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Technical data sheet (2020)

Product: Worktops EN16516 postformed

Worktops on particleboard basis with decorative laminate coating (postformed)

1. Product identification

Worktop is constructed from particleboard PB P2 as a supporting substrate covered with postforming laminate. Particleboard PB P2 is three-layer particleboard manufactured from specially selected wood chips and high quality synthetic resin. Particleboard, sanded on both sides, is covered with postforming HPL laminate on the top and front side and balancing cellulose foil on the bottom side. Joint between laminate and balancing foil is provided with water vapour protection polyurethane seal (steam barrier). Front side of particleboard edge is reinforced by HDF strip.
Surface layers are bonded to substrate by dispersion PVAC adhesive, type D3.

The laminate surface is characterized by an increased resistance to surface wear, scratching, impact and to dry heat.

These worktops have a wide application range in furniture industry kitchen worktops, table tops, bars and counters etc.

Manufacturer identification:

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2. Technical production specification

Production tolerances of Worktops EN16516				
Property		Test method	Attribute / unit	Requirement
Dimensional tolerances	Width	EN ISO 13894-1	Board width 600 mm	± 0,55 mm
			Board width 900 mm	± 0,70 mm
			Board width 1200 mm	± 0,85 mm
	Length (unmachined board)	EN ISO 13894-1	Board length 4100 mm	-5/+10 mm
	Thickness	EN ISO 13894-1		± 0,4 mm
Edge straightness		EN ISO 13894-1		± 0,50 mm
Edge squareness		EN ISO 13894-1		≤ 2,0 mm/m
Deviation from flatness [a] (deflection in width or length)		EN ISO 13894-1	in size ≤ 0,50 m	max. 0,8 mm
			in size ≤ 0,60 m	max. 0,9 mm
			in size ≤ 0,70 m	max. 1,1 mm
			in size ≤ 0,80 m	max. 1,3 mm
			in size ≤ 0,90 m	max. 1,6 mm
			in size ≤ 1,00 m	max. 2,0 mm
			size greater than 1,0m [b]	max. 2,0 mm/m

[a] Numerous factors, including changes in temperature and relative humidity such as are encountered on building size, may cause panels to bow and twist irreversibly. This requirement is therefore only applicable at the time of delivery and for boards which are not mechanically fixed in final application.
[b] For elements of dimensions greater than 1000 mm, measurement shall be made using a bow gauge of 1000 mm length.

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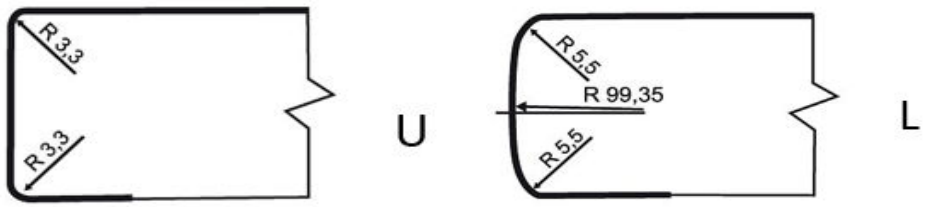
Production specification related to core particleboard			
Bending strength	EN 310	N/mm^2	≥ 8,5
Modulus of elasticity in bending	EN 310	N/mm^2	≥ 1200
Internal bond	EN 319	N/mm^2	≥ 0,20
Surface soundness	EN 311	N/mm^2	≥ 0,8
Density tolerance	EN 323	kg/m^3	± 10 %
Moisture content	EN 322	%	2 - 12 %
Production specification related to decorative postforming laminate HPL			
Resistance to surface abrasion	EN 438-2.10	IP, number of revolutions	≥ 150
Resistance to impact with large diameter ball	EN 438-2.21	Drop height [mm]	≥ 600
Scratch resistance	EN 438-2.25	Appearance, grade	≥ 1 (SQ finishes) ≥ 2 (other finishes)
Resistance to staining	EN 438-2.26	Group a 1 + 2, grade Group 3, grade	≥ 4 ≥ 4
Resistance to water vapour	EN 438-2.14	Appearance, grade	≥ 2 (SQ finishes) ≥ 3 (other finishes)
Dry heat resistance [c] (exposition to 160°C for 20 minutes)	EN 438-2.16	Appearance, grade	≥ 3 (SQ finish) ≥ 4 (other finishes)
Resistance to elevated temperature [d] (exposition to 100°C for 1 hour)	EN ISO 13894-1	Appearance	No surface damaging, no cracks and colour changes

[c] Intended for suitability for use in kitchens where contact with medium-hot kitchen utensils can be expected.
[d] Intended for suitability for use in kitchens where the close proximity of a cooking ranges or oven can be expected.

Worktops Edge Profiles:



3. Technical properties

Technical properties of Worktops		
Property	Test method, directives	Value
Reaction to fire	EN 13501-1	Class D,s2-d0
Formaldehyde content	EN ISO 12460-5	Class E1 ≤ 8 mg/100 g
Formaldehyde emissions	EN 16516	< 0,1 ppm (0,124 mg/m^3)
	EN 717-1	< 0,05 ppm (0,062 mg/m3)
Hygienic properties – materials for contact with foodstuff	EU regulation Commission No.10/2011 + No. 2016/1416 + No.2017/752; Directive ES no. 1935/2004	Decorative surface comply with requirement for materials intended for contact with foodstuff.

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4. Instruction for transport and storage

Packing:
Each worktop is wholly wrapped in PE foil to protect against damage during transport and storage.

Transport

- Railway carriages intended for this type of transport (closed and secured against climatic influence). In the carriages there are movable obstruction and fixing device (courting) which protects the goods against the damage.
- By road trucks. Canvas covers are used to protect the goods against climatic influence and fixing device (courting) are used to disable the movement and consequent damage of the goods inside the truck.

Storage

Worktops should be stored on flat surface, preferably in the original packaging. The individual board packing must be interleaved, the bottom package should be placed at least 10 cm above the floor.

Boards without protective foil shall be stored in a dry and ventilated area at an optimal temperature of 15 - 25°C and a relative humidity of 40 - 65%, at distance of min. 1.5 m from the heat source.

Improper storage as well as damage to the protective PE foil can lead to irreversible changes and permanent deterioration of the boards.

5. Instruction for handling and installation

Prior installation (after unwrapping) is essential the board conditioning. It means exposed to temperature and relative humidity of ambient air where the boards will be installed and used. The changes in temperature and relative humidity such as are encountered on building size, may cause panels to bow and twist irreversibly. These changes need to be avoided.

All cut or milled edges and drilled holes (for the installation of sinks, cookers and other penetrations) must be protected against the impact of high humidity and water. Exposure of the unprotected edge to moisture can lead to irreversible changes such as swelling in thickness. All cut-outs for sinks/cookers and other holes in boards must be made with rounded corners with a minimum radius of 6 mm. The minimum distance of the cut-outs for sinks/cookers from the end or another cut-out should be 300 mm.
It is recommended to protect the edges of the hob cut-outs with self-adhesive aluminium tape, also sufficient safety distance must be created from the hob as specified by the hob manufacturer's installation instructions.
In the case of placing dishwashers and stoves underneath of worktops, it is recommended to use self-adhesive aluminium tape over the end of laminate (steam barrier) on the bottom side of the worktops.

6. Protective equipment

Protective means fitting to the processing method and technical equipment of the processing plant (protective goggles, respirators, gloves, safety shoes).

7. Disposal of waste generated during worktops processing

With regards to general obligations imposed by the Act No.185/2001 Coll. (Czech law), on waste, the priority is to search for the material reuse of the respective waste in case that it was not possible to prevent its generation. In this respect those types of waste can be regarded as waste which complies with the requirements stipulated by Kronospan CR spol. s r. o. Jihlava concerning input raw material.

8. Related documents

- Cleaning and maintenance instructions

- Chemical resistance and hygienic properties of HPL