefinishing material with a sealer coat can help avoid chipping along saw cuts. For best results use a high-quality saw blade, feeding the material at a uniform speed through the saw. Solidly back panels to prevent chipping along kerf on the saw tooth exit side.

### **Drilling:**

A high-speed drill is recommended. To avoid chipout or breakage on the exit side, back the panel with scrap material.

### **Routing:**

A speed of 20,000 RPM is recommended using double-fluted router bits.

### **Filling:**

Standard wood putty can be used to fill any chips or holes caused by cutting and sanding. Select a color that best matches the color of Kirei Board or your finish color.

### **Fastening:**

All fastening methods may be used, including nail, staples, rivets, screws, bolts, glue or combination. Type A or AB, sheet metal, twin fast types and fully threaded screws designed for use in particle board offer better withdrawal resistance than wood screws. Pre-drilled pilot holes are recommended for the size screw used. If nailing, use spiral or ring shank nails for extra holding power.

(Note: Nailing or screwing into edge grain may result in lower screw holding power due to fewer cross-layers being engaged.)

### **Finishing:**

Kirei Board panels can be filled, sealed, painted, stained or varnished with most commercial finishing materials including short and medium oil length primers, fillers, lacquers, and synthetic base coats and topcoats and high temperature bake and acrylic and epoxy systems. The panels should be at stable room temperature (70 degrees F and higher) when coated. Kirei recommends Low-VOC emission finishes.

### **Edge Treatment:**

The exposed edges of Kirei Board are intended to be finished, unless the type of application does not require a more finished appearance than sanding affords. If shaped exposed edges are required, filling, sanding and painting of the edge will provide a satisfactory finish. Kirei Board can be edge banded with most commercial edge treatments using standard adhesives

# Material Specifications

Kirei Board is a composite panel board manufactured from reclaimed stalks of the sorghum plant, poplar wood bonding layers and KR Bond, an adhesive that emits no formaldehyde. Strong, lightweight and environmentally friendly, Kirei Board has been in use for wall covering, cabinetry, furniture, flooring and other decorative and finished products since 1995.

### Ordering information

Thickness	Dimensions	Sheet Weight
10mm	36"x72"	19.4 lbs.
20mm	36"x72"	35.1 lbs.
30mm	36"x72"	43.2 lbs.

Physical Properties		
Modulus of Rupture	1800mm	900mm
Modulus of Elasticity	1800mm	900mm
Internal Bond	1.5 kg/cm <sup>2</sup>	
Screw Holding Power	Face 25 Kg	Edge 10 Kg
Flame Spreading	3.025 inch/second (UL-HBF)	

Kirei Board is manufactured using KR Bond, a water-based polymer-isocyanate adhesive. Formaldehyde-free KR Bond does not contribute harmful Volatile Organic Compounds (VOCs) to the indoor atmosphere. Testing according to Japanese Government standard JIS A 6922-2003 resulted in 0.0 mg/L formaldehyde emission.