



Thomes Canada

Baltic Plywood features and Characteristics

Birch plywood, MR glue, Clear in Color made with Urea Melamine, or Urea Carbamide, or Urea Formaldehyde Glues

Russian Birch plywood is a high-quality structural material. Only 100% birch veneer sheets in all layers of plywood are used in the construction, and the use of high-quality glue and state-of-the-art equipment allows us to manufacture this world class product, which meets the world quality standards.

1. Technical properties

◇ Sizes

1525 x 1525 mm : standard size produced.

2440 / 2500 x 1220 / 1250 mm : by special order only using MR glue.

◇ Thickness

From 3 mm up to 40,0 mm*.

◇ Grade

I (B) ; II (BB) ; III (CP) ; IV (C).

◇ Formaldehyde emission

E1

◇ Density

640 - 700 kg/m³.

◇ Moisture content

Max 10%.

* : The possibility to manufacture sizes and thicknesses according to the customer's requirements.

2. Advantages

Russian or Baltic Birch Plywood features great strength and wear-resistance; Moisture resistance; High surface quality and integrity. All external and internal plywood layers are birch veneer sheet which results in the stability of board's geometry. All our panels are in compliance with the gluing durability indices according to DIN 68705 part 3 BFU 100.



Birch plywood, WBP glue, Phenol Formaldehyde, Phenol Resin Glue

Russian Birch plywood is a high-quality structural material. Only 100% birch veneer sheets in all layers of plywood are used in the construction, and the use of high-quality glue and state-of-the-art equipment allows us to manufacture this world class product, which meets the world quality standards.

1. *Technical properties*

◇ **Sizes**

2440 / 2500 x 1220 / 1250 mm.

1200 / 1220 / 1250 / 1500 / 1525 x 2440 / 2500 / 2745 / 3000 / 3050 mm.

◇ **Thickness**

From 4 mm up to 40,0 mm *.

◇ **Grade**

I (B) ; II (BB) ; III (CP) ; IV (C).

◇ **Formaldehyde emission**

E1

◇ **Density**

640 - 700 kg/m³.

◇ **Moisture content**

Max 10%.

* : The possibility to manufacture sizes and thicknesses according to the customer's requirements.

2. *Advantages*

Russian or Baltic Birch Plywood features great strength and wear-resistance; Moisture resistance; High surface quality and integrity. All external and internal plywood layers are birch veneer sheet which results in the stability of board's geometry. All our panels are in compliance with the gluing durability indices according to DIN 68705 part 3 BFU 100.



Film faced plywood

Film faced plywood is exterior birch plywood, overlaid with phenol or melamine film on one or both sides. The Film faced surface of the panel prevents moisture penetrating, has high resistance to abrasion, chemicals and fungus formation. Edges of film-faced plywood are varnished with water-resistant acryl-based paint. A wide range of film colors and types of surface (smooth, wire mesh, paper coated) are available which allows a wide range of end use areas of film faced plywood.

1. Technical properties

◇ Sizes

1200 / 1220 / 1250 / 1500 / 1525 x 2440 / 2500 / 2745 / 3000 / 3050 mm.
2440 / 2500 x 1220 / 1250 mm.

◇ Thickness

From 6,5 mm up to 40,0 mm *.

◇ Formaldehyde emission

E1

◇ Density

680 - 700 kg/m³.

◇ Moisture content

Max 10%.

* : The possibility to manufacture sizes and thicknesses according to the customer's requirements.

2. Advantages

Highly technical properties. High wear resistance. Excellent resistance to chemical and other aggressive environmental properties. Stability of board's geometry. Optimal ratio of weight to strength. Resistance to ultraviolet radiation* (applicable to melamine film). Comparative ease for further mechanical treatment. Possibility to manufacture sizes, thickness according to customer's requirements, (type of surface, color, film density). It has compliance with GOSTs and product manufacturing regulations as well as international quality standards.



Baltic Birch Plywood
Also known as Russian Birch

Russian Birch, also known as Baltic Birch, is a multi-ply plywood known for its strength and edge quality. It's used for drawer sides, toys, children's furniture, seat bottoms & backs, jigs and fixture boards. In fact, it can be used anywhere for superior strength or exposed edge applications. Once you've used it, you'll wonder where it's been all your life!



- Russian Birch Grades

GRADE B - Select One side has a uniform appearance and is typically free from defect.



GRADE BB - One side is generally light and uniform in colour. Pin knots and small sound tight knots are allowed. Occasional football patches are colour matched to the veneer. Sanding is smooth, 100 – 120 grit.



GRADE CP - One side is similar to grade BB in quality. Sound knots and patches may be more common than BB grade. Small open splits, knot holes and double patches are allowed. It may have some streaks and discolorations. Sanding is smooth.



GRADE C – Open defects (all sound), streaks and discolorations are allowed. Not sanded.



Picture showing the difference of Exterior vs. Interior Glue Lines:



Glue description and product usage in Baltic Birch Plywood

- *Water-resistant glues*

> **Melamine formaldehyde glues** are not extensively used for plywood gluing but are used where a high-grade bond is required, and where black phenolic glues cannot be tolerated. They are used to fortify urea-formaldehyde glues to increase the weathering resistance of the bond. The largest application of the melamine formaldehyde resin is in the production of decorative overlays.

> **Urea formaldehyde glues** are extensively used for interior and intermediate grade bonding, which covers the majority of hardwood plywood produced. Formulas differ somewhat and can be adapted to meet specific conditions. Usual use is regular 5 x 5 size Baltic Birch Plywood.

- *Waterproof glues*

> **Phenol-formaldehyde glues** are standard for exterior bonds. With a glue properly formulated for exterior use and suitably employed, no exposure conditions or laboratory tests are known which will degrade hot pressed phenolic glue bonds without destroying the adjacent wood layers. Phenolic glues are also used for impregnating veneers and paper overlays for plywood. Usual use is seen in 4 x 8, or 8 x 4, or 10 x 5 Baltic Birch Plywood.

The phenol formaldehyde gluing fulfils the requirements of EN 314-2 class 3 exterior. The gluing quality may still be referred to earlier national classification such as DIN 68705: BFU 100 or BS 6566: WBP.

Baltic Birch phenol formaldehyde glued plywood products exhibit very low levels of formaldehyde emissions. Urea formaldehyde glued products have slightly higher values but they still fulfill the requirements of the most demanding European standards E1 class relating to formaldehyde emission and content.

Synthetic wood adhesives, also known as resins, are man-made polymers which resemble natural resins, but are created to meet specific woodworking needs. They have superior moisture resistance and create very strong bonds. Synthetic glues can be placed into one of two categories – thermosetting and thermoplastic.

Thermosetting adhesives include urea-formaldehyde, phenol, resorcinol, melamine and epoxy. Urea is the most popular wood adhesive, as it provides moderate moisture resistance and can cure in minutes at high temperatures. Phenol and resorcinol glues are expensive but versatile, and provide extremely durable bonds. Melamine glue is rarely used alone, but must be combined with urea to increase moisture resistance. Epoxy is the most expensive thermosetting wood adhesive, and is typically impractical for large scale woodworking projects.

Thermoplastic adhesives include polyvinyl acetates and thermal hot melts. Polyvinyl acetate adhesives are the common white glues used in the woodworking industry. Sometimes referred to as simply "wood glue," polyvinyl has poor heat and moisture resistance, but is the easiest of the synthetic adhesives to use. Thermal hot melt adhesives are solid glues which must be heated and applied as drops or beads, and form a bond as the glue cools. The main advantages of thermal wood adhesives are their ease of handling and fast curing time.

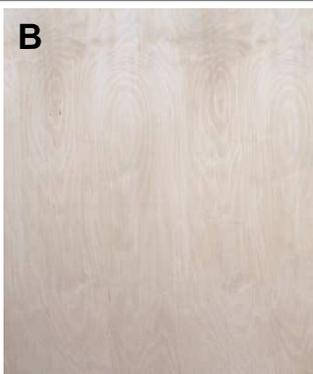
The vast majority of Baltic Birch Plywood, large format 4 x 8 or 5 x 10, is of cross-banded construction bonded with phenol resin adhesive. Normal gluing quality is suitable for use in exterior (service class 3) situations when properly protected.

Our Baltic Birch, (5 x 5 format), cross-banded plywood production is bonded with urea formaldehyde glue. These boards are suitable for use in dry (service class 1) or humid (service class 2) conditions.

Limitations on defects for Riga Ply



| Categories of defects | Plywood grades | | | | |
|------------------------------------------------------------|--------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------|
| | B | S | BB | WG | C |
| Pin knots (Sound intergrown knots $\leq \varnothing 3$ mm) | Permitted | Permitted | Permitted | Permitted | Permitted |
| Sound intergrown knots | Permitted $\leq \varnothing 6$ mm, $\Sigma \leq 12$ mm/m ² | Permitted $\leq \varnothing 20$ mm, $\Sigma \leq 50$ mm/m ² | Permitted $\leq \varnothing 25$ mm, $\Sigma \leq 60$ mm/m ² | Permitted $\leq \varnothing 65$ mm, $\Sigma \leq 600$ mm/m ² | Permitted |
| Unsound adhering knots | Not permitted | Not permitted | Not permitted | Permitted $\leq \varnothing 20$ mm, $\Sigma \leq 200$ mm/m ² | Permitted |
| Other knots and holes | Not permitted | Not permitted | Permitted $\leq \varnothing 6$ mm, $\Sigma \leq 25$ mm/m ² , repaired | Permitted $\leq \varnothing 15$ mm, $\Sigma \leq 100$ mm/m ² | Permitted $\leq \varnothing 40$ mm, ≤ 10 /m ² |
| Irregularities in the structure of the wood | Permitted, but slight | Permitted | Permitted | Permitted | Permitted |
| Curly grain | Not permitted | Not permitted | Permitted | Permitted | Permitted |
| Open splits and checks | Not permitted | Permitted for an individual width up to 2 mm and of an individual length ≤ 200 mm and ≤ 1 per metre of panel width, repaired | Permitted for an individual width up to 2 mm and of an individual length ≤ 200 mm and ≤ 1 per metre of panel width, repaired | Permitted for an individual width up to 4 mm and ≤ 2 per metre of panel width | Permitted for an individual width up to 10 mm and of an individual length ≤ 400 mm and ≤ 5 per metre of panel width |
| Closed splits and checks | Not permitted | Permitted for an individual length up to 200 mm and in number up to 2 per metre of panel width | Permitted for an individual length up to 200 mm and in number up to 2 per metre of panel width | Permitted | Permitted |
| Discolouration | Permitted, but slight (not at the edges of panel) $\leq 15\%$ of panel surface | | | | |
| Discolouration and coloured streaks | Not permitted | Permitted up to an extent of 15% of the panel surface, some streaks of colour and minerals | Permitted up to an extent of 30% of the panel surface | Permitted | Permitted |
| Brown, but not rot | Not permitted | Not permitted | Permitted up to an extent of 30% of the panel surface | Permitted | Permitted |
| Brown, rot at the initial period | Not permitted | Not permitted | Not permitted | Not permitted | Permitted |
| Inserts | Not permitted | Permitted ≤ 1 /m ² | Permitted up to an extent of 3% of the panel surface | Permitted | |
| Open joints | Not permitted | Not permitted | Permitted an individual width up to 2 mm, and of an individual length ≤ 200 mm and ≤ 1 per metre of panel width, repaired | Permitted an individual width up to 3 mm | Permitted an individual width up to 7 mm |
| Imprints and bumps | Not permitted | Not permitted | Permitted, but slight, 2 cm ² per panel | Permitted, but slight | Permitted |
| Roughness | Not permitted | Not permitted | Permitted, but slight (up to 10 cm ² /m ² , repaired) - three defects per panel | Permitted | Permitted |
| Sanding through | Not permitted | Not permitted | Permitted ≤ 10 cm ² /m ² | Permitted ≤ 20 cm ² /m ² | |
| Glue penetration | Not permitted | Occasionally | Permitted up to an extent of 5% of the panel surface | Permitted | Permitted |
| Unsanded areas (for sanded plywood) | Not permitted | Not permitted | Not permitted | Permitted up to an extent of 5% of the panel surface | |
| Defects at the edges due to sanding or trimming | Permitted up to 5 mm from the edge (if the glue is not visible) | Permitted up to 5 mm from the edge, not in all length, repaired | Permitted up to 5 mm from the edge, not in all length, repaired | Permitted up to 5 mm from the edge | Permitted up to 5 mm from the edge |
| Composed face veneers | | Permitted, if composed properly, conformable colour | Permitted | Permitted | Permitted |
| Total number of permitted defects | ≤ 3 | ≤ 6 | ≤ 9 | Unlimited | Unlimited |



KoskiPly birch

Thin birch plywood for multitude of applications



KoskiPly is a strong yet flexible cross-banded plywood, made throughout from birch veneers and faced with a joint-free birch veneer. Veneers can be left in its natural state, lacquered, waxed or stained.

Advantages

- homogeneous surface of a consistent high quality
- strong, excellent bending strength
- light and decorative
- easy machining and surface treatment
- taint and odour free

KoskiPly can be used both indoors and outdoors. The flexibility of the material is such that 1.5 mm thick KoskiPly can be bent through 180 degrees, this greatly extends the range of design possibilities.

Examples of end uses

- kitchen cabinets, door mirrors
- partition walls, sight screens
- furniture parts
- sound insulation latticework
- toys, souvenirs, cards
- models
- musical instruments
- interiors
- saddles
- icehockey sticks

KOSKIPLY BIRCH TECHNICAL DATA

Base plywood

Finnish birch veneer

Bonding

Exterior as standard
Interior at request

Qualities

Standard quality AB/B furniture grade rotary cut birch veneer, without joints.
Other face qualities at request. GL1- and GL2-qualities at request.

Thicknesses

0.4 mm 3 ply
0.6 mm 3 ply
0.8 mm 3 ply
1.0 mm 3 ply
1.5 mm 3 ply
2.0 mm 4 ply
2.5 mm 5 ply
3.0 mm 6 ply
3.5 mm 7 ply
4.0 mm 8 ply
4.5 mm 9 ply
5.0 mm 10 ply
Customised thicknesses and constructions at request.

Sizes

1200/1220/1270 x 1200/1220/1270 mm
1500/1525/1550 x 1500/1525/1550 mm
1820 x 910 mm
2400 x 1200 mm
Max size of 0.4 mm - 1.0 mm 3 ply is 1550 x 1550 mm.
Other sizes at request.

Weight

Approx. 700 kg/m³

Packaging

| Thickness | pcs/bundle |
|-----------|------------|
| 0.4 mm | 25 pcs |
| 0.6 mm | 25 pcs |
| 0.8 mm | 50 pcs |
| 1.0 mm | 100 pcs |
| 1.5 mm | 100 pcs |
| 2.0 mm | 100 pcs |
| 2.5 mm | 100 pcs |
| 3.0 mm | 50 pcs |
| 3.5 mm | 50 pcs |
| 4.0 mm | 50 pcs |
| 4.5 mm | 50 pcs |
| 5.0 mm | 50 pcs |

5.5 mm and thicker at request.
One pallet contains 4-6 bundles.

Certificates

EN ISO 9001, EN ISO 14001, Annex 4 of PEFC Technical Documentation 2004

The information, although based on extensive testing, is intended as a guideline only and comes without warranty. We reserve the right to amend specifications without notice. Any defects other than caused by clearly verified production or service faults by the supplier are the responsibility of the user. Any claim for compensation is limited to the value of the defective products.

KOSKISEN BIRCH PRODUCTS

Otavantie 395, 52550 Hirvensalmi, Finland
tel. +358 15 340 900, fax +358 15 340 920
www.koskisen.com



Film Faced Birch Plywood

Formply

Birch standard plywood overlaid on both the sides with a smooth phenol film which is hot pressed onto the surface thus achieving a high resistance to wear. The film is composed of a base paper and phenol resin that is impregnated into the base paper. It is moisture proof and resists chemicals, and the surface is easy to clean.

Panels are fully edge-sealed with an acrylic sealant to prevent moisture penetration. The most common film weight is 120g/m² available in Chestnut brown. Other colors are available. They are used for concrete shuttering, building boards, flooring, packing, pallets and in the transport industry.



Film Tex

Birch standard plywood overlaid with a phenol film that gets a wire mesh pattern on the wear side. The rough wire mesh overlay coating is extremely wear resistant and improves anti-slip characteristics.

It is also moisture proof and resists chemicals. It is an ideal material for various kinds of floors, such as vehicle floors, loading platforms, pedestrian bridges, storage and factory floors.





RIGA[®]

FORM

Product:

The basic plywood RIGA PLY bonded with waterproof phenol resin adhesive and overlaid on both the sides with a phenol film (grade F/F).

Overlaying colour:

Normally chestnut brown (120g/m²) or dark brown (167g/m²). Other standard colour are light brown transparent (120g/m²), dark brown (220g/m²), yellow non-transparent (167g/m²) and transparent (120g/m²), green (120g/m²), colourless (120g/m²), black (120g/m²), grey (174g/m²), red (220g/m²). Other colours on request.

Under transparent films BB grade veneer is applied.

Applications:

Chestnut brown (120g/m²) - for concrete shuttering, transport industry.

Dark brown (167g/m² and 220g/m²), black (120g/m²) - for concrete shuttering, building boards, transport industry, flooring.

Light brown transparent (120g/m²), green (120g/m²), red (220g/m²) - for concrete shuttering, building boards, transport industry, flooring.

Colourless (120g/m²), yellow non-transparent (167g/m²), yellow transparent (120g/m²), grey (174 g/m²) - for building boards, transport industry, flooring.

Advantage:

Environmentally friendly, durable, workable, hygienic, not smelling and don't give taste to food-stuff, easy to clean, wear-proof, weather and water-proof, resists commonly used chemicals. RIGA FORM for shuttering can be re-used many times.

Gluing classes:

Basic plywood is bonded with a phenol resin adhesive resistant to weather, boiling water and meets the requirements of the following standards:

BS 1203/H4 (WBP)

EN 314 - 2 / 3rd class

DIN 68705 Part 3 / type BFU 100

Formaldehyde emission:

In accordance with the standard EN 13986 formaldehyde emission meets the Class E1 requirements. Test method EN 717 Part 2.

LATVIJAS FINIERIS

AKCIJU SABIEDRĪBA



Bauskas iela 59, Rīga, LV 1004, LATVIA
Tel.: +(371) 7620857; Fax: +(371) 7820112
E-mail: info@finieris.lv
Home page: <http://www.finieris.lv>

RIGA[®] FORM

Overlaying:

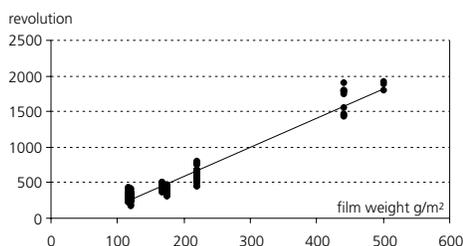
A smooth phenol film, which is hot-pressed onto the surface, is used as an overlay. The film is composed of a base paper and phenol resin that is impregnated into the base paper. Film weights 120g/m², ~ 170g/m², 220g/m². Overlaying with higher resistance to abrasion and multi-layer overlaying are also possible (respectively 240g/m², 440g/m² etc.). Multi-layer overlaying gives superior wear resistance.

Edges sealing:

Edges of the panels are matched with the face against absorption of moisture by using acrylic paint. Other colours are available and the edges may be unsealed at customers' request.

Overlaying characteristics:

Overlaying surface is smooth, glossy and hard. It withstands abrasion, it is weather and moisture proof and resists commonly used chemicals, dilute acids and alkalis. The surface is easy to clean with water or steam wash. Abrasion resistance according to the Taber test (EN 438-2): depends on applied film, conditions of product storage and application, thickness of film (see below) a.o.



It is possible to obtain overlaid plywood resistance to wear even above 10 000 revolutions

Company's specialists will assist you to choose the most appropriate product.

Sizes:

- 1200 mm x 1200/1500/1800/2100/2400/2700/3000 mm
- 1220 mm x 1220/1525/1830/2135/2440/2745/3050 mm
- 1250 mm x 1250/1500/1800/2150/2500/2750/3000 mm
- 1500 mm x 1500/1800/2100/2500/2700/3000 mm
- 1525 mm x 1525/1830/2135/2440/2745/3050 mm

Cut to size panels, machining, tongue & groove, jointing available in accordance with the customers' requirements.

Thickness:

- 4; 6.5; 9; 12; 15; 18; 21; 24; 27; 30; 35; 40 mm

Tolerance:

Size and right angle tolerance meets the standard EN 315 requirements.

| | | | | | | | | | | | | |
|------------------------------|-----|-----|-----|------|------|------|------|------|------|------|------|------|
| Nominal thickness, mm | 4 | 6,5 | 9 | 12 | 15 | 18 | 21 | 24 | 27 | 30 | 35 | 40 |
| No. of plies | 3 | 5 | 7 | 9 | 11 | 13 | 15 | 17 | 19 | 21 | 25 | 29 |
| Average actual thickness, mm | 3,8 | 6,4 | 9,2 | 12,0 | 14,9 | 17,7 | 20,5 | 23,4 | 26,5 | 29,4 | 35 | 38,7 |
| Lower limit, mm | 3,5 | 6,1 | 8,8 | 11,5 | 14,3 | 17,1 | 20,0 | 22,9 | 25,8 | 28,7 | 33,6 | 38,4 |
| Upper limit, mm | 4,1 | 6,9 | 9,5 | 12,5 | 15,3 | 18,1 | 20,9 | 23,7 | 26,8 | 29,9 | 35,4 | 41,2 |

| Parameter | Tolerance |
|-------------------------------|-----------|
| Length, width, (mm) < 1000 | ± 1 mm |
| 1000...2000 | ± 2 mm |
| >2000 | ± 3 mm |
| Right angle | ± 0.1% |
| Edge straightness | ± 0.1% |

Plywood is manufactured by a/s Latvijas Finieris whose Quality Management System is certified to the requirements of ISO 9001 by Bureau Veritas Quality International.





RIGA[®]

TEX

Product:

Birch plywood (RIGA PLY) overlaid with a phenol film on both the sides. The wear side has a rough wire mesh pattern (W); the reverse side normally is smooth (grade F/W), although it can have wire mesh pattern, too (grade W/W). Sealed edges. RIGA TEX rough wire mesh overlay withstands hard wear and it can be used for many different floor-panelling purposes.

Applications:

Vehicle floors, pedestrian bridges, storage and factory floors, storage shelves, loading platforms, ship decks, pier surfaces. In general - applications where high wear resistance and/or good anti-slip properties are required.

Advantage:

The wire mesh surface has high wear resistance and anti-slip properties, surface is weather and waterproof, resists to commonly used chemicals. Environmentally friendly.

Gluing classes:

Basic plywood is bonded with a phenol resin adhesive resistant to weather, boiling water and meets the requirements of the following standards:

BS 1203/H4 (WBP)

EN 314 - 2 / 3rd class

DIN 68705 Part 3 / type BFU 100

Formaldehyde emission:

In accordance with the standard EN 13986 formaldehyde emission meets the Class E1 requirements. Test method EN 717 Part 2.

Overlaying:

The panels are overlaid with a phenol film and have a wire mesh pattern imprinted during hot pressing process. The reverse side overlaid with a similar phenol film, and normally the reverse side is smooth.

The unit weight of RIGA TEX plywood film is 120 g/m² or 220 g/m². On special request, panels can be overlaid with multi-layer phenol film and both the sides can have a wire mesh pattern.

Wire mesh pattern can be of different kinds:

Large Mesh (grade WL) - 2.5 mesh per 1cm

Small Mesh (grade WS) - 4.5 mesh per 1cm

LATVIJAS FINIERIS

AKCIJU SABIEDRĪBA



Bauskas iela 59, Rīga, LV 1004, LATVIA
Tel.: +(371) 7620857; Fax: +(371) 7820112
E-mail: info@finieris.lv
Home page: <http://www.finieris.lv>

RIGA[®] TEX

Film colour:

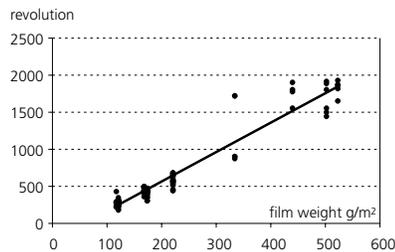
Normally dark brown (120g/m²). Other standard colours are light brown (120g/m²), dark brown (220g/m²), green (120g/m²), black (120g/m²). Grey (174g/m²) and red (220g/m²) colours on special order.

Edges sealing:

Edges of the panels are matched with the face against absorption of moisture by using acrylic paint. Other colours are available and the edges may be unsealed at customers' request.

Overlying characteristics:

The overlying surface is highly resistant to abrasive wear and it does not crack. It is also resistant to weather and moisture as well as commonly used chemicals. The wire mesh patterned surface provides high anti-slip properties. RIGA TEX panels can be machined by using normal woodworking equipment. During machining extra hard cutting tools are recommended. Abrasion resistance according to the Taber test (EN 438-2): depends on applied film, surface texture*, conditions of product storage and application, thickness of film (see below) a.o.



Small mesh resistance to wear parameters are better than Large mesh ones.

It is possible to obtain overlaid plywood resistance to wear even above 10 000 revolutions

Company's specialists will assist you to choose the most appropriate product.

Sizes:

1200 mm x 1200/1500/1800/2100/2400/2700/3000 mm
 1220 mm x 1220/1525/1830/2135/2440/2745/3050 mm
 1250 mm x 1250/1500/1800/2150/2500/2750/3000 mm
 1500 mm x 1500/1800/2100/2500/2700/3000 mm
 1525 mm x 1525/1830/2135/2440/2745/3050 mm

Cut to size panels, machining, tongue & groove, jointing available in accordance with the customers' requirements.

Thickness:

4; 6.5; 9; 12; 15; 18; 21; 24; 27; 30; 35; 40 mm

Tolerance:

Size and right angle tolerance meets the standard EN 315 requirements.

| Nominal thickness mm | 4 | 6,5 | 9 | 12 | 15 | 18 | 21 | 24 | 27 | 30 | 35 | 40 |
|------------------------------|-----|-----|-----|------|------|------|------|------|------|------|------|------|
| No. of plies | 3 | 5 | 7 | 9 | 11 | 13 | 15 | 17 | 19 | 21 | 25 | 29 |
| Average actual thickness, mm | 3,8 | 6,4 | 9,2 | 12,0 | 14,9 | 17,7 | 20,5 | 23,4 | 26,5 | 29,4 | 35 | 38,7 |
| Lower limit, mm | 3,5 | 6,1 | 8,8 | 11,5 | 14,3 | 17,1 | 20,0 | 22,9 | 25,8 | 28,7 | 33,6 | 38,4 |
| Upper limit, mm | 4,1 | 6,9 | 9,5 | 12,5 | 15,3 | 18,1 | 20,9 | 23,7 | 26,8 | 29,9 | 35,4 | 41,2 |

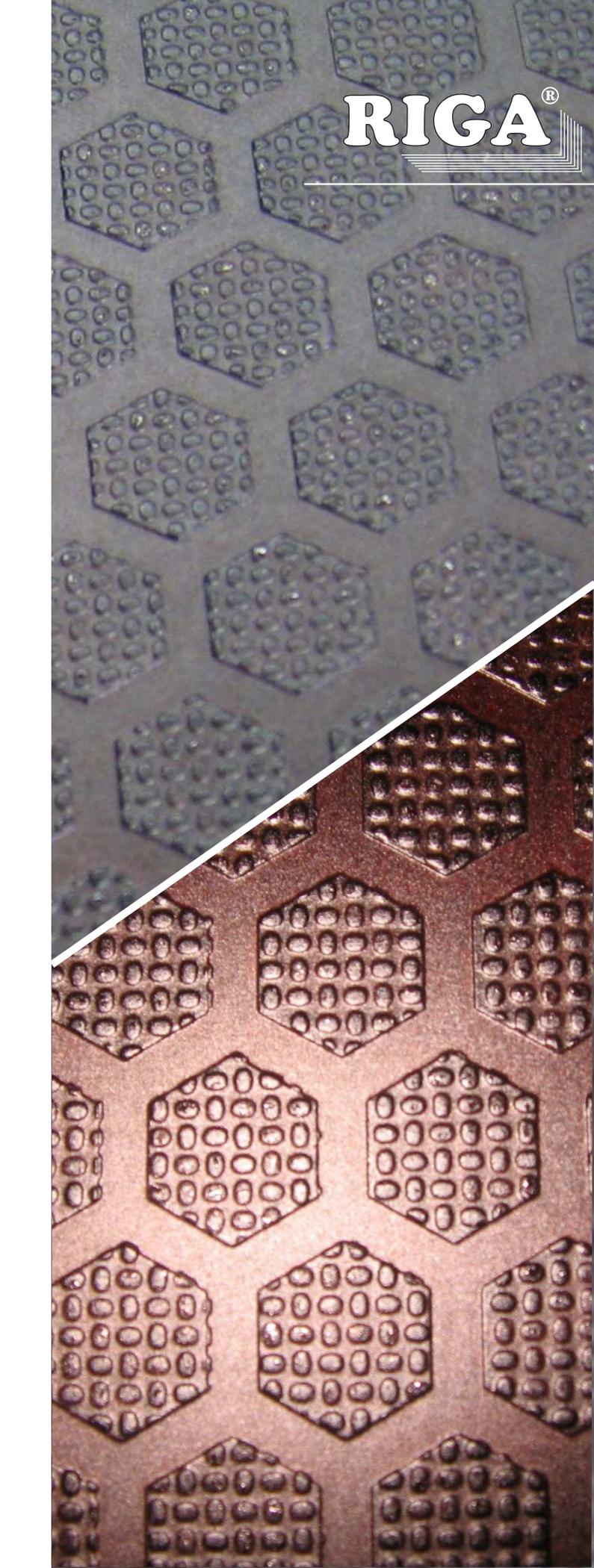
| Parameter | Tolerance |
|---------------------|-----------|
| Length, width, (mm) | |
| < 1000 | ± 1 mm |
| 1000...2000 | ± 2 mm |
| >2000 | ± 3 mm |
| Right angle | ± 0.1% |
| Edge straightness | ± 0.1% |

Plywood is manufactured by a/s Latvijas Finieris whose Quality Management System is certified to the requirements of ISO 9001 by Bureau Veritas Quality International.



The given information is for reference only and a/s Latvijas Finieris reserves the rights to amend and supplement the specifications of manufactured products without a prior notice.

Nr. 003 205_210404



RIGA[®]

HEKSA PLUS

Product

Birch plywood (*Riga Ply*) overlaid with a phenol or UV-resistant film on both faces. One face is with special surface pattern (*WT*, see figure 1). The reverse is smooth (*F*).

Application

Flooring in transport industry, pedestrian bridges, storage and factory floors, storage shelves, loading platforms, pier surfaces, scaffoldings, ship decks, shop fitting and flight cases. In general - surfaces where high wear resistance is required.

Further processing

The processing options include: cutting, drilling, milling, jointing in length, tongue and groove (*T&G*), half laps, profiled edges etc.

Advantages

Surface with high wear resistance, decorative appearance, waterproof, resists commonly used chemicals and easy to clean.
User and environmentally friendly, hygienic.

Gluing classes

Plywood is glued with waterproof phenol formaldehyde resin adhesive. The weather and boiling water resistant bonding meets the requirements of the following standards:

EN 314 / 3rd class;
BS 1203 / H 4 (previously WBP);
DIN 68705 Part 3 / type BFU 100.

Formaldehyde emission

In accordance with the standard *EN 13986* formaldehyde emission meets the Class *E1* requirements. Test method *EN 717 Part 2*.

LATVIJAS FINIERIS

AKCIJU SABIEDRĪBA



Bauskas 59, Rīga, LV-1004, Latvia
Phone +371 67620857, Fax +371 67820112
E-mail: info@finieris.lv
<http://www.finieris.com>



RIGA[®] HEKSA PLUS

Surface pattern

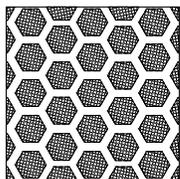


Figure 1. RIGA[®] Heksa Plus surface pattern

The panels are overlaid with a film and have a special pattern imprinted in hot pressing process (see Figure 1). The abrasion resistance of *Heksa Plus* and *Heksa Plus Heavy* is fundamentally different. (see Table 1).

Results of Wear Resistance Tests

Table 1

| Type of overlay | Taber test results, revolutions | Rolling test results, revolutions |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------|-----------------------------------|
|  <i>Heksa Plus</i> <ul style="list-style-type: none"> ▶ Dark brown (220 g/m²) ▶ Dark brown (440 g/m²) ▶ Green (120 g/m²) ▶ Grey (174 g/m²) | Min. 550 Min. 1350 Min. 700 Min. 900 | Min. 10 000 |
|  <i>Heksa Plus Heavy</i> <ul style="list-style-type: none"> ▶ Dark brown (350 g/m²) | Min. 6000 | |

Edge sealing

Edges sealed with acrylic paint.

Sizes

1250 mm x 2500 mm

1525 mm x 3050 mm

Cut to size panels and machining available in accordance with customers' requirements.

Thickness

6.5, 9, 12, 15, 18, 21, 24, 27, 30, 35 mm.

Tolerance

Size and right angle tolerance meet the standard *EN 315* requirements.

| | | | | | | | | | | |
|------------------------------|-----|-----|------|------|------|------|------|------|------|------|
| Nominal thickness, mm | 6.5 | 9 | 12 | 15 | 18 | 21 | 24 | 27 | 30 | 35 |
| Number of plies | 5 | 7 | 9 | 11 | 13 | 15 | 17 | 19 | 21 | 25 |
| Average actual thickness, mm | 6.4 | 9.2 | 12.0 | 14.9 | 17.7 | 20.5 | 23.4 | 26.5 | 29.4 | 35 |
| Lower limit, mm | 6.1 | 8.8 | 11.5 | 14.3 | 17.1 | 20.0 | 22.9 | 25.8 | 28.7 | 33.6 |
| Upper limit, mm | 6.9 | 9.5 | 12.5 | 15.3 | 18.1 | 20.9 | 23.7 | 26.8 | 29.9 | 35.4 |

| Parameter | Tolerance |
|--------------------|-----------|
| Length, width (mm) | |
| < 1000 | ± 1 mm |
| 1000...2000 | ± 2 mm |
| > 2000 | ± 3 mm |
| Right angle | ± 0.1 % |
| Edge straightness | ± 0.1 % |

Plywood is manufactured by AS *Latvijas Finieris* whose Quality Management System is certified to the requirements of *ISO 9001* by *Bureau Veritas Certification*.



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