



RIGA®

DOT

Product

Birch plywood (Riga Ply) overlaid with a phenol, UV resistant or melamine film on both faces. The wear face has a special surface pattern (WT). Pattern gives dot effect. The reverse face usually is smooth (F).

Film color

Phenol films: Dark brown 120 and 220g/m², Black 120g/m², Light Brown 120g/m², yellow 167g/m².
UV resistant films: Dark grey 220g/m², Light grey 220g/m², White melamine 200g/m², Opal white 174g/m².
Under transparent films BB grade veneer can be applied.

Applications

Transport industry: finishing of walls and ceilings; industrial furniture: components, shelving system and table tops; shop fitting; exhibition stands; booths, advertisement and information boards.

Advantages

Environmentally friendly, durable, easily workable, hygienic, odour free, easy-to-clean, wear resistant, weather- and water-proof, resists commonly used chemicals.

Further processing

Plywood can be machined with wood working tools: cutting, drilling, milling, jointing in length, tongue and groove (T&G), half laps, profiled edges etc.

Gluing classes

Plywood is glued with waterproof phenol formaldehyde resin adhesive. The weather and boiling water resistant bonding meets the requirements of the following standards:

EN 314 / 3rd class;
BS 1203 / H 4 (previously WBP);
DIN 68705 Part 3 / type BFU 100.

Formaldehyde emission

In accordance with the standard EN 13986 the formaldehyde emission meets the Class E1 requirements (test method EN 717 Part 2). Plywood glued with phenol-formaldehyde resins meets the CARB Phase 2 and Japanese 4-Star Regulation's requirements. Raw plywood Riga Ply, also used as film-faced panels core, corresponds to the Finnish Classification of Building Materials M1.

Overlaying

A matt phenol, UV resistant or melamine film, which is hot-pressed onto the surface, is used as an overlay. The phenol film is composed of a basic paper which is impregnated with phenol resin. The UV resistant film is impregnated with a special thermosetting mixture of polymers containing amino resins. The melamine film is a modified resin based film with improved crack resistance for the decorative lamination of plywood. Overlaying with higher resistance to abrasion and multi-layer overlaying is also possible (respectively 240g/m²; 440g/m², etc.). Multi-layer overlaying gives superior wear resistance.

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Characteristics of overlay

Surface with an overlay is smooth, matt and hard. It resists abrasion, it is weather and moisture proof and resists commonly used chemicals, dilute acids and alkalis. The surface is easy to clean with water or steam. Abrasion resistance according to the Taber test (EN 438-2): depends on applied film, conditions of product storage, thickness of film (see below) a.o. Overlaid plywood's wear resistance may be superior to 10'000 revolutions.

Latvijas Finieris specialists will assist you in choosing the most appropriate product.

Edge sealing

The panels' edges are sealed with an acrylic paint, to avoid absorption of moisture. The edge sealing paint and the panels' face colors match, but even other colors are available upon request.

Sizes

1220 mm x 2440 / 3050mm
1250 mm x 2500 / 2750 / 3000mm
1500 mm x 2500 / 3000mm
1525 mm x 2750 / 3050mm

3150mm upon special request

Cut-to-size panels and machined panels available in accordance with the customers' requirements.

Thickness

6.5, 9, 12, 15, 18, 21, 24, 27, 30, 35

Tolerance

Dimensional and right angle tolerance meets the standard EN 315 requirements.

Nominal thickness, mm	6.5	9	12	15	18	21	24	27	30	35
Number of plies	5	7	9	11	13	15	17	19	21	25
Average actual thickness, mm	6.4	9.2	12.0	14.9	17.7	20.5	23.4	26.5	29.4	35
Lower limit, mm	6.1	8.8	11.5	14.3	17.1	20.0	22.9	25.8	28.7	33.6
Upper limit, mm	6.9	9.5	12.5	15.3	18.1	20.9	23.7	26.8	29.9	35.4

Parameter	Tolerance
Length, width (mm)	
< 1000	± 1 mm
1000...2000	± 2 mm
> 2000	± 3 mm
Right angle	± 0.1 %
Edge straightness	± 0.1 %

Plywood is manufactured by AS Latvijas Finieris whose Quality Management System is certified to the requirements of ISO 9001 by Bureau Veritas Certification.



The given information is for reference only and AS Latvijas Finieris reserves the rights to amend and supplement the specifications of manufactured products without a prior notice.

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