

Storage and handling

The boards should only be transported flat, on a pallet or on wooden profiles.

The material must be stored in closed, heated rooms in temperature between 15 and 25 °C and the relative humidity between 40 and 60%, on the original pallet or with 4 timber battens and not exposed to direct sunlight. To prevent contamination, uneven temperature/humidity effects and surface damage, use protective foam between the boards and spacer boards at the bottom and top of the pallet.

To prevent contamination, uneven temperature/humidity effects and surface damage, use protective foam between the boards and spacer boards at the bottom and top of the stack.

Before processing the goods must have an acclimatization period at room temperature of at least 48 hours or longer depending on the season.

"The boards can be processed with most approved woodworking tools. Tools need to be sharp. When cutting, a saw blade should be used.

Testing is recommended before production begins to determine optimal machine settings."

Intensive and metallic colors should be process and install in one direction. Installation upside down may cause different optical impression of the color.

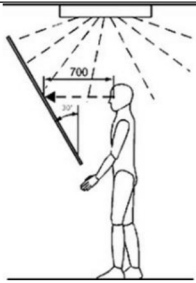
Cleaning

For cleaning, we recommend cloth with soapy water or detergent for domestic use. For best cleaning results, use a microfiber cloth. Avoid spraying products directly onto the surface as this can leave stains and marks. After cleaning with a damp cloth, wiping dry is recommended to remove moisture. Do not use paper towels, abrasive products, bleach, highly chlorinated products or acids. Before using a cleaner, test on a small, invisible part of the surface. Steam cleaners or high-pressure washers are not suitable for cleaning.

Dirt need to be removed as quickly as possible. Do not allow stains to dry on the surface.

Properties	Test method	Value	Unit
Surface properties			
Density	ISO 1183-1	1,1	g/cm ³
Scratch resistance	DIN 68861/T4	0,8	N
Impact resistance	EN 438-2	1600	mm
Abrasion resistance	DIN 53754	35	mg/50
UV resistance (light fastness)	ISO 4892-3	1,7	Delta E
Resistance to dry heat	DIN 68861/T7	7 E (60°C)	Rating
Resistance to wet heat	DIN 68861/T8	7 E (60 °C)	Rating
Colour accuracy (light colours)	ISO 2813	< 0.75	Delta E
Colour accuracy (dark colours)	ISO 2813	< 1.5	Delta E
Chemical resistance	DIN 68861/T1	1 B - no visible changes	Rating

Properties	Test method	Value	Unit
PP Surface properties			
Thickness	PN-ISO 4593	160 - 400 ± 5%	µm
Tensile strength at break PP3-PP10	PN-ISO 6383	long. > 30 trans: > 90	N/mm
Tensile strength at break PP1-PP2	DIN EN ISO 527-1;3	long.: 40 trans: 29	N/mm ²
tensile strength PP3-PP10	PN-EN ISO 527	long: > 16 trans.: > 12	MPa
Elongation at break PP3-PP10	PN-EN ISO 527	> 300	%
Elongation at break PP1-PP2		> 635	%

Surface quality	
<p>Due to technological limitations, it is not possible to produce a completely flawless surface. Minor defects and irregularities are acceptable. A surface defect is defined as a defect greater than greater than 1.0mm² and recognized when examining the surface at a distance of 0.7meters and an angle of view of about 30°. The defined maximum is 2 defect/m². The evaluation of the board should take place under daylight or artificial lighting D 65: 6500 K and lighting intensity: 1000 – 2000 lx. Maximum observation time is 20 seconds.</p>	

velvet Standard Technical Data

velvet Standard are furniture boards designed for interior use on vertical surfaces. They are manufactured on an MDF or particle board basis, covered on one side with coextruded ABS/PMMA film with a scratch-resistant high-gloss acrylic top layer, and on the other side with a polypropylene counter-pressure laminate. Only water-resistant PUR glue is used to manufacture **velvet** Standard boards.

Properties	Value	Unit
General properties		
Thickness tolerance relative to nominal value	$\pm 1^*$	mm
Thickness tolerance within the board	$t_{max}-t_{min} \leq 0,6$	mm
Length tolerance	± 10	mm
Width tolerance	± 10	mm
Flatness	≤ 2	mm/m
Edge Damage: 4 Sides	< 10	mm

* depends on components

Properties	Test method	Values	Unit
Chipboard core properties			
Thickness		16 - 20	
Density	EN 323	650	kg/m ³
Internal Bond	EN 319	0,35	N/mm ²
Bending Strength	EN 310	11	N/mm ²
Surface soundness	EN 311	0,8	N/mm ²
Formaldehyde emission E1	EN 717-1	E1	Class
Moisture Content	EN 322	5 - 13	%
Length width tolerance	EN 324-1	± 5 mm	mm
Straightness tolerance	EN 324-2	1,5	mm/m
Thickness tolerance	EN 324-1	$\pm 0,3$	mm

Properties	Test method	Value		Unit
MDF core properties				
Thickness		>12 - 19	>19 - 22	mm
Density	EN 323	≥ 720	≥ 720	kg/m ³
Internal Bond	EN 319	$\geq 0,55$	$\geq 0,55$	N/mm ²
Bending Strength	EN 310	≥ 20	≥ 18	N/mm ²
Swelling 24h	EN 317	≤ 12	≤ 10	%
Formaldehyde emission E1	EN 717-1	$\leq 0,1$		ppm
Formaldehyde emission E1	EN 16516	$\leq 0,1$		ppm
Formaldehyde emission E1	EN ISO 12460-5	$\leq 5,0$		mg/100g
Moisture Content	EN 322	4 - 11		%
Length width tolerance	EN 324-1	± 2 (max. ± 5)		mm
Straightness tolerance	EN 324-2	1,5		mm/m
Squareness tolerance	EN 324-2	2		mm/m
Thickness tolerance	EN 324-1	$\pm 0,2$	$\pm 0,3$	mm