



**RIGA**<sup>®</sup>

# HPL

## Product

Birch plywood (*Riga Ply*) overlaid with *HPL* (*High Pressure Laminate*) on one or both faces. On the reverse side balance paper can be applied.

## Overlay

*HPL* is a decorative high-pressure laminate. *HPL* is made of layers of Kraft paper impregnated with phenol resins (the core) and decorative melamine impregnated paper (the surface layer), manufactured under high pressure and temperature.

Colours at customer's request.

## Application

Furniture industry: kitchen and laboratory furniture components and worktops; furniture for shops.

Transport industry and construction: finishing works of walls and ceiling, surfaces where high wear resistance and appearance are required.

## 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* / 3<sup>rd</sup> class;

*BS 1203* / *H 4* (previously *WBP*);

*DIN 68705 Part 3* / type *BFU 100*.

*HPL* overlay is glued to the surface of plywood with high resistance melamine-urea-formaldehyde glue.

*HPL* bonding quality meets requirements of:

*EN 12765*/class *C4*;

*BS 1204*, *BS 1203* / *BR*.

## Formaldehyde emission

In accordance with the standard *EN 13986* the formaldehyde emission meets the *Class E1* requirements (test method *EN 717 Part 2*). Plywood glued with phenol-formaldehyde resins meets the *CARB Phase 2* and Japanese *4-Star Regulation's* requirements.

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## Sizes

1220 x 2400 / 3050 mm

1250 x 2500 / 3000 mm

Cut-to-size panels and machined panels available in accordance with the customers' requirements.

## Thickness

Plywood (*Riga Ply*) nominal thickness is 6.5, 9, 12, 15, 18, 21, 24, 27 mm.

To *Riga Ply* thickness the following should be added:

2 x 0.6 mm (*HPL* thickness), if *HPL* is applied on both sides;

0.6 + 0.25 mm (balance paper thickness), if *HPL* is applied only on one side.

## Tolerance

Dimensional and right angle tolerance meets the standard *EN 315* requirements.

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

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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