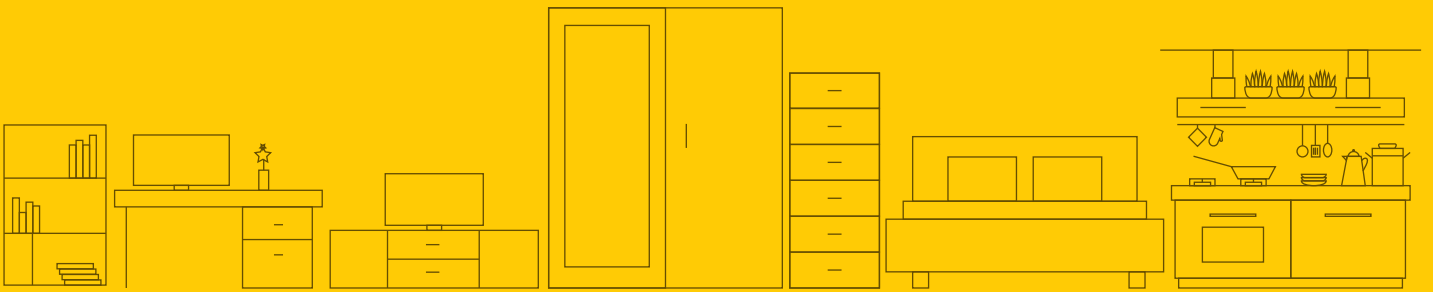



CENTURYMDF[®]
PROWUD

**USER
MANUAL**





Versatile
Greater formability

Smart
Superior technical features

Beautiful
Wide range of shades

DWR
Densified Water Resistant

DIR
Densified Interior Range



CenturyPly was established in 1986 with the vision of providing path-breaking solutions in the panel industry. It took a continuous emphasis on innovation and an intense focus on product quality over the last 3 decades to bring that vision to life. And in that time, as consumer needs diversified, CenturyPly grew its range of offerings too. From plywood to laminates, veneers, flooring and exteriors, and engineered wood products.

Along the way, we pioneered new technologies for the Indian market and set the bar higher and higher on business standards. Our commitment to R&D is reflected in rising investment in this area, resulting in newer and better products. We were the first to develop Borer Proof and Boiling Water Resistant products. As an organisation too, we are structured flexibly to enable innovation.

That's what it takes to come up with products like CenturyMDF Prowud - the wood of the future.

As technology and tastes evolve rapidly, consumers as well as architects and interior designers are constantly seeking new solutions. It is our endeavour to ensure that each of them is able to express their individual creativity, in exactly the way that they desire.

CENTURYMDF PROWUD WOOD

SOLUTIONS FOR THE NEXT GENERATION

CenturyMDF Prowud is a revolutionary product which consists of a wide range of high quality engineered wood substitutes. It meets the evolving demands of modern consumers by being:

Versatile: CenturyMDF Prowud is carefully engineered to make precise routing, machining, and finishing possible. The product provides chipping-free edges, and can easily be carved and moulded. This makes CenturyMDF Prowud highly versatile and suitable for specialized applications requiring unique shapes or intricate designs. When it comes to designing furniture or other interior elements, now the only limit is your imagination.

Smart: CenturyMDF Prowud comes packed with superior technical features which provide strength and durability even under harsh conditions. Each board is constructed with Scalper Technology and quality checked at 128 individual points. This ensures uniform and high density, smoothness and routing grade quality, and resistance to adverse environment and pests. Our products are credited by the Indian Green Building Council.

Beautiful: CenturyMDF Prowud provides both strength and beauty. Ultra smooth surfaces make them perfect for painting, polishing and providing high gloss. The smoothness also makes them the perfect substrate for laminates and veneers. Pre-laminated boards, backed by the wide range of Century Laminates, provide choices in terms of colours and designs which help our customers to express their creativity freely. CenturyMDF Prowud enables interiors, which can be aesthetically tailored to individual choice.

PRODUCT INFORMATION

The boards are available in two grades:

DWR - Densified Water Resistant (IS Grade I): Its densified structure is forged with moisture fighting properties which make them suitable for varied and prolonged application in humid conditions.

DIR - Densified Interior Range (IS Grade II): Super grade range for diverse applications in the interiors.

Both Grade I & Grade II Ranges are available in Plain and Pre-laminated MDF.



APPLICATION AREAS

CenturyMDF is the wood solution when you want to create things differently. Its technical superiority gives you the freedom to redefine your spaces exactly as you wish. Therefore, these boards find a wide range of applications:

Building Construction: Partitions, Ceilings, Door Panels, Moulding, Pelmet, Skirting, etc.

Furniture: Homes, Offices, Hotels, Schools, Hospitals, Colleges, Shopping Malls, Educational Institutions, etc.

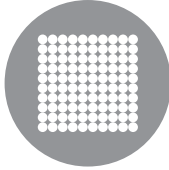
Industrial Applications: Laminate Substrates, Scientific Instruments, Musical Instruments, Stationary Items, Office Equipments, Speaker Boxes, TV Cabinets, Fridges, Sewing Machine Tops, Packaging, Shoe Heels, Toys, Sports Goods, Cut-outs, Photo Lamination, Moulds and Dies, Clocks, Trophies, Interiors of buses and rail coaches, etc.

Handicrafts: Sculptures, Decorative items, Artefacts, etc.

Other Applications: False Ceilings, Modular Kitchens, Short Cycle Press, Exhibition Sets, Aluminum Frame Doors, Packaging and Pallets, Photo Lamination, Photo Frames, Writing Boards and Exam Boards, etc.



PERFORMANCE CHARACTERISTICS



Uniform and High Density: CenturyMDF Prowud boards are very compact with uniform fiber density throughout. Their homogeneous construction makes them suitable for consistent applications.



Made with Scalper Technology: Stringent manufacturing standards and the latest equipment make these boards technically superior. The boards undergo 128 points quality check during the manufacturing, to ensure unmatched product quality.



Super Smooth: CenturyMDF Prowud Boards have super smooth surfaces, making application of paint easier. The smooth surface, free from knots and foreign particles, is a perfect substrate for laminates or veneers.



Hot and Humid Environment Resistant: These boards are very durable with high resistance to adverse environments like heat and humidity. Their high resistance makes them suitable for all locations and applications such as kitchen cabinets, wall paneling on external walls etc



Cost Effective All-rounder: CenturyMDF Prowud is suitable for diverse applications. It is formable, chipping-free, easily moulded, and cost effective, making it a highly sought after product in the interior solutions industry.



Resistance to Borers and Termites: CenturyMDF Prowud Boards are highly resistant to termites and borers, ensuring greater durability.



Environment friendly: CenturyMDF Prowud is an eco friendly product and conforms to E1 Formaldehyde emission level grade of European Standards.

Specifications and Standards

S. No.	Property	Unit	IS 12406 (Plain)		IS 14587 (Pre-laminated)	
			Grade I	Grade II	Grade I	Grade II
1	Density	Kg/m ³	600-900	600-900	--	--
2	Variation from mean density	%	±10	±10	±10	±10
3	Moisture Content	%	5-10	5-10	--	--
4	Variation from Moisture Content (absolute)	%	±3	±3	--	--
5	Thickness Swelling 2 hrs (Maximum)	%	--	--	4	7
6	Water absorption (maximum)	%				
	a. After 2 hr soaking		6	9	6	9
	b. After 24 hr soaking				12	18
	i. Up to and including 6mm thick		30	45		
	ii. 7 to 12mm thick		20	30		
	iii. 13 to 19mm thick		13	20		
iv. 20mm and above thick	12	18				
7	Linear expansion (maximum)	%				
	a. Due to general absorption (in thickness) 24 hrs soaking					
	i. Thickness		4	7		
	ii. Length		0.3	0.4	-	-
	iii. Width		0.3	0.4	-	-
	b. Due to surface absorption (in thickness) 2 hr				-	-
8	Modulus of Rupture	N/mm ²				
	a. Up to 20mm thickness					
	i. Average		28	28	28	28
	ii. Minimum individual		25	25	25	25
	b. Above 20mm thickness					
	i. Average		25	25	25	25
ii. Minimum individual	22	22	22	22		
9	Modulus of Elasticity	N/mm ²				
	a. Up to 20mm thickness					
	i. Average		2800	2800	2800	2800
	ii. Minimum individual		2500	2500	2500	2500
	b. Above 20mm thickness					
	i. Average		2500	2500	2500	2500
ii. Minimum individual	2300	2300	2300	2300		
10	Tensile Strength Perpendicular to Surface	N/mm ²				
	a. Up to 20mm thickness					
	i. Average		0.9	0.8	0.9	0.8
	ii. Minimum individual		0.8	0.7	0.8	0.7
	b. Above 20mm thickness					
	i. Average		0.8	0.7	0.8	0.7
ii. Minimum individual	0.7	0.6	0.7	0.6		
11	Tensile Strength Perpendicular to Surface	N/mm ²				
	a. After cyclic test					
	i. Average		0.45	NA	0.45	NA
	ii. Minimum individual		0.40	NA	0.40	NA
	b. After accelerated water resistance test					
	i. Average		0.30	NA	0.30	NA
ii. Minimum individual	0.25	NA	0.25	NA		
12	Screw withdrawal strength (minimum)	N				
	a. Face		1500	1500	1500	1500
	b. Edge (for thickness >12mm)		1250	1250	1250	1250
13	Abrasion Resistance (Minimum) revolutions	Revolutions				
	i. Type – I		NA	NA	1000	1000
	ii. Type – II		NA	NA	450	450
	iii. Type – III		NA	NA	250	250
	iv. Type - IV		NA	NA	75	75

HOW TO STORE, HANDLE AND USE

CENTURYMDF PROWUD BOARDS

Our MDF is very durable with high resistance to adverse environment. With proper care, this product gives unmatched durability.

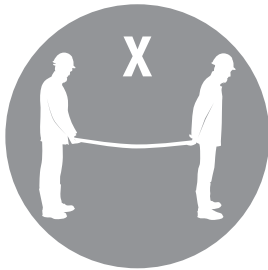
Storage and Handling

The homogeneous construction of CenturyMDF Prowud provides smooth, flat surfaces. Proper storage and handling procedures are required to maintain this inherent flatness.

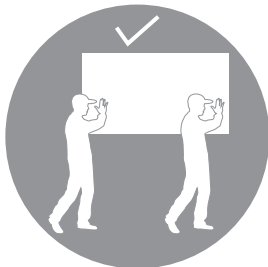
- Storage areas should be dry and well ventilated
- Always store the boards away from open windows and doors.
- Horizontal storing is advisable
- Boards should be stored, lifted clear off ground using dry battens
- Proper alignment and equal spacing of battens are important
- Ideally these boards should be stored flat on a level floor. In case the flooring is uneven, the battens should be accordingly sized to ensure level storage of the boards
- Never slide boards one over the other
- Always provide PVC covering when storing for a long period

Conditioning

Conditioning of boards is desirable for stabilized dimension and better results. Due to variation in climatic condition, a period of 48-72 hours at site, prior to use, is recommended.



Carrying the board horizontally can cause warping.



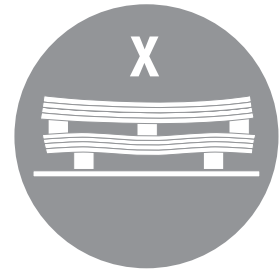
Boards should always be carried edgewise to avoid warping.



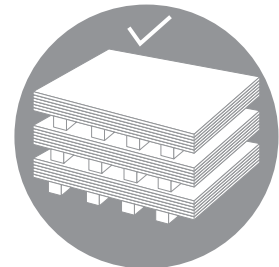
Vertical storage is not recommended.



When stacking vertically, provide support and ensure the gap between boards is uniform.



When storing horizontally, do not place battens arbitrarily.



Minimum 4-5 battens should be provided at maximum spacing of 50 times of the thickness of the boards, but not exceeding 800 mm distance, center to center



WORKING ON CENTURYMDF PROWUD BOARDS

CenturyMDF Prowud is the quick and easy solution to the evolving needs. By observing the following points, working with these boards becomes more efficient.

CUTTING AND SAWING

Saws to be used

Hand Saw: While CenturyMDF Prowud boards can be cut using normal saw, fine-toothed saw is recommended.

Machine Saw: The presence of synthetic resin binder makes CenturyMDF Prowud slightly more abrasive than common natural wood, hence use of TCT (Tungsten Carbide Tip) saws with a minimum of 80-90 teeth is recommended for longer life of cutting tools.

Saw speed can be calculated as:

$$\text{RPM} = \text{Rim speed} \times 60 / \text{Saw diameter} \times 3.14$$

The minimum recommended cutter speed should be 3600 rpm

Working with Machine Saw

To ensure a smooth cut, take the following precautions:

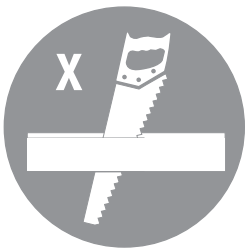
- Keep the blade around 10 mm above the board. Low blade projection can chip or damage the board
- If the board is to be chipped from the underside, lower the blade projection
- Keep the board moving to prevent build-up of heat
- Ensure the board is pressed down firmly against the cutting table to avoid vibration, rough cutting and chipping edges



Use fine-toothed saw.



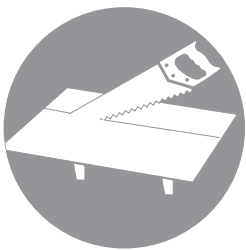
Use carbide tipped TCT machine saws for longer life of cutting tools.



Holding the saw incorrectly during Sawing can chip or damage the board.



Keep low angle for cutting.



Always cut pre-laminated boards along the scoring line.



Scoring line for sawing Pre-Laminated Boards

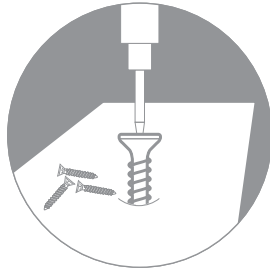
Scoring line should be chiselled before cutting, to avoid chipping while sawing Pre-laminated boards.

Note: Non adherence to the above may result in poorly finished edges due to edge chipping and removal of core fibers.

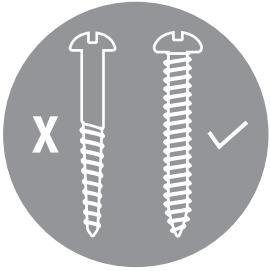




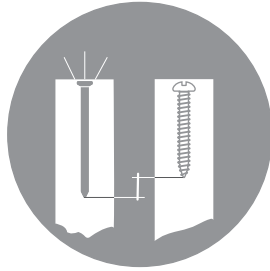
Do not hammer the screws



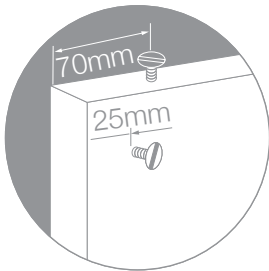
The fully threaded screw should be drilled and screwed into the panel



Use only fully threaded parallel shank steel screws



Drill pilot hole to avoid splitting. Depth of the hole should be 2-3 mm more than the length of the screw.



Minimum distance from corner on surface and edges: 25 mm & 70 mm respectively.



Use plastic sleeve to ensure better grip at the hinges

Screwing

For better result and durability, only screwing is recommended with CenturyMDF Prowud. Follow usage of guidelines maintained here while using screws with CenturyMDF Prowud boards.

Screws

Only fully threaded parallel shank steel screws of proper size should be used (reference may also be made of IS: 7170)

Board thickness in mm	Maximum screw gauge
8 & 9	4
12	6
17 & 18	8
25 and above	10

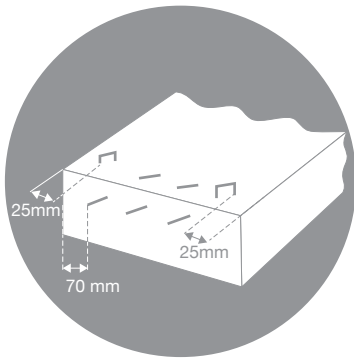
Screw Gauge	Pilot hold diameter
4	2 mm
6	2.5 mm
8	3 mm
10	3.5 mm

Placement and Fixing

Distance of screws from corner on surface and edges should be minimum 25 mm and 70 mm respectively.

If screws are to be repeatedly removed and fixed as in kitchen shutters, use of plastic or metal sleeves are recommended.





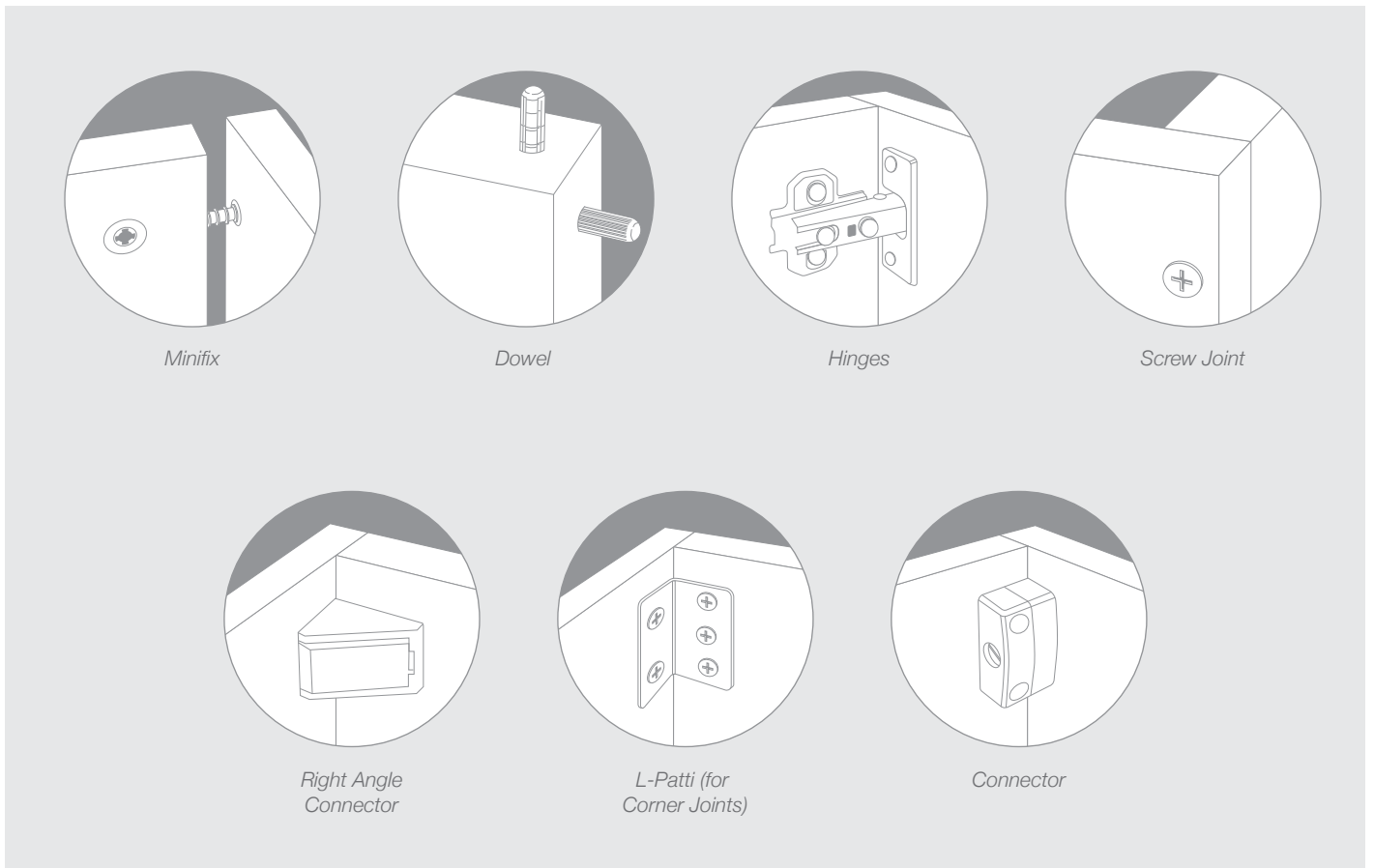
Distance from corner on surface and edges should be minimum 25 mm and 70 mm respectively.

Nailing / Stapling

Nailing can be done for applications like upholstery, fixing of beading, moulding etc. The nails should not be thicker than 17 gauge. When stapling, it is important to control the air pressure so that the top of the staple is just below the surface to achieve the best holding power. Distance of the nails/staples from corner of surfaces and edges should be minimum of 25 mm and 70 mm respectively. Spacing of individual nails or staples should be minimum 150 mm distance from center to center.

Joineries

All common furniture joineries are possible for CenturyMDF Prowud boards, few of the common joineries are illustrated below



Design of load bearing shelves

CenturyMDF Prowud boards are also suitable for load bearing applications such as shelves or storage units, cupboards, wardrobes etc. For these applications, thickness of the boards can be calculated as shown below.

$$T = [5WL^3 \times 9.81 / 32ebd]^{1/3}$$

Where

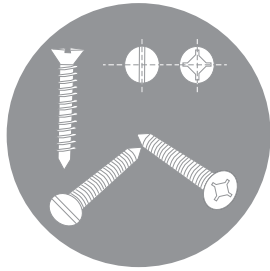
T = Shelf thickness (mm)	e = Modulus of elasticity (N/mm ²)
W = Total load uniformly distributed (kg)	b = Shelf width (mm)
L = Distance between supports (mm)	d = Centre deflection (mm)

Adhesives

All adhesives that are suitable for wood surfaces are suitable for CenturyMDF Prowud boards. We can use normal carpentry adhesives for gluing CenturyMDF Prowud boards, e.g. PVA glues. When bonding CenturyMDF Prowud with other materials, the choice of adhesive is mainly determined by the surface properties of the other material.

Hardware

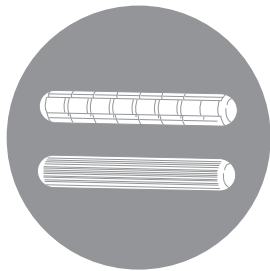
Though normal carpentry hardware can be used for fixing and joining CenturyMDF Prowud boards, for durability and better results, use of recommended hardware is desired.



Fully threaded parallel screws.

Screws

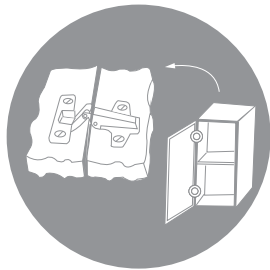
Only fully threaded parallel shank steel screws of proper size should be used (Reference may also be made to IS: 7170)



Dowels can be of plastic, metal, bamboo or wood.

Dowels

Dowels made of plastic, metal, bamboo or wood of proper size can be used and the diameter of the hole should be slightly more than the diameter of the dowels to avoid splitting.



Support shutters with an appropriate number of hinges.

Hinges

We can use all types of carpentry hinges for CenturyMDF Prowud boards. For better result and performance, use of surface mounted hinge is recommended.

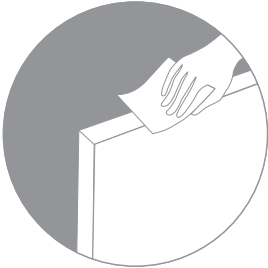
Locks

All types of locks like multipurpose, mortise, cylindrical etc can be used in CenturyMDF Prowud boards

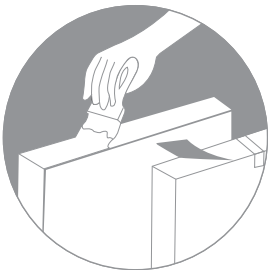
Tips for fixing locks and hinges

- Do not force the door to exceed 93° as it could damage the hinge
- Do not apply paint or polish
- Keep the hinges parallel
- For heavy and long shutters, use 3 or more hinges
- Recommended thickness: 19 mm
- Maximum size of cabinet of 34" x 22" (850 mm x 550 mm) for 2 hinges
- Do not hammer the screw for fixing hinges

FINISHING AND CARE OF EDGES



To seal the edges, start with sanding the edges of the board.



Any of the sealants mentioned alongside may be used to seal the edges.



The exposed edges can also be sealed with timber beading applied with glue.



PVC lipping applied with glue can also be used for edge banding.

Sealing of edges

- Sealing should also be done suitably for the areas exposed for fixing of hardware, hinges, cutting and routing etc.
- After completing the work, all the exposed edges should be sealed suitably with primer/paint/polish/wooden lipping or edge banding. This is required to prevent the boards from absorbing moisture through atmosphere.
- You can use any of the following sealants for edge sealing:
 - a) Epoxy resin
 - b) Nitro-cellulose lacquer
 - c) Polyurethane resin
 - d) Polyvinyl acetate
 - e) Synthetic enamel paint or varnish
 - f) Synthetic wood painter
- The following can be used as lipping material
 - a) PVC bands
 - b) Melamine edge
 - c) Solid wood strips
 - d) Aluminium strips

Surface finishing

- CenturyMDF Prowud boards are sanded with 150 grit finishes, hence no further sanding is required for painting, polishing and photo-lamination.

Painting/Polishing

- The smooth and fine finish of CenturyMDF Prowud boards makes it an ideal product for all kinds of painting, polishing and coating finishes, like Enamel, Acrylic, Nitrocellulose, Polyurethane, and Spirit/French/Melamine etc.
- While normal painting methods recommended by respective paint manufacturers should be followed, extra care should be taken for coating the edges. While coating, the edges should be sealed immediately after sanding as moisture in the air may cause the fibers to stand up and ruin the finish. (User may also refer IS: 2338, Part I & II)
- While painting, polishing and laminating CenturyMDF Prowud. It is recommended to finish the boards on the opposite surface also with the same material (e.g. painting, polishing or lamination) and thickness to prevent warping.

Lamination and Veneering

- The smooth and fine surface finish of CenturyMDF Prowud acts as an excellent substrate for lamination of wood veneer, paper, pre-finished foils, and melamine impregnated papers etc, using normal adhesives like PVA or Urea Formaldehyde and their derivatives.

A FEW THINGS TO KEEP IN MIND TO GET THE BEST OUT OF OUR MDF

Dos

Storing and Handling

- Store boards horizontally on battens
- Battens should be of the same height to ensure surface flatness during storage
- Lift board edgewise while carrying/transporting
- While storing, avoid protrusion or overhanging of boards
- Avoid sharp, or feathered, protruding edges

Cutting & Sawing

- Chisel the scouring line before sawing when working on the pre-laminated boards
- Use fine-toothed push/pull type saw depending on chisel marking to avoid chipping
- While cutting, hold the saw at a low angle
- Use higher RPM carbide-tipped machine saws for better working
- All sharp corners and edges should be rounded off

Screwing

- Use fully threaded parallel shank screws
- Fix screws 25 mm from corners and 75 mm from edges
- Fix screws in zig-zag fashion
- Drill pilot hole while fixing screws & nails (on edges)
- Allow sufficient clearance for screws and dowels of other fittings/joints while assembling

Sealing & Laminating

- Seal all edges and surfaces opened for moulding, routing, etc. must be sealed with proper sealants.
- Use polyurethane primers for sealing
- Use only Synthetic Enamel or Oil-based paints
- When laminating, use lamination of same weight and thickness on both sides

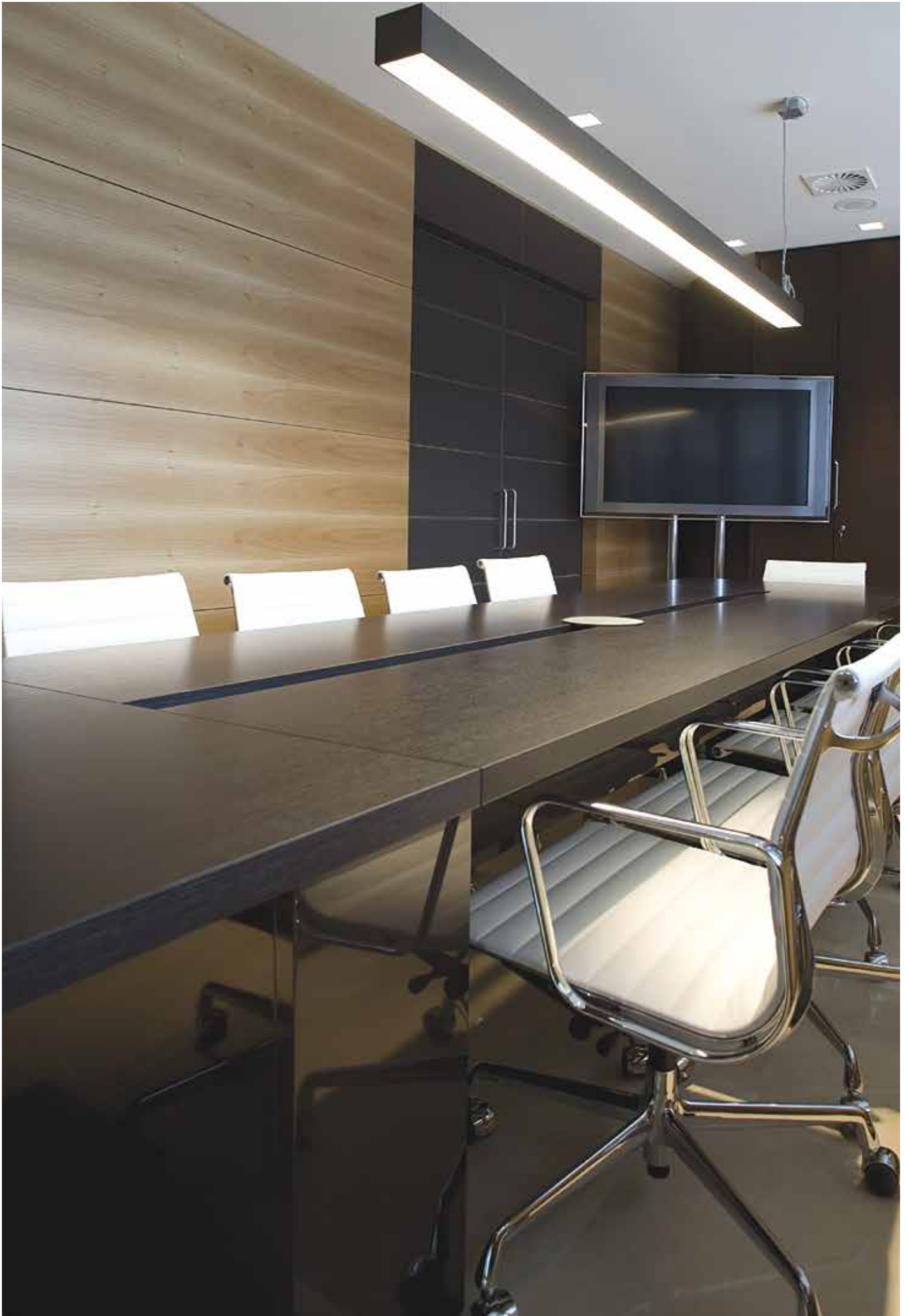
Don'ts

- Do not store boards on floors or wet surface
- Do not drop, drag or slide boards on grid, dirt or grass, or one over another

- Do not use saw without marking the scouring line
- Do not hold the saw vertically while cutting
- Do not use Coarse Rip Saw

- Do not use conventional wood screws
- Do not use screws and nails on the edges of boards 12 mm & below
- Do not fix screws/nails in a straight line
- Do not hammer or over-tighten screws
- Do not make tight-fit joints. This could lead to cracking or glue starvation

- Do not leave edge unsealed/open
- Do not use wood primers
- Do not use Acrylic Emulsion or Water based paints
- Do not use lamination papers of different weights or thickness, or laminate only one side

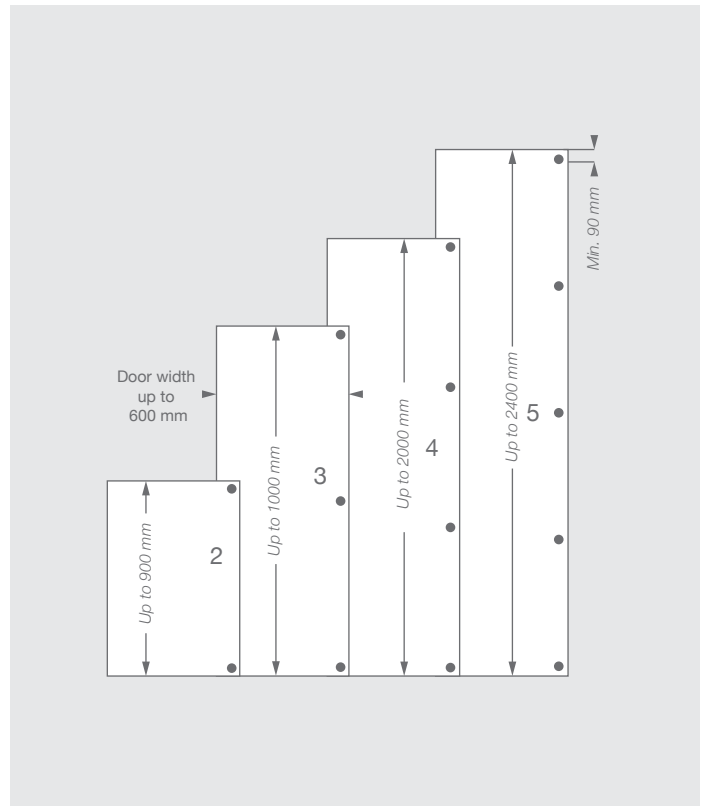


HINGES & FURNITURE FITTINGS

NUMBER OF HINGES PER DOOR

Door width, door height, door weight plus material quality of the door are key factors to determine the required number of hinges.

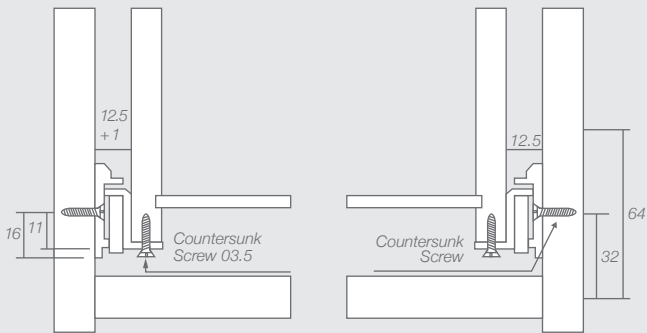
For stability, the distance between hinges should be chosen as large as possible.



HINGES & FURNITURE FITTINGS

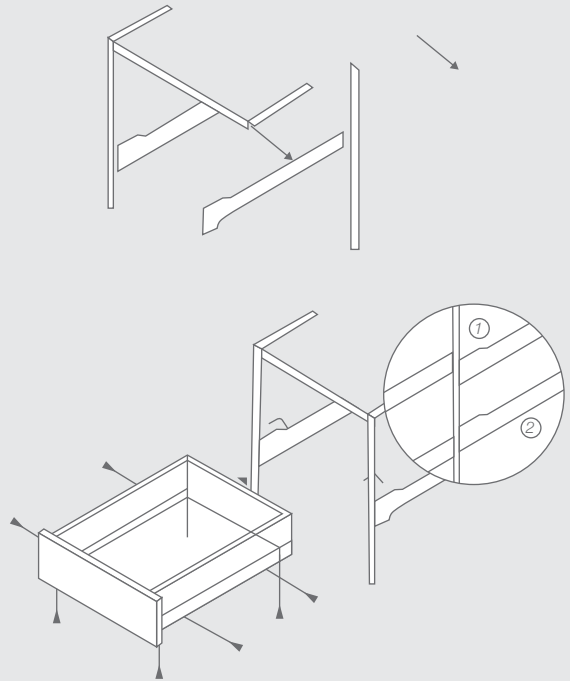
DRAWER CHANNELS INSTALLATION

Countersunk Screw

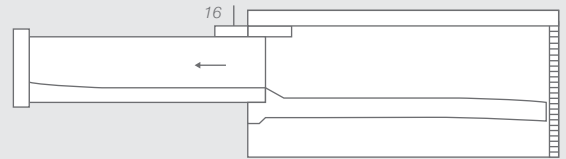


Runner width 12 mm
Installation width 12.5 mm for tolerance compensation

Assembly

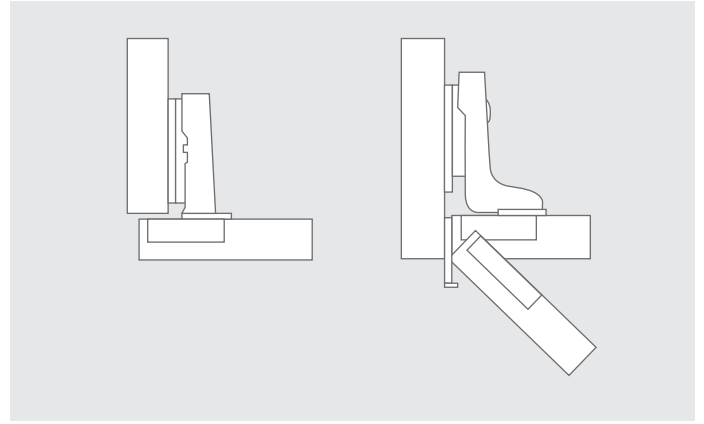


Drawer removal



HINGES & FURNITURE FITTINGS

TYPES OF MOUNTING HINGES

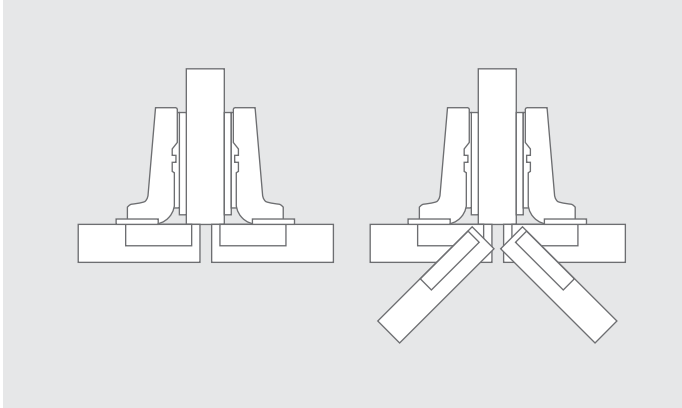


Inset (16 mm Cranking)

In this configuration, the door is positioned inside the side wall of cabinet. A reveal is required for opening the door. This configuration necessitates the use of heavily cranked hinges. * The minimum door reveal, also called door deflection, is the space required for opening a door.

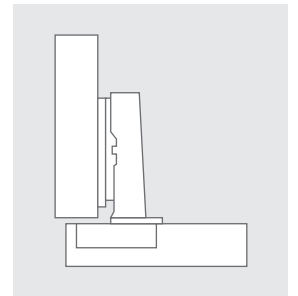
Full Overlay (0 mm Cranking)

In this configuration, the door is positioned in front of a side wall of the cabinet. The reveal at one side is such that the door can be opened safely.



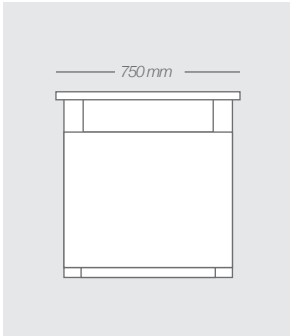
Half Overlay (9.5 mm Cranking)

In this configuration, two doors are positioned in front of the middle wall of a cabinet. The distance between the doors is the total required reveal. The door overlay is reduced which necessitates the use of cranked hinges.

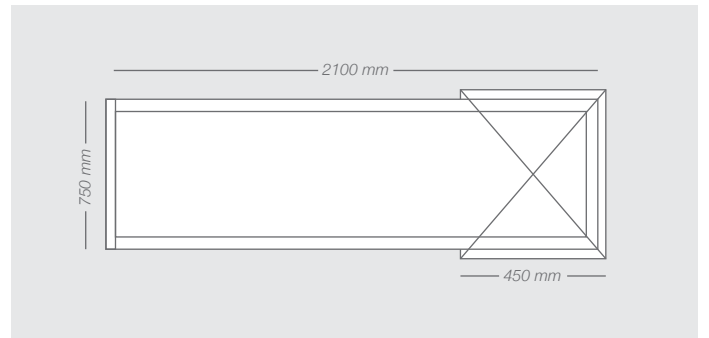
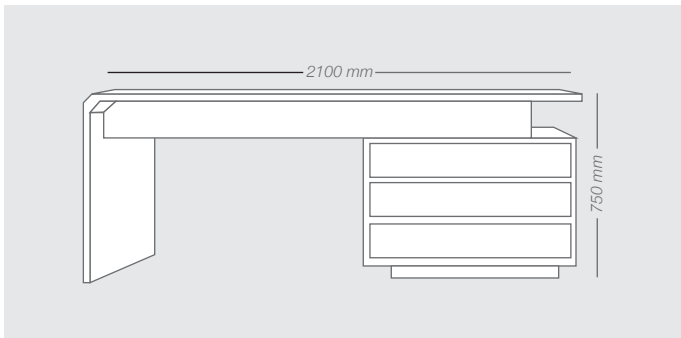


FURNITURE APPLICATIONS OFFICE

STAFF / EXECUTIVE TABLE



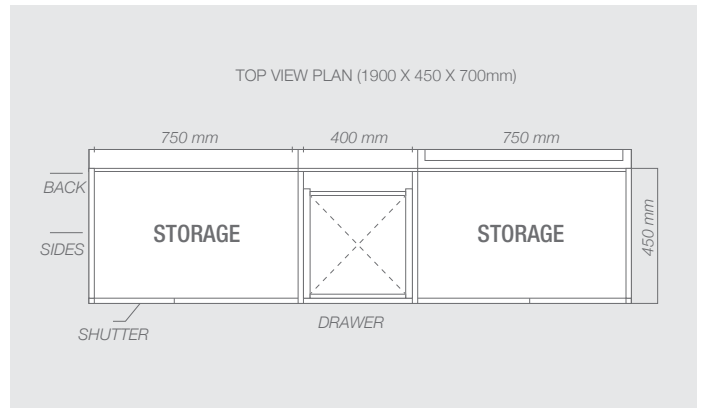
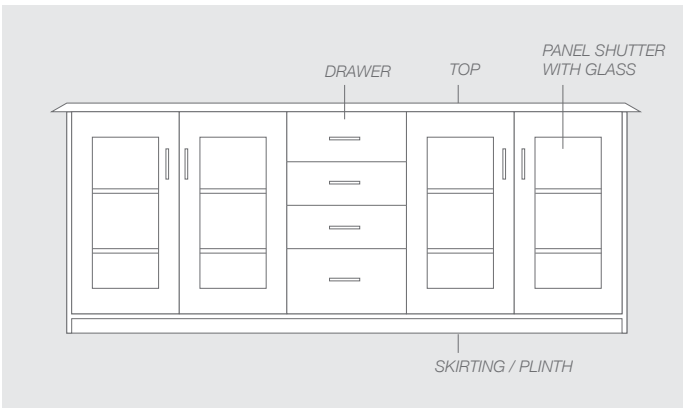
COMPONENTS		CENTURY BOARDS (Particle/MDF Boards)		THICKNESS SPECIFICATIONS
		Plain	Prelam	
Table Top	Length > 1500 mm	√	OSL	25 mm
Table Top	Length > 1500 mm	√	OSL	18 mm
Sides			BSL	30 or 25 mm
Laminates			--	1 mm
Drawer Unit	Carcass	√	OSL	18 mm
Drawer Unit	Back	√	OSL	5.5-7 mm
Drawer Unit	Skirting	√	OSL	18 mm
Drawer Unit	Front	√	OSL	18 mm
Drawer Unit	Box	√	OSL	12 mm
Drawer Unit	Drawer bottom	√	OSL	5.5-7 mm
Screws				Screw Size
Executive Table	18 mm to 18 mm			8 x 38 mm
Executive Table	18 mm to 12 mm			8 x 42 mm
Executive Table	25 mm to 25 mm			10 x 50 or 8 x 50 mm
Drawer Unit	18 mm to 18 mm			8 x 38 mm
Drawer Unit	18 mm to 12 mm			6 x 32 mm
Drawer Unit	12 mm to 12 mm			6 x 24/32 mm



FURNITURE APPLICATIONS

HOME FURNITURE

COMPONENTS	CENTURYMDF Prowud Boards		THICKNESS SPECIFICATIONS
	Plain	Pre-Lam	
Top & Bottom	✓	OSL	18 mm
Sides	✓	BSL	18 mm
Skirtings & Dividers	✓	OSL	18 mm
Back	✓	OSL	8 mm
Front	✓	BSL	18 mm
Span not to exceed	✓		900 mm
Height of shutter	✓	BSL	1800 mm (max)
Width of shutter	✓	BSL	450 mm (max)
SCREWS			SCREW SIZE
18 mm to 18 mm			8 x 38 mm
18 mm to 25 mm			8 x 42 mm
			DOWELS
			36
			36



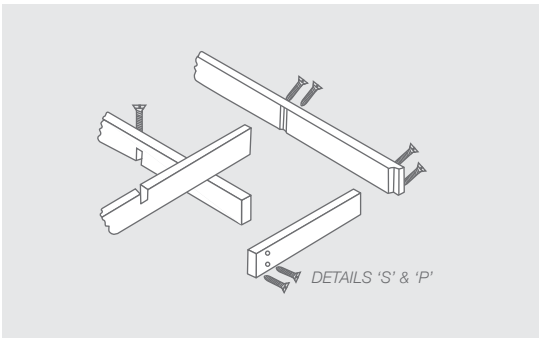
Note: All the unexposed areas should be treated with suitable primer. Check and treat walls & ceilings for any dampness/leakage before installation and rectify if necessary.



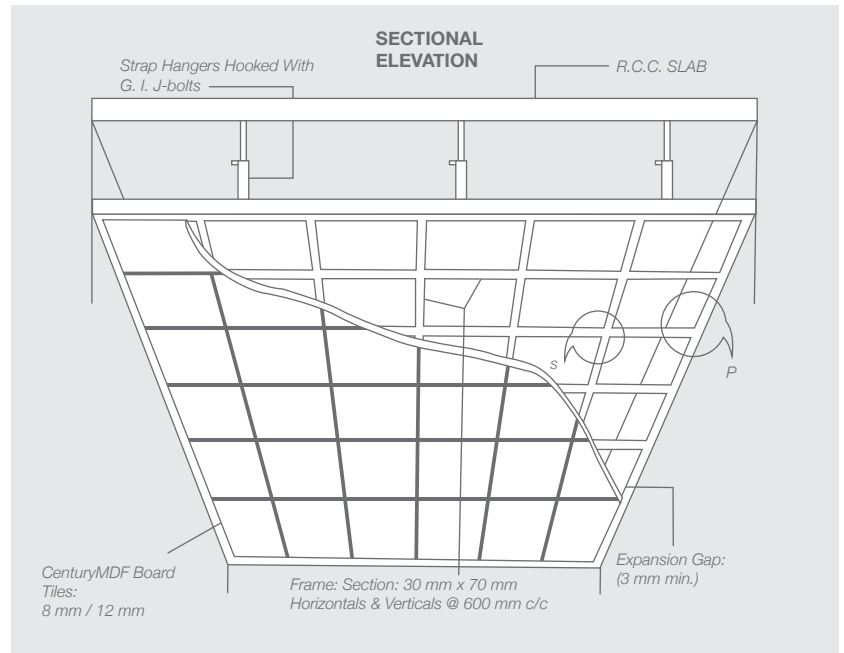
CEILING SUSPENDED

SCREWS	SCREW SIZE
I) 8 mm / 9 mm thick tile	6 x 25 mm
II) 12 mm thick tile	6 x 32 mm
CLEATS	SIZE
12 mm thick tile	75 mm (3")

THICKNESS OF TILE FOR CLADDING	SIZE OF TILE
I) 8 mm / 9 mm	600 mm x 600 mm
II) 12 mm	600 mm x 600 mm 1200 mm x 600 mm / 1200 mm 1800 mm x 600 mm / 1200 mm 2400 mm x 600 mm / 1200 mm



COMPONENTS	RECOMMENDED SPECIFICATIONS
Frame Section	70 mm x 30 mm thickness
Spacing between Horizontal & Vertical Sections	600 mm centre to centre
Expansion Gap between cladding joints	Minimum 3 mm
Cladding Tiles	12 mm / 8 mm thickness
Strap Hangers (MS Flat x 6 mm) hooked to G.I. J-bolts fixed to ceiling at spacing	1200 mm centre to centre
Spacing between fully parallel threaded screws	300 mm centre to centre

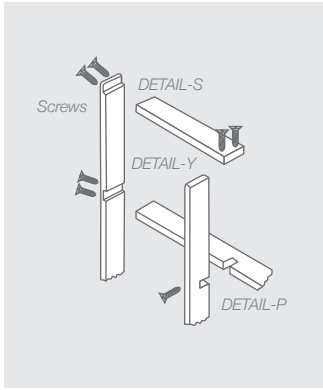
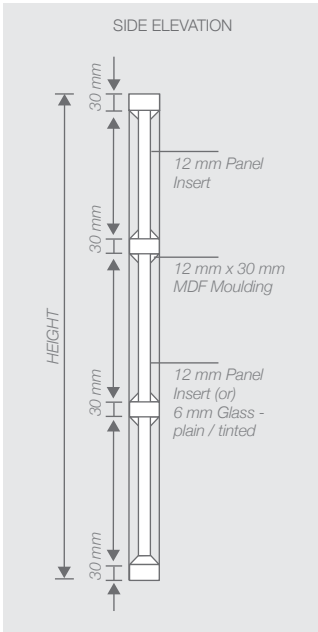
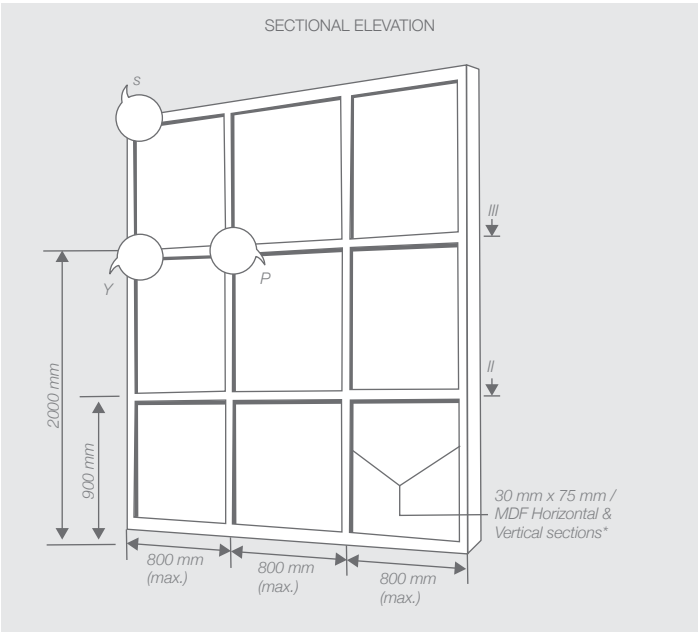


Note: The unexposed area like the tiles & the entire framework has to be duly treated with two coats of suitable primer.



SINGLE SKIN PARTITION

COMPONENTS	RECOMMENDED SPECIFICATIONS
Horizontal & Vertical Sections (Height less than 10' - 0" or 3.0 meters)	75 mm x 30 mm thickness
Horizontal & Vertical Sections (Height more than 10' - 0" or 3.0 meters upto 16' - 0" or 4.8 meters)	100 mm x 30 mm thickness
Spacing between each vertical/s (Height less than 10' - 0" or 3.0 meters)	Maximum 800 mm centre to centre
Spacing between each vertical/s (Height more than 10' - 0" or 3.0 meters) upto 16' - 0" or 4.8 meters)	Maximum 900 mm centre to centre



For height less than 10' - 0" the horizontals to be placed one at bottom, second at 900 mm height, third at 2000 mm height, and one at ceiling level. The joinery for horizontal and vertical members is with HALF LAP and SCREWS.

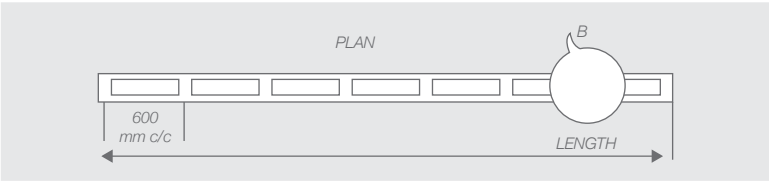
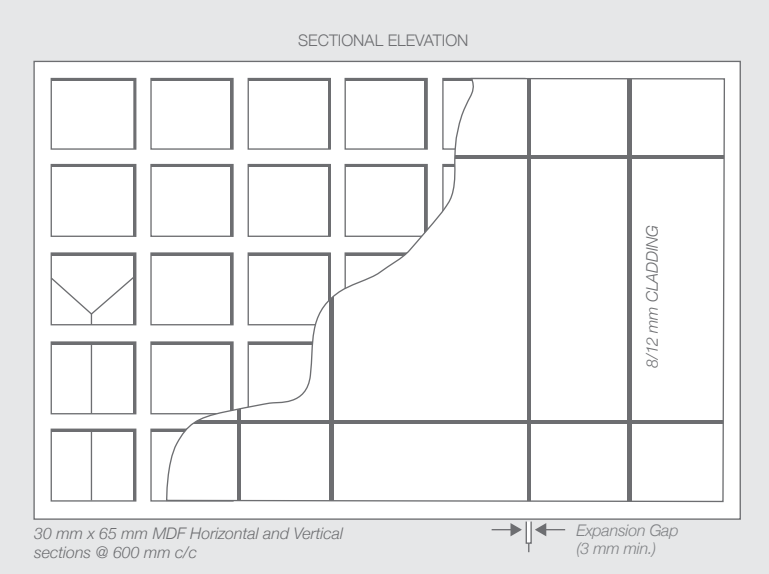
For glazed partitions, 6 mm thick plain/tinted glass to be fixed in between II & III horizontals with 30 mm x 12 mm moulding fixed with headless nails.

Note: The unexposed area like the members at floor, wall and ceiling should be coated with a minimum of two coats of suitable paint.



DOUBLE SKIN PARTITION

COMPONENTS	RECOMMENDED SPECIFICATIONS
Horizontal & Vertical Sections (Height less than 10' - 0" or 3.0 meters)	65 mm x 30 mm thickness
Horizontal & Vertical Sections (Height more than 10'0" or 3.0 meters upto 16'0" or 4.8 meters)	80 / 81 mm x 30 mm thickness
Spacing between each vertical/s (Height less than 10'0" or 3.0 meters)	600 mm centre to centre
Cladding tiles	8 mm / 12 mm thickness
Expansion Gap between every joint of cladding	3 mm to 6 mm



SCREWS	SCREW SIZE
a) FRAMEWORK	8 x 38 mm or 8 x 42 mm
b) CLADDING	
I) 8 mm thick	6 x 25 mm
II) 12 mm thick	6 X 32 mm

HEADLESS NAILS	NAILS SIZE
CLADDING ONLY	
I) 8 mm thick	20 gauge (20 x 18 mm) = 3/4" long
II) 12 mm thick	17 gauge (17 x 25 mm) = 1" long
CLEATS	SIZE
12 mm thick	75 mm (3")

3 mm Expansion Gap

8/12 mm thk.

65 mm

17

30 mm x 65 mm section

DETAIL 'B'

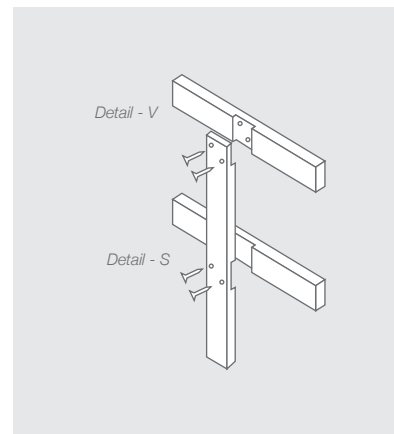
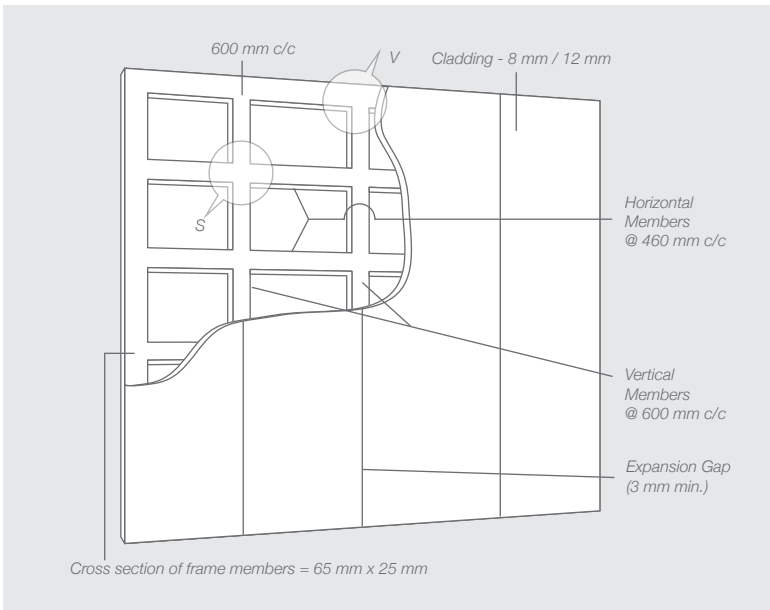
Note: The unexposed area like the members at floor, wall and ceiling should be coated with a minimum of two coats of suitable primer.



WALL PANELLING

COMPONENTS	RECOMMENDED SPECIFICATIONS
Frame Cross Section	65 mm x 25 mm
Spacing between Horizontal Frame Sections	450 mm centre to centre
Spacing between Vertical Frame Sections	600 mm centre to centre
Expansion Gap between cladding joints	Minimum 3 mm
Cladding Tiles	8 mm/12 mm thickness plain or pre-lam

SCREWS	SCREW SIZE
a) FRAMEWORK	8 x 25 mm
b) CLADDING	
I) 8 mm thick	6 x 25 mm
II) 12 mm thick	6 x 32 mm

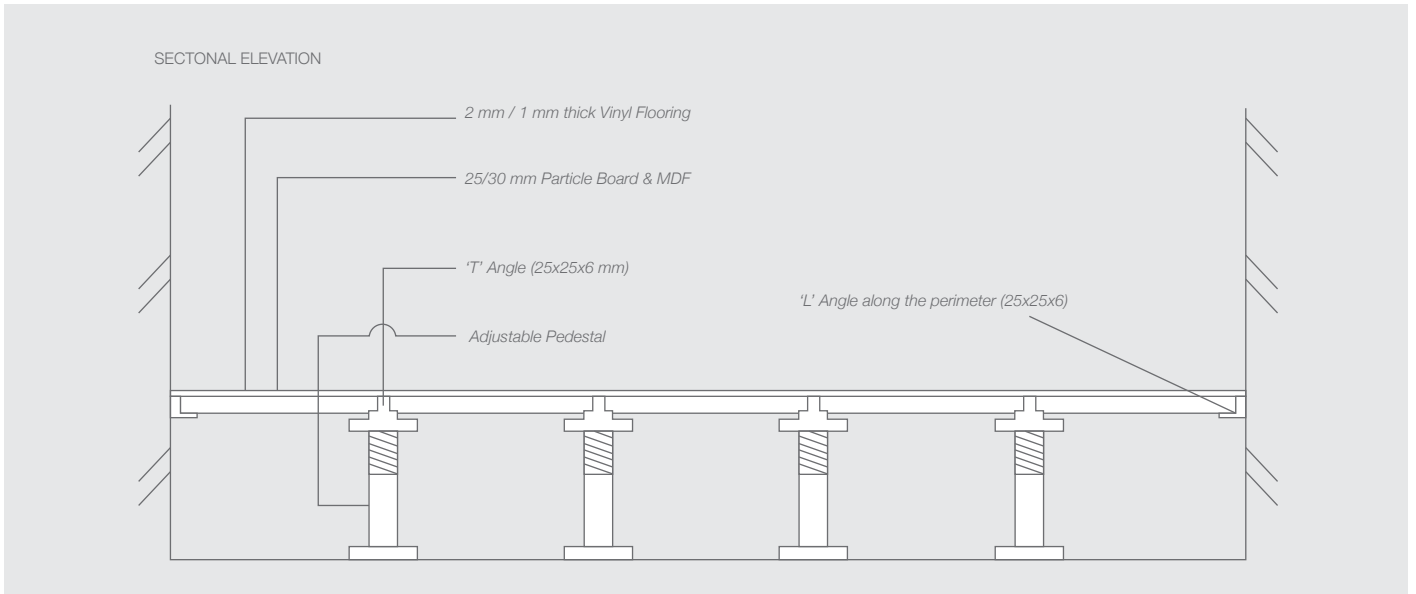


Note: Prior to mounting on the wall, the entire framework and the cladding panels facing the frame have to be provided with at least two coats of suitable primer. Before commencing work, check the walls and ceiling for any dampness or leakage. If leakage is found then apply at least two coats of suitable primer.

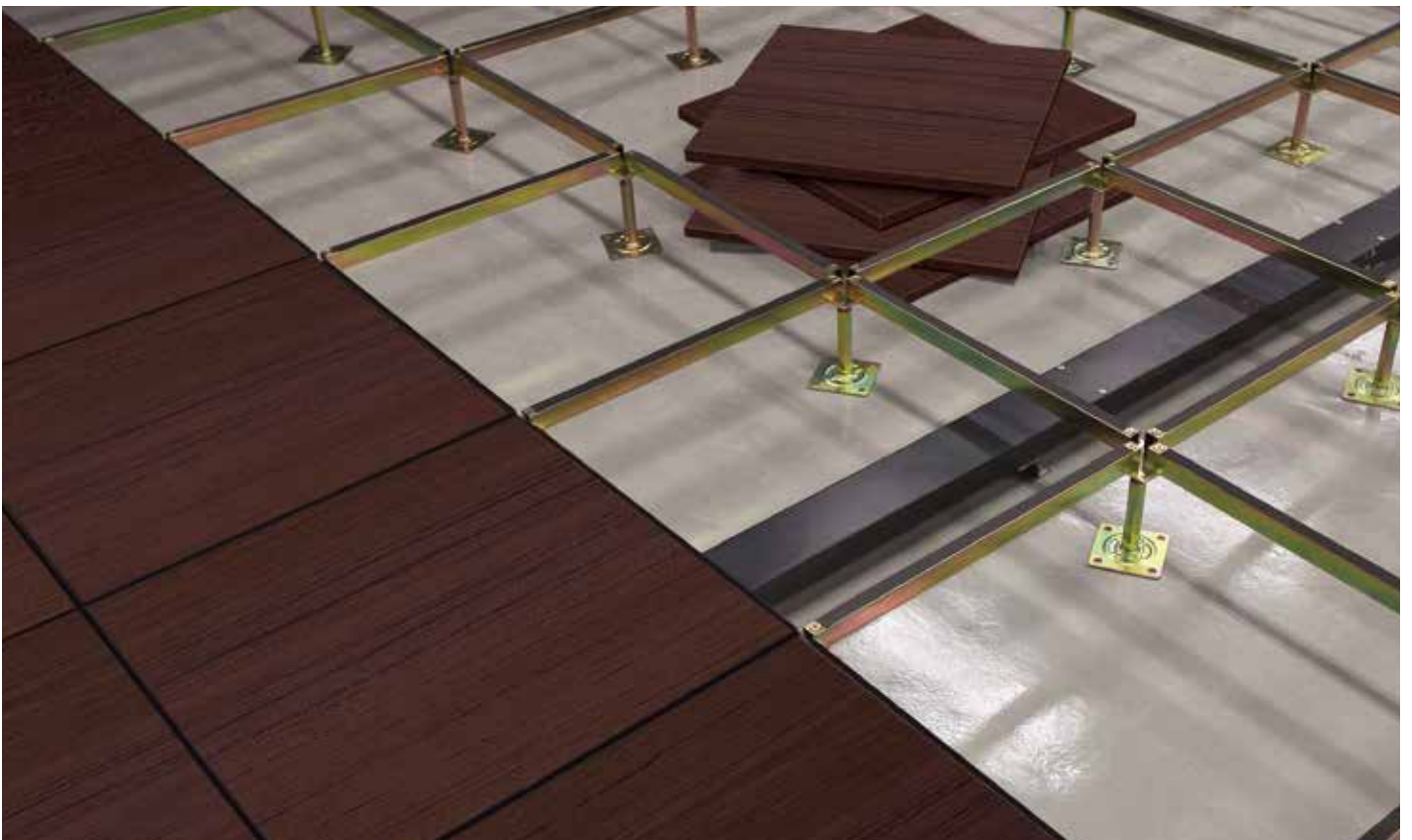


CAVITY FLOORING

COMPONENTS	RECOMMENDED SPECIFICATIONS
Flooring Panel	25/30 mm thickness
Grid Size / Tile Size	600 mm x 600 mm
Spacing between fully parallel threaded screws	300 mm centre to centre
Spacing between T Angles	600 mm centre to centre
T Angle	Manufacturer's / Designer's recommendations should be followed
L Angles along the perimeter	
Vinyl Flooring	
MS Framework with adjustable pedestals with top and base plates	



Note: All the unexposed areas should be treated with suitable primer. Check and treat walls & ceilings for any dampness/leakage before installation and rectify if necessary.



RECOMMENDED CENTURYMDF PROWUD BOARDS APPLICATIONS SPECIFICATIONS

SR. NO.	APPLICATIONS		CENTURYMDF PROWUD BOARDS	
	Product	Components of CenturyMDF Prowud Boards	Thickness to be used	Grade recommended
1	Suspended Ceiling	Tiles Framework	8 mm / 12 mm / 30 mm	Grade I & II
2	Wall Panelling	Tiles Framework	8 mm / 12 mm / 25 mm	Grade I & II
3	Solid Core Door Shutters Panelled Door Shutters	Panel Inserts	12 mm	Grade I & II
4	Partitions I) Single Skin II) Double Skin	Panel, Framework	12 mm / 18mm / 30 mm	Grade I & II
		Panel, Framework	8 mm / 12 mm / 30 mm	Grade I & II
5	Flooring		25 mm / 30 mm	Grade I
6	Column		18 mm	Grade I & II
7	Pelmets		18 mm	Grade II
8	Cornices		18 mm / 25 mm / 30 mm	Grade II
9	Handicrafts		18 mm / 25 mm / 30 mm	Grade II
10	Conference Tables, Office Tables / Workstations, Computer Workstations, Driving Tables, Study Tables	Tops, Sides Skirting	18 mm / 25 mm 12 mm / 18 mm	Grade II
11	Dressing Tables, Bedside Tables, Centre Tables	Top, Sides, Back Mirror Back	12 mm / 18 mm 5.5-7.0 mm 12 mm	Grade II
12	Storage Units, Wardrobes, Wall Units, Display & Storage Cabinets, Shoe Racks, Filing Units	Tops, Sides, Dividers Back	18 mm / 8 mm / 5.5-7.0 mm 12 mm	Grade II
		Shutters, Shelves, Drawers: Front Sides Bottom	18 mm 12 mm / 18 mm 5.5-7.0 mm / 8 mm	
13	Kitchen Cabinets	Frame	25 mm / 30 mm	Grade I
		Sides, Shelves, Shutters Drawers	18 mm As mentioned above	
14	School Benches/Desks/Tables Book Shelves		18 mm	Grade II
15	Black Board	Panel Frame	12 mm 30 mm	Grade II
16	Interiors of Carriages; Buses; Travel Coaches; Railway Carriages	Seat	12 mm / 18 mm	Grade I & II
		Backrest, Ceiling Cladding	5.5-7.0 mm / 8 mm	
17	Speakers; Audio Visual Cabinets (TV) Scientific Instruments		5.5-7.0, 9.75, 10, 12, 18 mm	Grade I & II
18	Architectural, Engineering & Design Models;		5.5-7.0 mm	Grade I & II
19	Exhibition Pavilion	Panels	8 mm / 12 mm	Grade I & II
20	Picture Frames		12 mm	Grade I & II
21	Audio Video Trolley	Top	18 mm	Grade I & II
		Sides	18 mm	
22	Photolamination	Back	8 mm	Grade I & II
23	Beds		12 mm - 30 mm	Grade I & II

**Grades recommended here are indicative. Actual selection should be made as per site conditions. CenturyMDF Prowud Boards are available in DWR (Grade I) and DIR (Grade II) only.*



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