

TECHNICAL DATA

Blockboard for use as non-structural components produced by Sklejka Orzechowo S.A.

1. Standard Information's

--	Type of Blockboard	
	interior	exterior
Type of Resin	Urea-formaldehyde	Phenolic-formaldehyde
Type of Wood	inner – Pine, Spruce outer – Alder, Birch	
Dimensions* [mm]	1 220 × 2 440 1 250 × 2 500	
Thickness [mm]	from 13 to 38 mm	
Classes of top layers	I / I; I / II; I / II +; II / II; II + / II +	
Surface	sanded	
Emission class	E1, EN 717-1	E1
Thickness of veneer [mm]	1,4	
Biological durability (EN 335)	Hazard class 1	Hazard class 2

* other dimensions – on demand of client

2. Declared performance:

Essential characteristics	Performance	Norms for technical Specifications	
Humidity	6 – 10 %	EN 322	
Density	500 – 600 kg / m ³	EN 323	
Reaction to fire	D-s2,d0 (EN 13986 Tab. 8 for density ≥ 400 kg/m ³ and thickness ≥ 9 mm)		
Water vapour permeability	Interpolated from EN 13986 Tab. 9 for density 600 kg/m ³		
	μ wet cup	80	μ dry cup
Sound absorption coefficient	EN 13986 tab. 10		
	250 – 500 Hz: 0,10		1000 – 2000 Hz: 0,30
Airborne sound insulation	Calculated per EN 13986 point 5.10		
Content of pentachlorophenol (PCP)	EN 13986 section 5.18	< 5 ppm	



Bending strength	Along fibers	Cross fibers	EN 310
	min. 20 MPa		

3. Types of blockboards and bond quality

Division of blockboards depending on the type of adhesive joint:

Interior blockboard for use in dry conditions. Blockboard based on urea-formaldehyde resin. Blockboard intended for use in conditions where the moisture content in the material corresponds to the humidity equivalent to that obtained at a temperature of 20 °C and the relative humidity of the surrounding air exceeds 65% only for a few weeks a year. Boards of this type are suitable for use in conditions specified for class 1 of biological attack hazard according to EN 335-3. The bonding quality must meet the requirements of class 1 according to EN 314-2.

Exterior blockboard for outdoor use. Blockboard based on phenol-formaldehyde resin. This type of blockboards are suitable for use in conditions specified for biological attack hazard class 2 according to EN 335-3. In the environment typical of this class, the moisture content of the board can often be over 20%, so they will often be susceptible to attack by wood-decay fungi. The bonding quality must meet the requirements of class 3 according to EN 314-2.

Glue joints of all types of plywood must meet the criteria given in the table below for all gluing classes.

Bond quality per EN 314-1,2	
Average shear strength N / mm ²	Average percentage of wood after shear %
$0,2 \leq f_v < 0,4$	> 80
$0,4 \leq f_v < 0,6$	> 60
$0,6 \leq f_v < 1,0$	> 40
$1,0 \leq f_v$	no requirements

4. Tolerance

Tolerance per EN 315											
Thickness [mm]	4	5-8	9-11	12-14	15-18	19-21	22-24	25	26	27-28	29-30
Tolerance [mm]	+0,3 -0,5	+0,4 -0,6	+0,5 -0,7	+0,6 -0,8	+0,7 -0,9	+0,8 -1,0	+0,9 -1,1	+1,0 -1,2	+1,3 -1,2	+1,4 -1,2	+1,5 -1,3
Dimensions tolerance						± 5,0 mm				EN 314-1	
Waviness of board for thickness >10 mm						< 10 mm / m					

5. Packing – according to customer requirements

6. Transport

Loading and unloading must be carried out in such a way as not to damage the boards. The transporting vehicle must protect the load against water, moisture and unfavourable weather conditions.

Packages of blockboard must always be prepared according to the packing method, and pallets must be fastened to the floor of the car to prevent them from shifting during transport.

7. Storage

The blockboards should be stored in a horizontal position, and the room should protect it from direct exposure to water, excess moisture and drastic temperature changes. The boards should not be placed directly on the substrate.

The final humidity of the board should be within the range of 10%.

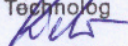
Optimal storage conditions:

- Relative air humidity – $40 \div 65\%$
- Air temperature – $20 \pm 5 \text{ }^\circ\text{C}$

Storing blockboard in warehouses should be organized in such a way that the product does not lose its physical and mechanical properties and, above all, is not exposed to moisture and high temperatures, as this may cause irreversible changes to the product. The board should be protected against mechanical damage.

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