



RIGA

FORM

Product

Birch plywood (*Riga Ply*) bonded with waterproof phenol resin adhesive and overlaid on both sides with a phenol film or with UV-resistant film (grade *F/F*).

Film colour

Normally dark brown (120 g/m² and 220 g/m²). Other colours are available on request (dark brown, dark brown (wear resistant), light brown, yellow non-transparent and transparent, green, black, grey, red, opal white, honey). Under transparent films *BB* grade veneer can be applied.

Application

Shuttering, transport industry, building boards, flooring, inter-wall structures in farms, advertisement and information boards.

Further processing

Plywood can be machined with wood working tools: cutting, drilling, milling, jointing in length, tongue and groove (T&G), half laps, profiled edges etc.

Advantages

Environmentally friendly, durable, workable, hygienic, without odour (smell), easy to clean, wear, weather and water-proof, resists commonly used chemicals. *Riga Form* for shuttering can be re-used many times.

Gluing classes

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

EN 314 / 3rd class;
BS 1203 / H4 (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*.

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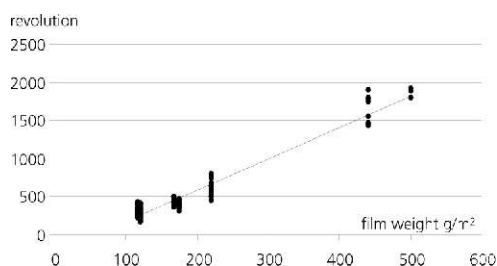
RIGA[®] FORM

Overlaying

A smooth film, which is hot-pressed onto the surface, is used as an overlay. The phenol film is composed of a base paper and phenol resin that is impregnated into the base paper. The modified UV-resistant film is impregnated with special thermosetting mixture of polymers containing amino resin. Overlaying with higher resistance to abrasion and multi-layer overlaying are also possible (respectively 240 g/m², 440 g/m² etc.). Multi-layer overlaying gives superior wear resistance.

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.

Edge 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.

Sizes

1220 mm x 2440 mm
 1250 mm x 2500 / 3000 mm
 1525 mm x 3050 mm
 2150 mm x 3850 mm

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

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



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