

COMPOSITION

Particleboard coated with decorative paper on both sides and acrylic lacquering covering on its front face. When they are supplied as finished components, PUR glue and ABS, PP or PMMA edge-band are used to cover the edges.

RECOMMENDED APPLICATIONS








Components for indoor furniture and decoration.

BASE BOARD CHARACTERISTICS

DIMENSIONAL TOLERANCES

















| | PROPERTY | VALUE | STANDARD |
|--|------------------|----------|----------|
|  | Length and Width | ± 2 mm/m | EN 324-1 |
|  | Thickness | ± 0,3 mm | EN 324-1 |
|  | Squareness | ± 2 mm/m | EN 324-2 |

PHYSICAL & MECHANICAL PROPERTIES

| | PROPERTY | THICKNESS (mm) | | | STANDARD |
|---|---|-------------------------------------|----------|----------|------------|
| | | 10 - 12 | 16 - 18 | 19 - 25 | |
|  | Density (kg/m³) | 690 ± 50 | 650 ± 50 | 630 ± 50 | 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 |
|  | Modulus of elasticity (N/mm²) – min. | 1800 | 1600 | 1500 | EN 310 |
|  | Residual moisture (%) – range | 5 – 13 | | | EN 322 |
|  | Standard formaldehyde content (mg/100g) – max. (Classes available under order) | E1 (E0.5 – CARB2 – TSCA – F****) | | | EN 120 |
|  | Fire behavior (class) | D-s2, d0 | | | EN 13501-1 |

COATING CHARACTERISTICS

PHYSICAL & MECHANICAL PROPERTIES

| | PROPIEDAD | RESULT | NORMA |
|---|---|--------------------------------|----------------|
|  | Stain resistance | Grade 5 | EN 14323:17 |
|  | Resistance to cold liquids | Grade 5 | EN 12720:09 |
|  | Cross cut test (adherence) | Grade 1 | ISO 2409:13 |
|  | Crack resistance | Grade 5 | EN 14323:17 |
|  | Cold check (40 cycles: 1h 60 °C, 1h -20°C, 15' room tem.) | No damage | AIDIMME |
|  | Light fastness | Blue scale: 8 Grey scale: 5 | EN 14323:17 |
|  | Dry heat resistance (100 °C) | Grade 5 | EN 12722:09 |
|  | Damp heat resistance (85 °C) | Grade 5 | EN 12721:09 |
|  | Scratch resistance (diamond point cone, radius 0,09 mm) | 2.0 ± 0.5 N | ISO 1518-1 |
|  | Abrasion resistance | Class 3B | EN 14323:17 |
|  | Resistance to water steam | Grade 5 | EN 14323:17 |
|  | Resistance to impact stress (large diameter steel ball) | 40 cm | EN 14323:17 |
|  | Measures tolerance (edged parts) | ± 0,5 mm | ALVIC |
|  | Warping tolerance | 2 mm / 1 m | ALVIC |
|  | Plain color tolerance | ΔE ≤ 0,70 | CIELab D65/10° |
|  | Gloss (60°) | 2 ± 0.5 GU | ISO 2813 |

EVALUATION OF SURFACE DEFECTS

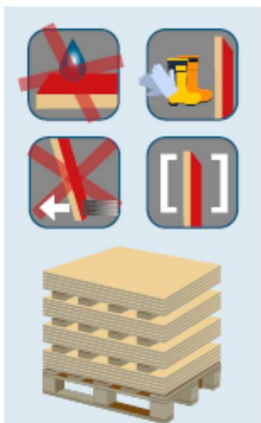
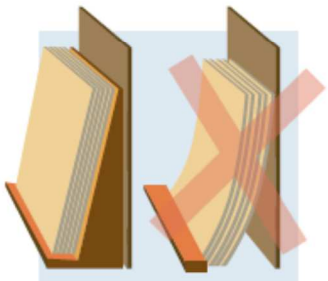
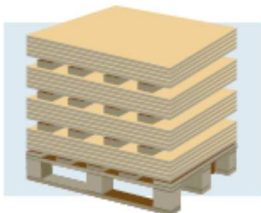
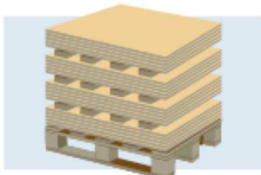
The following framework conditions apply:

1. Viewing distance: 700 mm
2. Lighting intensity: 1000 – 2000 lx
3. Inclination angle: 30° to the vertical
4. Type of light (daylight, color temperature) D 65: 6500 K
5. Viewing duration: max. 20 seconds

QUALITY STANDARD (AMK-MB-009)

On an even surface, defects must not appear at a distance of 0.7 meters. Where surfaces without any defects cannot be realized, small flaws and irregularities in the surface are admissible. Surface defects are only those defects, which are greater than 1.0 mm² and recognized when examining the surface at a distance of 0.7 meters and an angle of view of about 30°. The defined maximum is 1 defect/m².

USE RECOMMENDATIONS



STORAGE

The panels 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%

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

The panels/components must be consumed within 12 months of delivery to prevent the adhesive of the protective film from causing residue problems or excessive adhesion.

HORIZONTAL STORAGE

The panels 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 boards. 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. To protect the surface of the panels, use upper and lower panels protections.

VERTICAL STORAGE

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

HANDLING & TRANSPORT

Avoid at all times the negative impact that moisture may have on the panels by preserving the integrity of the shrink wrap protective film until final use. If any previous operations of loading, transport, unloading, etc. have caused the protective film to deteriorate, the pack should be re-wrapped as soon as possible. Likewise, cut pieces should also be protected from moisture until they can be edged.

In manual handling of the boards protective gloves and safety shoes must be worn in order to avoid injury. During machining of the panels, appropriate suction systems must be used and, if necessary, protective masks to prevent breathing in of dust generated from the panel.

The panels must not be dragged on any surface that may cause deterioration of any of their faces. During all handling and machining it is essential to prevent particles, machined material and protective film residues or any other dirt from being caught between the pieces, since, with the cumulative weight of several units, visible marks may be produced on the lacquered surface. This precaution is especially critical for high gloss coatings.

USE RECOMMENDATIONS

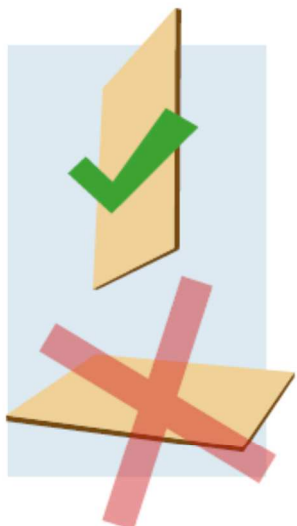


CLEANING

The protective film of the panels must be removed once installation is complete or a maximum of 6 months after delivery, in order to ensure that no adhesive residue remains on the surface.

For cleaning, it is recommended to use a nonabrasive cloth moistened with soap and water and immediate subsequent drying. Melamine sponges are recommended for persistent stains.

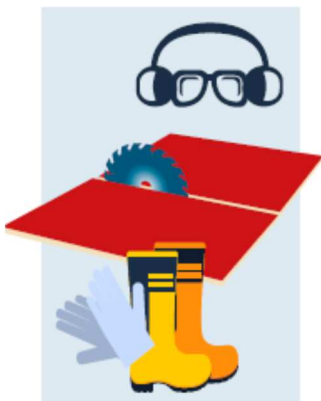
Under no circumstances must harsh chemicals be used such as solvents, alcohol, ammonia, etc.



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.



MACHINING RECOMMENDATIONS

The panel can be cut with any normal cutting disc, provided that it is adequately sharpened. It is recommended to use discs with an angle of attack that is not too aggressive in order to avoid splintering. An example of a suitable disc would be the Freud LU3F with -3° back-slanted teeth.

As guidance, for squaring, the LU3F model can be used with disc diameter = 300 mm, plate width = 3.2 mm, body width = 2.2, axle = 30 mm and number of teeth = 96. For edging, it is advisable to use a diamond cutter, the more teeth, the better the result. With a Homag edger, two suitable options are as follows:

Leuco Leucodia Power-Tec Model CM 250x14x80 Z = 18+18 (good result)

Leuco Leucodia Power-Tec Model S 250x14x80 Z = 24 +12+6 (optimal result)

The choice of one or the other depends on the durability the user gets from each.

It is essential to discard at least one centimeter around the perimeter of the board.



UPDATES

This document may be modified at any time by the company without any express obligation to send any updated edition to all original recipients. To verify that you have the latest edition available, you are advised to contact the customer service department of Alvic Group.