



HOLZ IN FORM

technical data sheet / handling instructions
Model 2487 BORKE linear
embossed panel from the „Holz in Form” product range



Werkstätten

updated 2012

General Definition:

The embossed panels Model 2487 BORKE linear from the “Holz in Form” product range are elements with special developed veneer with a plywood core.

The 2487 BORKE boards have **no** repeating pattern.

Range of applications:

Furniture industry for facing, visible sides, fillings, covers, and so on. Interior wall and ceiling covering, sliding doors, architectural doors, et cetera.

Technical data:

Sizes: 2450x1050mm 8.04x3.44ft
the first specification identifies the direction of the structure and the veneer

Thickness: 21mm 0.83inch

Size accuracy: +/- 1,0mm per metre

Straightness: +/- 3,0mm per metre

Thickness allowance: +/- 0,5mm

Density (kg/m³): approximately 890-900kg/m³ equivalent to 18.8kg/m² depending on surface composition.

Besides the allowance of +/-0.5mm of the total area thickness referring to the highest point there are minor differences in the thickness of the embossment - about 0.4 – 6,8mm due to the natural design specifications.

Notice: You could for different scopes of design countersink into the deeper black layers of the veneer. Your cutter should be set to 2.5 - 3mm to do that.

Packing: holohedral lying on palett.

Storage: Ample vented, dry and moisture/frost free.

The boards have to be stored holohedral reclined. Boards with veneer should be sun-protected .

Adequate conditioning before processing is also very important.

Processing: **BORKE linear boards need to seat solidly with at least 50% of the direct mechanical irradiated area.**

Sawing: Use sharp hard metall sawing blades and a low sawing feed rate. Scoring is nonessential.

Milling: Use also hard metall tools for milling and profile cutting.

Drilling: The standard drilling tools for woodworking could be used.

Screws: We recommend primary drilling before using screws to avoid splitting.

Gluing: Standard wood glues and adhesives could be used. We recommend formaldehyde-free glues.

and bonding: If you have to raise or heighten some parts the backside **have so be** similar in composition.

For example: 9mm board – 10mm carrier plate – 9mm counter draw (.35 - .39 - .35”).

Edges and Missing edge processing could lead to cracks in the material. **Follow absolutely our references**

Lacquering: **in the brochure “Edge and Surface” development for deep and narrow pattern!**

Sanding after edge development. Than priming and the final lacquering. Please follow the instructions of your laquer manufacturer.

The boards must rest holohedral – no hanging on the sides!

Lacquer allways both sides! **Never use wall paint on “Holz in Form” boards!**

Attention! If you need to encase equipment that emits heat please contact us before to avoid later damages.

Recycling: Thermal/Energy recovery of the boards is uncomplicated (no PVC).

Explanatory notes: The given details in this data sheet are our field-tested experience. They could not consider any parameter, use case or application and they are therefore without commitment. These data does not represent guarantee of condition in the legal sense or a assurance of the characteristics. No legal claims could be derived by using the information given in these data sheets or by our free of charge technical consultants.

Please contact us about precast elements or any questions about our products.

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