



## How to use

*karuun® shine* is either put together and pressed onto a carrier (e.g. plexiglas, glass, chipboard, multiplex or MDF) or placed into a frame without a carrier.

Contact us directly if you have any queries.

***karuun®* is a natural product obtained from the rattan palm which is produced using a highly energy-efficient manufacturing process. When processed, the characteristic dotted structure of *karuun® shine* produces a uniform surface with a subtly tiled pattern.**

The end-grain material is not only translucent but also permeable to both air and light. The natural capillary structure of the material also ensures excellent stability while also being

pleasant to the touch. Depending on thickness, the degree of translucency varies when viewed from different angles.

## Product Specifications



**Thickness:** 0.3/0.5 mm (unpolished)  
**Dimensions:** custom sizes upon request  
**Design:** natural, black, red, blue dots and custom dot colour

**400** kg/m<sup>3</sup>

**Density (product)**  
+/-

**10** %

**Moisture content**  
at 20°C/65% relative humidity

**0.15** %

**Differential shrinkage (V)**  
longitudinal / tangential  
per % changes of moisture

**0.048** %

**Differential shrinkage (V)**  
radial  
per % changes of moisture

**2.3** N/mm<sup>2</sup>

**Compression (fc,90,k)**  
Rectangular to the grain

**12** N/mm<sup>2</sup>

**Compression (fc,0,k)**  
Face grain direction

All dimensions are approximate. *karuun®* is a natural material therefore slight variations in colour cannot be ruled out.



**GERMAN  
DESIGN  
AWARD  
GOLD  
2016**



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## Processing guidelines

**Storage:** Store *karuun*® materials covered in a dry place protected from dust and UV rays.

**Suitable adhesives:** Common adhesives such as PVAC, PU, UF, MF or adhesive films

### General tips:

- The material is very susceptible to humidity and temperature fluctuations.
- The material is fragile, take care when handling.
- Over-exposure to heat can lead to discolourations and make the material brittle.

#### Suitable tools:

- Scissors, Stanley knife, circular saw
- Special joining machines for veneer (2mm joints upwards)
- Common veneer presses or membrane presses.
- Common grinding machines
- Compressed air devices

#### Preparation:

- The ideal moisture content to process *karuun*® materials is 8–11 %.
- Cut rolled material to size and join as required.
- If necessary, mask the surface before joining to prevent glue from penetrating the adjacent capillaries.
- Most common panel materials are suitable for use as a substrate.
- It is recommend you use the same material for the backing material.

#### Pressing:

- Adhesive required: 100–200 g/m<sup>2</sup>
- Ensure the adhesive is distributed evenly (be careful that it doesn't bleed through).
- Open time: depends on adhesive (see manufacturer's guidelines)
- Pressing temperature: 15–130 °C depending on the adhesive and pressing process (discolouration may occur at higher temperatures and longer pressing times)
- Leave panels to air on both sides after pressing.
- Pressing time: depends on adhesive (see manufacturer's guidelines) and pressing process (from 5 seconds)
- Pressing pressure: 3–8 kg/cm<sup>2</sup> depending on application
- The material is only slightly malleable in a dry condition.
- By adding heat and/or moisture, the material becomes elastic and malleable (caution: excessive exposure to moisture leads to swelling and will potentially destroy the material).

#### Sanding:

- Use 180–300 grit sandpaper
- Hand sanding (e.g. with an orbit sander)
- Machine sanding (with wide belt sander, preferably with an air platen)
- Blow any residue off the surface and out of the pores with compressed air once sanding is complete.

#### Finishing:

- Surface must be dry, free of dust and grease.
- The finishing process should be performed immediately after sanding.
- Suitable products: solvent-based varnishes (varnishes should be medium/highly diluted as necessary to prevent the fine pore structure from being worn away)
- Order: the first application is the priming coat (from different angles to wet the pores' inner walls), after curing comes intermediate sanding (e.g. 240 grit – orbit sander), blast/suck surface with air, 1–2 thin top coats.
- Apply the product as thinly as possible so as to retain the material's structure.
- A fine intermediate sanding after each application is recommended.



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