

Film Faced Plywood with Phenolic Film

Stocked Film Weights & Colours

Covering Films	Colour	Test Taber Abraser - Revolutions
120 g/m ²	Dark Brown	320
150 g/m ²		480
167 g/m ²		600
220 g/m ²		

Surface Structure - One side wiremesh imprint (net/smooth) (Instead of imprint of the net there is a possibility of different types of imprint, e.g. hexagonal of honeycomb structure).

Nets 1.8 x 1.8: Ø 0.8mm, 4.5 x 4.5; Ø 1.8mm.

Stocked Sizes - 1250 x 2500mm & 1500 x 2500 / 3000mm

Thickness - 4 - 50mm

Density - 680 - 760kg/m³

Scope and field of application - Technical specification for phenolic film faced plywood in which film is pressed in hot technology.

Structure - Under film is cross built hardwood plywood.

Materials

Plywood hardwood exterior - Alder & Birch

Plywood hardwood exterior - Combi: Alder, Birch, Pine & Spruce

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.

Transparent phenol film - 40/120 g/m². Standard light brown & green.

Acrylic water resistant paint - for painting of the edges, on request.

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)

Quality requirements

Categories of Characteristic	Range of Tolerance
Mat spots	Permitted up to 20cm ² . up to a number 2 pcs./ 1m 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 & painting	Permitted up to 2mm from the edge
Streaks, fogging colour on film surface	Permitted
Visible unevenness because of the structure of the wood	Permitted

ATTENTION! Colour of film can change because of sunbeams.

Quality requirements outer veneers - II class acc. to PN-EN 635-2 if transparent film.



Dimensions & Tolerances

Formats - 1250 x 2500mm

1500 x 2500/3000mm

Tolerance acc. to EN 315 ± 3.5 mm

Thickness - 6.5 ÷ 35mm

Tolerance acc. to EN 315

Nominal Thickness (t) mm	Tolerances on Nominal Thickness mm	Tolerance Within One Panel mm
≥ 6.5	+ (0.2 + 0.03 t)	0.6
≤ 25	- (0.4 + 0.03 t)	
> 25	+ (0.0 + 0.05 t)	0.8
≤ 30	- (0.4 + 0.05 t)	
> 30	+ (0.0 + 0.03 t)	
> 30	- (0.4 + 0.03 t)	

Squareness - 2mm / 1m

Distortion - Cup, Bow & Twist

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

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

Formaldehyde Release - Formaldehyde class E1 acc. to PN-EN 636

Moisture Content of Plywood - 4-12%

Other conditions can be agreed with the parties.

