

TECHNICAL LEAFLET

FLATNESS OF EGGER LAMINATE BONDED BOARDS



EGGER laminate bonded boards are composite elements consisting of EUROSPAN raw chipboards, EGGER MDF or other coreboards faced on one or both sides with decorative EGGER laminate.

Deviations from flatness

The figures in the following tables apply to non-load bearing, free-standing composite elements with a total thickness ≥ 16 mm.

The tolerances listed result from:

- possible warping of the coreboard (EUROSPAN raw chipboard)
- unavoidable influences through the bonding of coreboard and laminate
- the characteristics of the laminate

Deviations from flatness in composite elements can occasionally be put down to the material characteristics and are unavoidable within the tolerance limits.

Conditions

The tolerance figures refer to measurements on composite elements and prefabricated elements stored in standard climatic conditions (23 ± 2 °C and $50 \pm 5\%$ rel. humidity).

Measuring process

Measurements are made on free-standing elements placed on the longitudinal or transverse edge; the elements are placed on two strips of underlay. The measurement is taken at the point with the largest deviation from flatness using a measuring staff or tensioned cord. The measurement is always made on the concave warp side.

TOLERANCE TABLE 1

Deviations from flatness in composite elements made from EUROSPAN raw chipboard laminated on both sides with EGGER laminate in thicknesses ranging from 16 mm to 24 mm.

Composite element dimensions Length / Width	Maximum permissible warping*	
	Concave	Convex
≤ 300 mm	0.5 mm	0.5 mm
≤ 500 mm	0.5 mm	0.8 mm
≤ 600 mm	0.7 mm	0.9 mm
≤ 700 mm	1.0 mm	1.1 mm
≤ 800 mm	1.3 mm	1.3 mm
≤ 900 mm	1.6 mm	1.6 mm
≤ 1,000 mm	2.0 mm	2.0 mm
≤ 1,300 mm	3.3 mm	3.3 mm
≤ 1,500 mm	4.6 mm	4.6 mm
≤ 2,000 mm	6.4 mm	6.4 mm

* relative to the visible side of the composite element

TOLERANCE TABLE 2

Deviations from flatness in composite elements made from EUROSPAN raw chipboard and EGGER laminate in thicknesses ranging from 24.1 mm to 38 mm.

Composite element dimensions Length / Width	Maximum permissible warping* (concave - convex)	
	One-sided CPL	Two-sided CPL
≤ 600 mm	0.9 mm	0.5 mm
≤ 700 mm	1.1 mm	0.6 mm
≤ 800 mm	1.3 mm	0.7 mm
≤ 900 mm	1.6 mm	0.8 mm
≤ 1,000 mm	2.0 mm	1.0 mm
≤ 1,300 mm	3.3 mm	1.7 mm
≤ 1,500 mm	4.6 mm	2.3 mm
≤ 2,000 mm	6.4 mm	3.2 mm
≤ 3,600 mm	10.0 mm	5.0 mm
≤ 4,000 mm	15.0 mm	7.5 mm
≤ 5,000 mm	20.0 mm	10.0 mm

* relative to the visible side of the composite element

TOLERANCE CURVE

Deviations from flatness in composite elements made from EUROSPAN raw chipboard laminated with EGGER laminate (acc. to Table 1).

