



HOLZ IN FORM

technical data sheet / handling instructions
Model 2526 BRUSH
embossed panel from the „Holz in Form“ product range



General Definition:

The embossed panels Model 2526 BRUSH from the “Holz in Form” product range are elements with special developed compositions of melamine resin saturated papers with a chipboard core.
The 2526 BRUSH boards have a repeating pattern at size 3135 x 1270 mm resp. 1270 x 3135 mm.

Range of applications:

Furniture industry for facing, visible sides, fillings, covers, and so on. Interior wall and ceiling covering, sliding doors, architectural doors, et cetera.

Technical data:

Sizes in “mm”: 1270 x 3135 mm
3135 x 1270 mm
1050 x 2450 mm
The first mentioned size indicates the direction of embossing and the grain direction of veneer.

Thickness: 18,5 mm

Size accuracy : +/- 1,0 mm per meter

Straightness: 3,0 mm per meter

Thickness allowance: +/- 0,5 mm

Density (kg/m3) approximately 800 kg/m3 equivalent to 14,7 kg/m2 up to 15,5kg/m2 depending on surface composition. For panels with metal coatings a weight of 900kg/m3 and 16,6 kg/m2 has to be assumed.

Packing: holohedral lying on pallet.

Storage: Ample vented, dry and without influence of frost and/or moisture.
At all times the panels have to be stored holohedral, seated solidly. Veneered panels have to be protected against the sun-light. **Adequate conditioning before processing is also very important.**

Processing: **It is compellent that during any mechanical processing BRUSH panels are seated solidly with at least 50% of the surface to be processed!**

Sawing: Use sharp hard metal sawing blades and a low sawing feed rate. Scoring is not absolutely necessary.

Milling: On milling and shaping hard metal tools should be used.

Drilling: For drilling the standard drilling tools and machines for woodworking can be used.

Screws: We recommend primary drilling before using screws to avoid splitting of the panel.

Gluing and bonding: All standard wood glues and adhesives can be used. We recommend the use of formaldehyde-free glues. If you have to double materials in thickness, the reverse side has to have the same, homogenous compositions. For example: 9mm panel – 10mm core board – 9mm counter draw panel.

Edges and lacquering: Not applying edging material can lead to cracks in the material. **It is absolutely important to follow our instructions included in our processing guidance “edge and surface – flat structure with shallow pattern”!** Sanding after edge-banding. Then priming and the final lacquering. Please follow the instructions of your lacquer manufacturer. **Panels always holohedral – seated solidly – no hanging of the edges!** Lacquer always both sides! **Never use wall paint on “Holz in Form” panels!**

Attention! If you need to encase equipment that emits heat please contact us before to avoid later damages.

Recycling: The thermal use of the relief panels does no cause any problems (no PVC).

Explanatory notes: The given details in this data sheet are our field-tested experience. They cannot consider all parameter, use case or application and they are therefore without commitment!
These data do not represent guarantee of condition in the legal sense or an assurance of the characteristics. No legal claims can be derived neither by using the information given in this data sheet nor by information received from our free of charge technical consultants.

Please contact us if there are questions regarding our products.