

DATA SHEET- TECHNICAL PLYWOOD – FOILED WITH MELAMINE FILM OR LAMINATED

Wood-based panels consisting of layers of wood glued together (outer and inner veneers), with the fibers of the adjacent layers usually running at right angles. Outer veneers are made of birch, alder or beech wood. The surface of panels is foliated with a melamine film or with laminate, which protect against the adverse effects of weather conditions, increase the abrasion resistance of the surface, and facilitate cleaning. In the case of a panel covered with a melamine film, the right side of can be smooth or wire mesh - in the production process is imprinted a wire mesh or a hex pattern.

Types of plywood depending on the type of bonding:

- moisture resistant plywood - on the basis of urea-formaldehyde resin, for use in dry conditions (according to PN-EN 636), meeting the requirements of 1 gluing class quality according to PN-EN 314-2
- weather-boil-proof with a bright glue line – on the basis of melamine-urea-phenol-formaldehyde resin, for use in exterior conditions (according to PN-EN 636), meeting the requirements of 3 gluing class quality according to PN-EN 314-2
- weather-boil-proof - on the basis of phenol-formaldehyde resin, for use in exterior conditions (according to PN-EN 636), meeting the requirements of 3 gluing class quality according to PN-EN 314-2

Types of plywood depending on surfaces quality:

- laminated plywood is produced in quality class I and II according to ZN-2011/BZS-ST-2
- plywood covered with melamine film is produced in quality class I and II according to ZN-2011/BZS-SFM-1

Types of plywood with melamine film depending on type of surface:

- one-side foiled smooth
- one-side foiled with a wire mesh imprint
- one-sided foiled with a hexa imprint
- smooth on both sides
- double-sided foiled with a one-sided wire mesh imprint
- double-sided foil with a one-sided hexa imprint

Types of plywood with laminate depending on type of surface:

- covered with laminate on both sides
- covered with laminate on one side, left side covered with back-pressure film

Type of plywood covered with melamine film depending to weight of the film

- plywood foiled with melamine film, standard 200g / m²

Plywood covered with laminate

- laminate thickness 0.5 - 1.0 mm

Types of melamine films

- gray melamine film
 - white melamine film
 - black melamine film
- Other types of melamine films as agreed with the customer

Thickness and tolerances

Plywood is produced in the thickness range from 4 to 35 mm. Thickness tolerances are defined in the standard EN 315.



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Humidity

10±5% (according to EN 322).

Density

- density of plywood covered with melamine film 650 – 800 kg/m³ (acc. to EN 323)
- density of plywood covered with laminate 700 – 900 kg/m³ (acc. to EN 323).

Some of strength parameters

SKLEJKA LIŚCIASTA Deciduous plywood			ZGINANIE Bending		MODUŁ Modulus	
GRUBOŚĆ Thickness	ILOŚĆ WARSTW * Number of plies	UKŁAD WARSTW * Lay-up	f _{m,0} N/mm ²	f _{m,90} N/mm ²	E _{m,0} N/mm ²	E _{m,90} N/mm ²
4	3	I-I	90,1	15,2	11323	1121
5	4	I-I-I	88,2	16,3	9565	4315
6	5	I-I-I-I	84,8	26,1	9787	5714
9	7	I-I-I-I-I	78,6	33,2	9486	5930
12	9	I-I-I-I-I-I	76,2	40,8	9170	6114
15	11	I-I-I-I-I-I-I	74,2	42,6	8710	6490
18	13	I-I-I-I-I-I-I-I	68,4	53,3	8542	6713
21	15	I-I-I-I-I-I-I-I-I	64,5	54,4	8443	6853
24	17	I-I-I-I-I-I-I-I-I-I	62,7	54,3	8453	6896
27	19	I-I-I-I-I-I-I-I-I-I-I	60,7	57,5	8300	6900
30	21	I-I-I-I-I-I-I-I-I-I-I-I	60,5	57,9	8218	7071
35	23	I-I-I-I-I-I-I-I-I-I-I-I-I	59,6	61,2	8124	7321

* the number and arrangement of the layers may be different from that shown

Standard formats

2500x1250mm, 1250x2500mm, 2440x1220mm, 1220x2440mm, 2130x1250mm, 1250x2130mm or as agreed with the customer.

Length and width tolerance: ± 3,5 mm (acc. to EN 315).

Edge straightness: ± 1,0 mm/m of side length (acc. to EN 315).

Processing options:

Cutting into smaller formats; simple and profile processing of edges, drilling holes, milling grooves, grooves, rebates; machining on CNC machining centers. In the case of plywood covered with a melamine film, narrow surfaces are secured with waterproof acrylic paint as standard. Painting narrow planes aims to reduce moisture absorption during transport and storage. After additional processing of the plywood, the recipient should protect narrow surfaces (edges, holes, etc.). Narrow surfaces of plywood covered with laminate are not painted.

Application

Construction, flooring, packaging, boatbuilding, vehicle construction, shipbuilding, furniture, playgrounds, production of wooden accessories and others.

