

COMPOSICIÓN

Wood particle base board, E1 classified, coated with High Pressure Laminate (HPL) on both sides.

RECOMMENDED APPLICATIONS

Components for furniture and decoration.

BASE BOARD CHARACTERISTICS

DIMENSIONAL TOLERANCES

	PROPERTY	VALUE	STANDARD
	Length & width	± 5 mm.	EN 324-1
	Thickness	± 0,3 mm.	EN 324-1
	Squaring	2 mm.	EN 324-2

PHYSICAL & MECHANICAL PROPERTIES

	PROPERTY	THICKNESS (mm)			STANDARD
		10-12	16-18	19-25	
	Density (kg/m³)	710 ± 30	670 ± 30	650 ± 30	EN 323
	Tensile strength (N/mm²) – min.	0,40	0,35	0,30	EN 319
	Flexural strength (N/mm²) – min.	11	11	10	EN 310
	Elastic modulus (N/mm²) – min.	1800	1600	1500	EN 310
	Residual humidity (%) – range		5 - 13		EN 322
	Formaldehyde content E1 (mg/100g) – max.		8 mg.		EN 120
	Fire performance (class)		D-s2, d0		EN 13501-1

COATING CHARACTERISTICS

PHYSICAL & MECHANICAL PROPERTIES

PROPERTY	VALUE	STANDAR
Resistance to cold food products	Conforming	UNE 56875
Resistance to cleaning products	Conforming	UNE 56875
Coating adhesion (% particulate adhesion)	100%	UNE 56875
Light fastness	Conforming	UNE 56875
Scratch resistance	Grade 3 / 2,5 N	UNE 56875
Stain resistance	Conforming	UNE 56875
Edge banding (Processed edge pieces)	Conforming	UNE 56875
Modulus of elasticity (N/mm ²) – min. (Processed edge pieces)	± 0,5 mm	ALVIC
Warping tolerance	2 mm / 1 m	ALVIC
Plain colour tolerance between production batch	$\Delta E \leq 0,70$	CIE Lab D65/10°

EVALUATION OF SURFACE DEFECTS

The evaluation conditions for surface defects are as follows:

1. Viewing distance: 700 mm
2. Position of workpiece: Vertical (installation conditions)
3. Lighting: diffused light of white fluorescent lamps (6500K)
4. Observation time : maximum 20 seconds

Higher than 1.0 mm² to be visible under the above conditions not be considered admissible defects.

USE RECOMMENDATIONS

STORAGE

The panels and bands should be checked upon receipt so that any eventual issue can be communicated as soon as possible.

Avoid exposure of the product to sunlight (UV radiation) and other sources of heat. Store in a ventilated area. Use a FIFO inventory management system to avoid the mixing of products of very different dates of production, which, with the slight changes in the qualities of coatings, might lead to visible differences between them.

The recommended range of environmental conditions of storage and use is as follows:

Temperature: 10°C - 40°C

Humidity: 30% - 70%

HORIZONTAL STORAGE

The panels and bands must not be placed directly on the ground. Whenever possible, the storage support media supplied with each pack should be used and placed in the same position in order to maintain a uniform and level height and to prevent deformation of the panels and bands. For the length of 2750 mm at least 4 supports should be used distributed uniformly.

When stacking multiple packs, up to a recommended maximum of four, the supports of different packs must be aligned vertically in order to transfer the weight to the lower layers without deforming the panels and bands. To protect the surface of the boards, use upper and lower board protections.

VERTICAL STORAGE

Although it should be avoided whenever possible, a limited number of panels and bands may be stored vertically in racks with a support surface for the boards, so as to prevent warpage, and a minimum inclination of 10°.

HANDLING & TRANSPORT

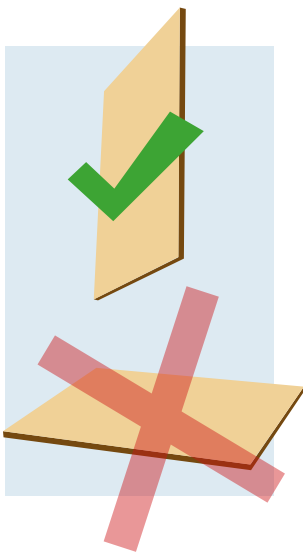
During machining of the panels and bands, appropriate suction systems must be used and, if necessary, protective masks to prevent breathing in of dust generated from the board. The boards must not be dragged on any surface that may cause deterioration of any of their faces.

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USE RECOMMENDATIONS

**CLEANING**

For cleaning, it is recommended to use a nonabrasive cloth moistened with soap and water and immediate subsequent drying. Under no circumstances must harsh chemicals be used such as solvents, alcohol, ammonia, etc.

**APPLICATIONS**

The characteristics of the product enable it to be used as non-work surface (vertical surface).

The information contained in this document does not relieve the purchaser, transformer, assembler and/or final user of the obligation to check the compatibility of the material with the planned use and installation.

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