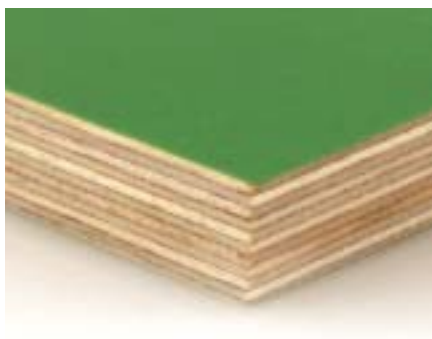


FILM FACED PLYWOOD WITH PHENOLIC FILM



1 Scope and field of application

Technical specification for phenolic film faced plywood in which film is pressed in hot technology.

2 Structure

Under film is cross built hardwood plywood.

3 Materials

3.1 Plywood 100% hardwood exterior

(alder, birch)

3.2 Plywood hardwood exterior

(combi - alder, birch pine, spruce)

3.3 Covering phenol film

40/120 g/m²

60/150 g/m²

60/167 g/m²

80/220 g/m²

Standard dark brown, other colours can be agreed.

3.4 Transparent phenol film

40/120 g/m². Standard light brown, green.

3.5 Acrylic water resistant paint

for painting of the edges – on request.

4 Types of the surface structure

- both sides smooth (smooth/smooth)
- one side wire mesh imprint (net/smooth)
- both sides wire mesh imprint (net/net)
- one side hexagonal imprint (hexa/net)
- (hexa/smooth)

5 Quality requirements

Categories of characteristic	Range of tolerance
Mat spots	permitted up to 20 cm ² , up to a number 2 pcs. / 1 m ²
Scratch e.g. because of pressing plate	permitted of occasional
Cracks of film	not permitted
Defects at the edges of the panel due to cracks of film and painting	permitter up to 2 mm from the edges
Streaks, fogging colour on film surface	permitted
Visible unevenness because of the structure of the wood	permitted

ATTENTION! Colour of film can changed because of sunbeams.

5.1 Quality requirements outer venners

II class acc. to PN-EN 635–2 if transparent film.

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6 Dimensions and tolerances

6.1 Formats

1250 x 2500 mm
1500 x 2500/3000 mm
Tolerance acc. to EN 315 $\pm 3,5$ mm

6.2 Thickness

6,5 ÷ 35mm
Tolerance acc. to EN 315

Nominal thickness (t) mm	Tolerances on nominal thickness mm	Tolerance within one panel mm
$\geq 6,5$ ≤ 25	+ (0,2 + 0,03 t) - (0,4 + 0,03 t)	0,6
> 25 ≤ 30	+ (0,0 + 0,05 t) - (0,4 + 0,05 t)	0,8
> 30	+ (0,0 + 0,03 t) - (0,4 + 0,03 t)	

6.3 Squareness: 2 mm / 1 m

7 Distortion – cup, bow, twist

In plywood up to 10 mm thick distortion is not taken into consideration so the distortion is unlimited. In plywood 10 mm thick and thicker distortion is permitted up to 10 mm / 1 m of length.

8 Bonding quality

Phenolic glue
Bonding quality acc. to PN-EN 314-2/class 3 (DIN BFU 100, BS 1203 WBP)

9 Formaldehyde release

Formaldehyde class E1 acc. to PN-EN 636

10 Moisture content plywood: 4-12%

11 Other conditions can be agreed between the parties.