



WOODLINE COMPANY LIMITED

Address: 2th Floor, Kinh Do Building, 292 Tay Son street, Dong Da district, Hanoi, Vietnam

Quality Control Data Sheet For FILM FACE PLYWOOD

Technical Information

ITEMS	VALUE
Size	1220*2440mm, 1250*2500mm 610*2440mm, 610*2500mm, As customer's request
Thickness	12, 15, 18, 21mm
Core Veneer	Acacia, Eucalyptus hardwood
Glue	WBP Melamine / Phenolic, water boiling > 10/20/30/50 hours Formaldehyde emission standard: E0, E1 or E2
Film	120 gsm: Vietnam brand for low/medium grade 180 gsm: Dongwa, Dynea brand for high quality Color : Brown, Black + Logos printed if required
Density	≥ 600 kg/CBM
Production	Sanding, cold-press: 1 time, hot press: 2 times
Edge	Spay black/brown waterproof paint
Re-use times	6-8 times, 8-10 times, Over 12 times, Over 20 times
Packaging	Wrapped by wood veneer/carton paper, plastic strap
Production Capacity	2500 CBM/month (50 of 40ft-containers/month)

Property	Standard Value	Test method	Result
Tolerances for Length and Width	± 3mm	In House	± 2.5mm
Tolerances for Thicknesses	±0.5mm	In House	± 0.5mm
Moisture Content	≤ 12%		10%
Density	≥ 600 kg/CBM		650 kg/CBM
Shearing Strength	≥ 2N/mm ²	EN 314 - 1,2	2.53 N/mm ²
Bending Strength	Longitudinal	EN 310	70.2 N/mm ²
	Latitudinal		38.6 N/mm ²

CORE SPECIFICATION

1, Wood Species Hardwood Acacia, Eucalyptus.

2, Density of Acacia/Eucalyptus >600 kg/m³

3, Size of Veneers 1.7 - 2*630*1270mm

4, For 18mm thickness, Number of core veneers 11 Layers

PRODUCTION INFORMATION

UREA FORMALDEHYDE ADHESIVE, UF- 151

1, Glue Type

WBP Melamine / Phenolic

E0, E1 or E2 Grade

2, Specifications (Glue)

Colour Brookfield Viscosity poise / 30°C	Wilky White Liquid
Non- Volatile content W%	1.3 - 1.6
Specific Gravity 30°C	50.0 - 51.5
By Metter	1.185 - 1.195
Formaldehyde W% age	7.5 - 8.5

3, Glue Mixing Formula

Glue UF - 151	1.0 max
Ind. Wheat Flour	100Kgs
Hardener H - 12	14 - 20
Melamine 15%	1.0 - 1.5
Water (Adjust)	0 - 12

Note: The formulation is suggested as a guide. It is sensitive to the Property of Ind. Wheat Flour used

4, Glue Viscosity	16 - 20 poise/33°C
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5, Veneer Moisture (MC)

6, Glue Spread Value	Below 14%
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2.0 - 2.5mm	34 - 38 gm/ft DGL
2.5 - 3.2	37 - 41
3.2 - 3.8	40 - 43

7, Cold Pressing

Pressure	15 - 20 kg/cm ²
Time	1.5 - 2 hours

8, Hot Pressure (first time)

Pressure	15 - 20 kg/cm ²
Temperature	110 - 11 eC
Time (110°C)	45 - 50 mins

9, Hot Pressure (second time for film-face)

Pressure	10 - 12 kg/cm ²
Temperature	110 - 11 eC
Time (110°C)	25 - 30 mins