

## SPECIFICATION FILMFACED ROBUSTA PLYWOOD

Dimensions	2500 x 1250 mm / 1250 x 2500 mm
Thicknesses	8/10/12/15/18/21/24/27/28/30 mm
Tolerances length/width	+/- 2 mm
Type of surface	both sides smooth
Film surface (standard)	120 gr/sqm, dark-brown
Edge protection	water resistant sealing
Wood type used	Robusta / Poplar
Class of formaldehyde emission	E1
Water resistance	WBP marking
Humidity	8-12 %
Bonding strength	1,5 MN/sqm (after 4 hours in boiling water) 1,35 MN/sqm (after 72 hours in boiling water)
Module of elasticity	5200-4200 N/mm <sup>2</sup>
Resistance to bending	56-48 N/mm <sup>2</sup>
Abrasive strength of top layers (Taber rotations)	350-400

## SPECIFICATION FILMFACED ROBUSTA PLYWOOD IN STANDARD DIMENSION 1250 x 2500 mm

Thickness in mm	Numbers of layers	Weight per each sheet in kg (abt.)	Weight per bundle in kg	Numbers of pieces per bundle
8	4	12	1520	126
10	5	15	1520	101
12	6	18	1520	84
15	7 or 8	22	1520	67
18	9	26	1520	56
21	11	31	1520	48
24	12	35	1520	42
27	13	40	1520	37
28	14	41	1520	36
30	15	44	1520	34

## SPECIFICATION OF FILMFACED BIRCH-POPLAR-BIRCH PLYWOOD

Dimensions	2500 x 1250 mm / 1250 x 2500 mm
Thicknesses	15/18/21 mm
Tolerances length/width	+/- 2 mm
Type of surface	both sides smooth
Film surface (standard)	120 g/sqm, dark-brown
Edge protection	water-proofed sealing
Wood type used	Birch / Robusta
Class of formaldehyde emission	E1
Water resistance	WBP marking
Humidity	8 %
Specific weight	590 kg/cbm
Glueing	class 3, water-resistant
Bonding strength	1,5 MN/sqm (after 4 hours in boiling water) 1,35 MN/sqm (after 72 hours in boiling water)
Module of elasticity	Em 5% $\parallel$ (Em90) 6.630,04 N/mm <sup>2</sup> Em 5% $\perp$ (Em 0) 5.419,80 N/mm <sup>2</sup> class E 40/60
Resistance to bending	fm 5% $\parallel$ (fm90) 56,877 N/mm <sup>2</sup> fm 5% $\perp$ (fm 0) 52,43 N/mm <sup>2</sup> class F 30/30
Abrasive strength of top layers (Taber rotations)	350-400

## SPECIFICATION FILM-FACED BIRCH-POPLAR-BIRCH PLYWOOD IN STANDARD DIMENSION 1250 x 2500 mm

Thickness in mm	Numbers of layers	Weight per each sheet in kg (abt.)	Weight per bundle in kg	Numbers of pieces per bundle
15	9	22	1860	67
18	11	26	1860	56
21	13	31	1860	48

## QUALITY CRITERIA WELDE-FORM film-faced plywood – SURFACE APPEARANCE

№	TYPE OF CRITERIA	EXTRA quality	STANDARD quality	ECONOMY quality
1	Panel squaredness (EN 315)	Allowed 1 mm per running meter of panel length	Allowed 1 mm per running meter of panel length	Allowed 1 mm per running meter of panel length
2	Slight color variation of film	allowed	allowed	allowed
3	Imprints of the INNER veneers (knots or splits) onto the panel surface	allowed up to: – maximum 2 per m <sup>2</sup> for knots with width 50mm – maximum 2 per m <sup>2</sup> for splits with width 5mm	allowed up to: – maximum 2 per m <sup>2</sup> for knots with width 80mm – maximum 5 per m <sup>2</sup> for splits with width 10mm	allowed
4	Missing film	not allowed	allowed up to 1% of the surface	allowed up to 2% of the surface
5	Burnt or unglued film (grey-brown appearance) running along the edge of the panel surface	Along the short side of the panel: stripe up to 10mm wide Along the long side of the panel: stripe up to 5mm wide	In addition to Extra, the following is allowed: – Spots: maximum 2 per m <sup>2</sup> with max. diameter of 80mm – Small stripes: maximum 2 per m <sup>2</sup> with max. width of 10mm – Sanding marks under film – up to 1% per panel	allowed up to 2% of the surface
6	Swelling of top veneer layer	not allowed	not allowed	allowed up to 1 per m <sup>2</sup> with diameter of 200mm
7	Panel straightness (EN 315)	Allowed up to 2mm per running meter from the diagonal of the panel	Allowed up to 2mm per running meter from the diagonal of the panel	Allowed up to 2mm per running meter from the diagonal of the panel
8	Missing face/inner veneers from panel's edge	Face veneer: not allowed Inner veneer: up to 3mm depth	Face veneer: not allowed Inner veneer: up to 5mm depth	slight soft edge allowed
9	Small dry overlap on face veneer	up to 3mm width	up to 5mm width	Allowed

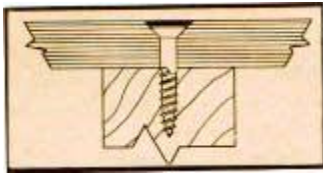
## OPTIMAL HANDLING OF FILMFACED PLYWOOD

Proper handling instructions – so clients can bring the best out of our filmfaced plywood:



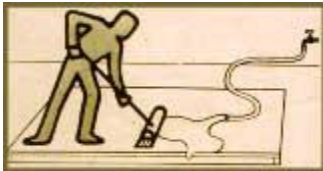
Sealing of the edges

The edges of plywood panels coated with special paint are sealed at the factory. It is very important that panels edges are kept sealed. They should be re-painted after cutting to prevent water from entering the panel.



Sealing of drilled holes

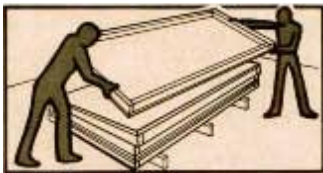
Newly drilled holes have to be sealed properly to avoid penetration of water.



Cleaning

The surface should be cleaned immediately after the detaching the board from the concrete surface.

Film-faced plywood can be cleaned with conventional solvents or with water and a suitable natural brush (not metallic).



Storage

Film-faced plywood surface should be properly cleaned before stored. Panels should be dried slowly and fully before storing.