

PLYWOOD TECHNICAL SPECIFICATION

RAW MATERIALS

Wooden species

It is possible to use different wood species suitable to be working from the veneer peeling machine. I.C.T.A is using Italian poplar coming mainly from its own plantation. Most of these plantations have the FSC certification. Also sliced veneered wood are used beech (also FSC 100%), Pine, Oak, Spruce, Ayous (also FSC 100%)...etc.

Plywood composition

The composition is obtained from the log cutting. Every single veneer is one layer of the plywood panel and the thickness and dimension are different.

I.C.T.A. composition:

- Thickness: 1,0 mm - 3 mm
- Width: 1200 mm – 2200 mm
- Length: 1200 mm – 2520 mm
- Also special dimension available

CLASSIFICATION

Classification according to the bonding

The glue mix is the main element for the plywood performances in the different situations of its use.

The adhesives used are synthetic thermosetting.

Among the main components, I.C.T.A. is using the following:

Urea (UF)

Melamine/urea (MUF)

Class of bonding	Proof treatment	Suitable adhesive
Class 1 (indoor use)	24 hours in 20° water	Urea (UF)
Class 2 (humid indoors and covered outdoors)	24 hours in 20° water 6 hours in boiling water 1 hour in 20° water	Melamine/urea (MFU)

Classification according to the aspect of the faces

UNI EN 635-1	DESCRIPTION
A	Faces that may remain visible - ideal for any type of finishing (coatings, varnishes, etc). Almost without defects
AB	Faces that may remain visible - ideal for any type of finishing (coatings, varnishes, etc). May contain a few pin knots or healthy small, well-done putty repair work that blends well with the rest of the surface & very light discolouration. Sanded. Oxygenated water treated on the surface
B	Natural face with colour variations and well done putty repair. May contain small knots, knotholes or cracks, so long as good repairs have been made. May also contain light discolouration and some limited glue stains and good repairs. Sanded
BB	Commercial face with putty work performed - ideal for non-visible uses and overlaying with laminates and veneers. May contain healthy knots, loose knots, cracks, bark and overlapping. May also include natural discolouration, glue stains, repairs and any form of putty work and repairs. Sanded
C	Plywood face designed for packaging and similar uses. May contain all the natural wood characteristics and various processing defects, provided these do not compromise the functions of the plywood (e.g. the presence of fungi and metal parts is not allowed). Sanded on request

PROPERTIES

Main Physical characteristics

In the following tables are quoted the values of the main characteristics of the plywood produced by I.C.T.A. srl:

max/min- cm Dimensions	252/242/222 x 82/92/122/172/184 (standard dimensions) Special dimensions available	
Thickness and layers	3,4,5,6 5,6,7,8,9,10, 12,14,15, 15,18,20, 25,27,30,35,40 3 5 7 9	
Thickness tolerance	+/- 0,3 mm	UNI EN 323
Size tolerance	+/- 5 mm	UNI EN 324-1
Density	400 – 430 Kg/m ³	UNI EN 323
Moisture	7 – 12 %	UNI EN 322