

1 Scope of Technical Specification

The scope of this Specification is moulded plywood for laser cutting Rotary Boards. The main characteristic of plywood for laser cutting its special build. Both, the surfaces and the core of the plywood have to be free from any open defects or cavities. It is supposed to allow the laser beam to cut plywood with same efficiency within the panel area.

2 Materials:

- Beech *Fagus*

3 Plywood construction

- In the plant option.
- Veneer thickness 1,5 mm
- Beech 100%

4 Quality requirements

Repaired with wood insertions (plugs);	allowed
Knots sound, intergrown	
Discolorations	
Splits, gaps and core gaps	not allowed
Splits, gaps and gaps in face veneers	
Puty, fillings, bumps, sanding through or roughness	

5 Dimensions and tolerances

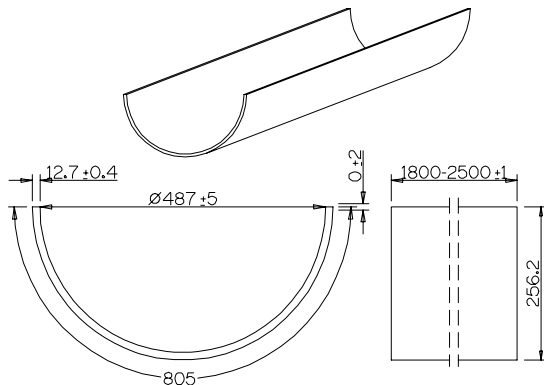
5.1 Standard sizes for Ø487 mm

1800 - 2500mm (length) x 805 mm (width)
other formats to agree

5.2 Standard thickness

12,7; 13,0 mm

5.3 Dimension tolerances



6 The optimum relative humidity in what plywood for laser cutting should be kept is 60%.

7 Type of gluing

Glue used: melamine – urea – formaldehyde.
Bond quality – class 1 acc. to PN-EN 314-2 dry conditions (INT, MR)

8 Formaldehyde emission

Emission class A acc. to PN-EN 1084.
Hygienic class E1.

9 Moisture content 5-12 %

10 Other conditions can be agreed between buyer and producer.