

DECLARE OF PERFORMANCE



LAMINATED VENEER LUMBER TECHNICAL PARAMETERS - 72 HOURS WBP GRADE				
SR. NO.	PARTICULARS	REFERENCE	UOM	MIN. PERFORMANCE
1	DENSITY		KGS/M3	600+ KGS/M3
2	THICKNESS TOLERANCE	IS 4990	MM	+/- 0.3 mm
3	SURFACE QUALITY			NO DENTS, NO IMPRESSIONS AND NO JOINT MARKS
4	72 BOILING WATER TEST	IS 4990		NO DE-PLY OR DE-VENEERING
5	LENGTH TOLERANCES	IS 4990		+/- 6 MM
6	WIDTH TOLERANCES	IS 4990		+/- 3 MM
7	EDGE STRAIGHTNESS	IS 4990		2 MM/1000 MM or 0.2 %
8	SQUARENESS	IS 4990		2 MM/1000 MM or 0.2 %
9	MYCOLOGICAL TEST	IS 14616		Should not Show any appreciable signs of separation at the edges of the veneers
10	MODULUS OF ELASTICITY	IS 14616	N/MM2	MIN. 7500 N/MM2
11	MODULUS OF RUPTURE	IS 14616	N/MM2	MIN. 50 N/MM2
12	COMPRESSIVE STRENGTH PARALLEL TO GRAIN	IS 14616	N/MM2	MIN. 35 N/MM2
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	PARALLEL TO LAMINAE		N/MM2	MIN. 35 N/MM2
	PERPENDICULAR TO LAMINAE		N/MM2	MIN. 50 N/MM2
14	HORIZONTAL SHEAR	IS 14616		
	PARALLEL TO LAMINAE		N/MM2	MIN. 6 N/MM2
	PERPENDICULAR TO LAMINAE		N/MM2	MIN. 8 N/MM2
15	TENSILE STRENGTH PARALLEL TO GRAIN	IS 14616	N/MM2	55
16	RESIN USED			PHENOL FORMALDEHYDE
17	APPLICATION OF RESIN			ON BOTH SIDES OF CORE VENEER
18	SCREW HOLDING POWER	IS 14616	N	EDGE - 2300 N FACE - 2700 N
19	THICKNESS SWELLING (2 HOURS WATER SOAKING)	IS 14616	% GE	MAX 3%
20	WARPING	IS 14616	MM	NOT EXCEEDING 1.5 MM PER 1000 MM LENGTH
21	RESIN USED			PHENOL FORMALDEHYDE
22	APPLICATION OF RESIN			ON BOTH SIDES OF CORE VENEER
23	MOISTURE CONTENT	IS 14616	% GE	5 TO 15%
24	THICKNESS OF VENEER		MM	VARYING BETWEEN 1.8 MM TO 2.25 MM
25	DELAMINATION AFTER CUTTING			NO DELAMINATION ALLOWED
26	USAGE OF METAL PINS/STAPLES			NO METAL PINS/STAPLES TO BE USED IN PRODUCTION
27	GAPS IN VENEER PLYS			NO AIR GAPS ALLOWED