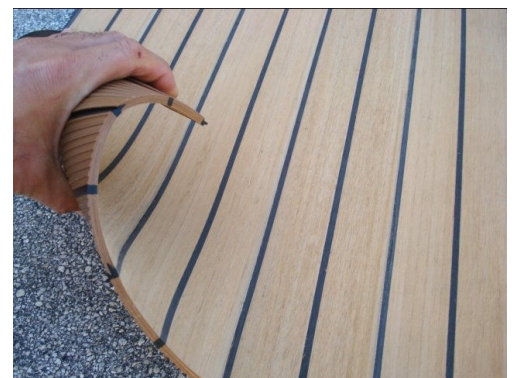


FABRICATING NUTEAK



The New Standard in Synthetic Teak Decking

Begin by opening your boxes of Nuteak and unrolling the material on a clean dry surface for 30 minutes to 24 hours depending on air temperature. Once acclimatized warping from being rolled up will have left the material and you are ready to begin.



YOU WILL NEED:

- Nuteak material, double plank, margin and king plank quantities as required by your application and design.
- PVC welding rod matching the color of your nautical line
- PVC welding gun
- Razor Knife
- Heat resistant gloves
- Mask
- Safety glasses
- Sanding block with 40 and 60 grit paper
- Pen or pencil



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STEPS TO FABRICATING A NUTEAK PANEL

1. Lay out the template on a large enough flat working surface. If the template is transparent look for text to ensure that the template is not up-side-down. Find the center line and decide if you want a plank or a nautical line in the center.
2. Line up the center line with your nautical line and cut your sections of double plank until you have enough to cover the template. Leave a small amount of sacrificial material on each side as a safety. If you will be adding margins remember to deduct 55mm from the template outline so as not to have too much wasted material.
3. Use a straight edge to ensure the lines are straight and start gluing the strips of double plank together with MAST adhesive. Apply a thin layer of glue and hold for 2-12 seconds in 10cm - 20cm increments.
4. Once the material is bonded line up the template and trace and cut the outline or the margin line if applicable. If you will be adding margins at this point flip the material and cut or rout a 2mm deep 2mm wide groove on the bottom edge before flipping the deck back over and using the MAST adhesive to attach any margins or king plank sections (top weld if necessary).
5. (This step is optional for for small DIY Projects) Flip your deck over and weld all glued seams, then remove excess welding rod with a blade. Sand if necessary to ensure the bottom of the deck is flush with no protruding welding rod material.
- 6 Use the sandpaper to round cut edges and remove any imperfections. (**Always sand in the direction of the grain.**)



Welding:

Practice before hand to ensure you are familiar with your welding gun. Hold the gun at an an angle that heats both the rod and the material it is bonding with. If a black crust forms or the material melts or warps, the gun is set too hot or you are welding too slowly. If the rod does not have a strong bond the gun is not hot enough or you are welding too fast. The weld is usually perfect when you see a small bulge of liquid plastic on either side of the rod where it meets the material.

Safety:

- Always wear safety glasses, gloves, and a mask when welding synthetic teak.
- Make sure the work area is well-ventilated.
- Keep flammable materials away from the welding area.
- Don't touch the molten plastic. It can be hot enough to cause burns.

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