SWISS KRONO

SWISS**SPAN DECOR**

Melamine faced particleboards for furniture and indoor surfaces

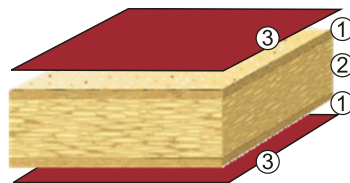|	
Characteristics	SWISS**SPAN DECOR** is a wide range of decorative melamine lined particleboards for furniture and indoor surfaces. Countless combinations of plain, wood, and fantasy decors with various structures can be chosen from.
	SWISS**SPAN DECOR** melamine lined particleboards are made to Swiss precision with wood from sustainable Swiss forests.
	The decor papers impregnated with melamine resin are applied to the SWISS**SPAN** base boards on short cycle presses to form a robust, diffusion tight, easy care surface with a high quality look. All raw papers are made free of chlorine.
Use	SWISS**SPAN DECOR** is suitable for classical, non-load-bearing indoor and furniture applications in dry areas:
	¬ as decorative, robust, and high quality furniture elements (body, fronts, shelving)
	¬ as horizontal and vertical faces on indoor surfaces
Technical class	Melamine faced board for indoor uses according to EN 14322; particleboard according to EN 312, type P2 (indoor fittings including furniture)

Product structure

Classical furniture board for many and diverse applications:

¬ Melamine resin impregnated decor papers (3) are pressed on both sides of the particleboards. Under heat and pressure, the resins cure completely, forming a tight bond between the board and paper. The result is a largely diffusion tight surface.

¬ The base board is a multi-layered structure of coarse, flat particles in the centre ply (2) and fine particles in the top ply (1).

Processing	¬ SWISS**SPAN DECOR** can be processed with the usual woodworking tools.
	¬ Edges are available in different materials in colour combinations.
	¬ Storage conditions: Boards must be placed flat over their whole surfaces at 15–25 °C and 45–65% relative air humidity.
	¬ The constant action of heat is permitted at temperatures no greater than 50 °C. Over brief periods (max 1 hour), temperatures as high as 90 °C are permitted.
	¬ The surface can be cleaned with a damp, mild, nonabrasive cleaning agent. No acids, lyes, or abrasive agents.

Certificates / Labels

Swiss Made Swiss Quality | Certified Quality and Environmental Management | Low CO_2-production | Swiss Wood | Sustainable forest management (certificates can be provided upon request)

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Technical Specifications

Product range

The current delivery programme can be found at www.swisskrono.ch → Interiors

Technical specifications for base board SWISS**SPAN P2**

EN 312, type P2

Thickness	**8-13**	**15-19**	**22, 25**	**28, 30**	**33-40**	**>40**	mm	EN 324-1
Final surface sanding (Grit size)	100	100	100	100	100	100		
Density	680-760	630-680	600-630	600-630	580-620	560-600	kg/m³	EN 323
Bending strength	11.0	11.0	10.5	9.5	8.5	7.0	N/mm²	EN 310
Modulus of elasticity	1800	1600	1500	1350	1200	1050	N/mm²	EN 310
Internal bond strength	0.40	0.35	0.30	0.25	0.20	0.20	N/mm²	EN 319
Surface soundness	1.0	1.0	1.0	1.0	1.0	1.0	N/mm²	EN 311
Moisture content	5-6	5-6	5-6	5-6	5-6	5-6	%	EN 322
Lindane | Pentachlorophenol	n.d. | n.d. mg/kg (n.d. = not detectable)							CEN/TR14823
Formaldehyde content	E1 ≤ 6.5 mg/100g dry board							EN 120
Formaldehyde release	E1 ≤ 0.124 mg/m³ air							EN 717-1

Technical specifications lined board SWISS**SPAN DECOR**

EN 14322: Melamine faced boards for interior use

Decor variant		Plain decors	Wood, fantasy, trend			Standard
Wear resistance		3A	1	Class [1–4]		
IP | WP		≥ 150 | ≥ 350	< 50 | < 150	Rotations		EN 14323
Behaviour at scratches		1.5	1.5	N		EN 14323
Cracking susceptibility		5	5	Level [1–5]	5 – No cracking 1 – Surface cracking	EN 14323
Behaviour under water vapour		4	4	Level [1–5]	5 – No damage 1 – Blistering/ delamination	EN 14323
Colour/surface agreement		4	4	Level [2–5]	4 – minor diffe- rences possible	EN 14323
Stain resistance	Group 1	5	5	Level [1–5]	5 – No damage 1 – Damage/ blistering	EN 14323
	Group 2	4	4			
Colour fastness (xenon arc lamp)		≥ 4	≥ 4	Levels [3]		EN 14323
Formaldehyde release		≤ 1		mg/(m²h)		EN 717-2
		≤ 0.03		ppm		EN 717-1
Tolerances		Thickness ±0.3 mm | Thickness difference in board ≤ 0.6 mm | Distortion ≤ 2 mm/m Length x width for 2.80 x 2.07 m ± 5.0 mm, for trim ±2.5 mm Edge roughness on 2.80 x 2.07 m ≤ 10 mm, for trim ≤ 3 mm Surface defects: Points ≤ 2 mm²/m², length error ≤ 20 mm/m				EN 14323
Ecological characteristics		Renewable energy > 90% | Wood 80–85% | UF adhesive 8–10% | Swiss wood | No post-consumer recycled content | No chlorides No biocides in wood | No heavy metals in lining | thermally recyclable				SIA 493.05

Safety and other information

- ¬ Owing to their weight and size, special care must be taken in handling the boards (proper way of lifting, risk of crushing, etc.).
- ¬ Processing can give rise to saw- and grinding dust. Do not breathe in this wood dust (protective equipment and suction)! Suction equipment should always be used to remove wood dust. The risk of explosion is therefore minimised. Store unprocessed boards horizontally in a dry environment!
- ¬ The product is not on the list of hazardous substances, nor is it subject to precise labelling requirements (Dangerous Substances Ordinance / Waste Traffic Ordinance).
- ¬ The product is chemically stable and has no toxic effects. It is suitable for indoor applications.
- ¬ SWISS **SPAN DECOR** is a product from sustainable forest management. The wood used comes from forest thinnings, and so helps to keep Swiss forests healthy.
- ¬ The product can be recycled after the first lifecycle or converted into heat in a suitable plant (CO2 free energy).

SWISS KRONO AG

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