

# Eveneer Alpikord

pre-finished reconstructed timber veneer sheets

## What is Eveneer Alpikord?

Eveneer Alpikord is a range of reconstructed timber veneers, factory finished with high quality 2 pack polyurethane complete with UV inhibitors, laid onto a high pressure laminate back. The result is a sheet of wood in large size (3050 x 1300mm or 2500 x 1250mm) already finished and ready for application. Eveneer Alpikord unites the beauty of real wood with the versatility of HPL laminate. Eveneer Alpikord reduces the working, polishing and laying times associated with traditional timber resulting in savings of time, labour and costs.

## Advantages

- FSC certified and E0
- Manufactured exclusively with wood from agricultural plantations and sustainable forests.
- Already finished, ready for application and protected with a peel-off sheet.
- Can be applied the same way as HPL laminate
- Postformable with a minimum bending radius of 20mm
- On request can be supplied with IMO MED (for marine furnishings) or EN 13501-1-2002 Class B-S1.d0 Certificates

## Technical

	Polyurethane finish			Melamine finish	
	Groove	Silk	Wax	Soft-OL	IMO Soft-OL
Nominal thickness	1mm	1mm	1mm	1mm	1mm
Grade	Postformable	Postformable	Postformable		
Bending radius					
longitudinal	20mm	20mm	20mm	–	–
transversal	20mm	20mm	20mm	–	–
Postforming temperature	145°C	145°C	145°C	–	–
<u>Weight per m2</u>	<u>1.2kg</u>	<u>1.2kg</u>	<u>1.2kg</u>	<u>1.2kg</u>	<u>1.3kg</u>
Dimensional variations					
longitudinal	0.40%	0.40%	0.40%	0.40%	0.90%
transversal EN 438-2, 17(2005)	1.20%	1.20%	1.20%	1.10%	1.40%
Abrasion resistance					
(average values) EN 438-2, 10(2005)	>80 Taber Turns	>100 Taber Turns	>80 Taber Turns	>350 Taber Turns	>350 Taber Turns
<b>Stain resistance EN 438-2, 26(2005)</b>	<b>no effect</b>	<b>halo caused by acetone</b>	<b>no effect</b>	<b>no effect</b>	<b>no effect</b>
Lightfastness (xenon test)	>2 grey scale	>2 grey scale	>2 grey scale	>2 grey scale	>2 grey scale
Formaldehyde emission EN 717-2	0.2mg/m2h	0.2mg/m2h	0.2mg/m2h	–	–

### Standard Sizes

Length x width – 2500mm x 1250mm or 3050mm x 1300mm

Thickness – 1mm

### Finishes

**GROOVE** (Polyurethane – Gloss 0%)

A grooved tactile effect, this exclusive finish enhances the natural depth of the wood texture.

**WAX** (Polyurethane – Gloss 5%)

Reproduces a wood treated with wax and natural oils with a smooth, matt (5% gloss) surface.

**SILK** (Polyurethane – Gloss 15%)

A traditional, refined finish with a brightness that recalls the look and feel of traditional furniture.

**MELAMINE** (Soft 10% or OL 15%)

More durable finishes – also available with IMO MED certified fire resistance.

## **Directions for use**

Eveneer Alpikord panels can be handled stocked and worked mainly as a traditional HPL panel with a melamine overlay. However, some specific features of wood surfaces require particular care.

- Eveneer Alpikord sheets are always to be stacked flat, horizontally, face to face, at a moderate ambient temperature (about 20C) and a relative humidity of around 60%.
- Care should be taken to avoid bending or cracking if the sheets are to be rolled. Rolling against the grain may cause the veneer to crack, and must be done with care. Refer rolling instructions. It is not recommended that the veneer be stored in rolls.
- As for all wood surfaces, they must be protected from sunlight and humidity. Wrap in non-transparent plastic, preferably dark, to assure stability.
- The sheets are always to be handled by 2 people.
- Eveneer Alpikord is supplied with a clear protective film. We recommend that you leave the film on the surface while working the veneer. Colour uniformity and quality checks should be carried out on the sheets before working with the veneer. The protective film is clear enough that you may inspect the material without removing it. When in doubt peel the film in the area, or up to the area that is suspect.
- The recommended shelf life of the peel-off protective film is 1 year. After this date the adhesive may begin to react with the polyurethane surface. Please check the manufacture date on the peel-off film.
- No particular equipment or glues are required for cutting and gluing operations. A good vinyl adhesive is recommended for a stronger adhesion, thus reducing the dimensional movements due to temperature and humidity variations.
- Eveneer Alpikord sheets can be adhered in a hot or cold press at a maximum temperature of 60 – 70C and with pressure values suitable to the kind of glue used. Too high pressure and temperature as well as too long in the press may cause the following problems: panel bowing, release of glue from the protective peel off film onto the surface, irregular variation of the finish brightness or even deterioration of the polyurethane surface with a consequent irreversible change of wood colour.
- To avoid bubbling when applying Eveneer Alpikord with neoprene or contact adhesive, be sure to allow adequate drying time so that the solvents (or water, if the contact adhesive is water based) can evaporate. Always follow the adhesive manufacturer's instructions.
- Before application it is absolutely necessary to condition the Eveneer Alpikord sheet and substrate in the same place for at least 24 hours.
- For a correct counterbalancing we suggest that the same kind of sheet be used. For less demanding applications (small surfaces) it is possible to use HPL panels of the same thickness and quality.

- Typical substrates are plywood, MDF and particleboard. The more resistant the substrates are to dimensional change (shrinking and expansion from changes in humidity and temperature) the better the result. The substrate must be smooth and free of grease, wax, dust, oil, silicones, etc. All raised areas must be sanded or filled so that the surface is smooth. The substrate must be uniform in thickness.
- Finish all edges of Eveneer Alpikord on your finished product to prevent moisture absorption into the timber layer.
- Panel saws or table saws may be used to cut Eveneer Alpikord before or after lamination. Routers for trimming edges after bonding must have a smooth, clean base plate, so that the surface of the veneer will not be scratched. Use carbide-tipped bits with ball bearing guide rolls. Keep the bits sharp. Drilling into Eveneer Alpikord may be done with standard wood bits or with router bits. Use a flat, smooth or fine file for a final edge finishing. You may consider applying a light or dark stain to the edge to hide the phenolic line.
- Eveneer Alpikord can be post-formed utilizing similar equipment and techniques that are used with the plastic laminate. The post forming temperature is 145C. It is also important to know that when post forming with the gloss finish it is acceptable to leave the protective film on the product. When post-forming with the wax finish it is important to remove the protective film prior to form. If the protective film is not removed prior to the post-forming the film will burn and adhere to the veneer.

## Important Instructions

### Colour Consistency

As with traditional wood, even with Eveneer Alpikord surfaces, it is not possible to guarantee an absolute consistency in colour between one batch and another. Therefore, a slight colour difference between two sets of panels cannot be considered a defect.

### Reaction to light

All woods, including Eveneer Alpikord, react to direct and indirect light, both natural and artificial (such as incandescent and fluorescent lamps). Therefore a change of the surface colour and appearance over time is a natural characteristic, not a defect. In particular, heat and humidity will interact with light to accelerate the aging process. Furthermore, when exposed to direct and strong light, pastel coloured, melamine-finished patterns can undergo sudden and irregular changes in the original colour.

### Cleaning and Maintenance

The pre-finished Eveneer Alpikord surfaces are easy to clean using a damp cloth and non-abrasive cleaning products. In case of more resistant stains, we recommend the use of alcohol, ammonia or other light solvents. Never use acetone or trichloroethylene on the polyurethane surface.

### Melamine surface

The melamine finished panels, particularly suitable for application on horizontal surfaces (tables, etc.) for their higher resistance to abrasion, show a similar, but not identical colour when compared to panels of the same article with polyurethane finish. A direct matching of panels with the same pattern but different finish is to be avoided.

*The above information and data is merely the result of our observations and experiences. No part of it may be construed as creating a binding obligation or other liability with regard to the way in which customers may process or use our wood. Our laboratory and technical service are always at the customer's disposal.*

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