

**RIGA**<sup>®</sup>

# FORM

## Product

Birch plywood (Riga Ply) bonded with waterproof phenol resin adhesive and overlaid on both the sides with a phenol film or with an UV resistant film (grade F/F).

## Film color

Phenol films: dark brown (120, 130 (wear resistant) and 220g/m<sup>2</sup>), light brown (120g/m<sup>2</sup>), yellow non-transparent (167g/m<sup>2</sup>), green (120g/m<sup>2</sup>), black (120g/m<sup>2</sup>), red (220g/m<sup>2</sup>), honey (120g/m<sup>2</sup>), UV resistant films: opal white (174g/m<sup>2</sup>), grey (174g/m<sup>2</sup>), blue (200g/m<sup>2</sup>). Under transparent films BB grade veneer can be applied.

## Applications

Shuttering, transport industry, building and construction, flooring, inter-wall structures in farms, advertisement and information panels, furnishing panels.

## Advantages

Environmentally friendly, durable, easily workable, hygienic, odour free, easy-to-clean, wear-resistant, weather- and water-proof, resists commonly used chemicals. Riga Form for shuttering can be re-used many times.

## 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 / 3<sup>rd</sup> class;  
BS 1203 / H4 (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.

## Overlaying

A smooth phenol or an UV resistant 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. Overlaying with higher resistance to abrasion and multi-layer overlaying is also possible (respectively 240 g/m<sup>2</sup>, 440 g/m<sup>2</sup>, special wear resistant film, etc.). Multi-layer overlaying gives superior wear resistance.

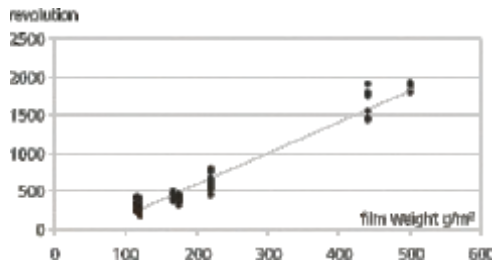
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## Characteristics of overlay

Surface with an overlay is smooth, glossy 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.

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 / 3050 mm
- 1250 mm x 2500 / 3000 mm
- 1500 mm x 2500 / 3000 mm
- 1525 mm x 3050 / 3660 mm
- 2150 mm x 3050 / 3340 / 3850 mm

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

## Thickness

4, 6.5, 9, 12, 15, 18, 21, 24, 27, 30, 35, 40, 45, 50 mm.

## Tolerance

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

Nominal thickness, mm	4	6.5	9	12	15	18	21	24	27	30	35	40	45	50
Number of plies	3	5	7	9	11	13	15	17	19	21	25	29	32	35
Average actual thickness, mm	3.8	6.4	9.2	12.0	14.9	17.7	20.5	23.4	26.5	29.4	35	38.7	43.6	49.6
Lower limit, mm	3.5	6.1	8.8	11.5	14.3	17.1	20.0	22.9	25.8	28.7	33.6	38.4	43.3	48.1
Upper limit, mm	4.1	6.9	9.5	12.5	15.3	18.1	20.9	23.7	26.8	29.9	35.4	41.2	46.6	51.7

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.



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