



HOLZMANUFAKTUR HÖXTER

Spezialverbundplatten für technische Türen

Datasheet Aluminum Core Sandwich Panel

Range of application:

Aluminum core sandwich panels are being used in the construction of interior doors with climate class requirements as a vapor control layer. The processing company is responsible for testing if our product meets his guidelines of application.

Composition:

- **Surface layer:** 2 x Wood Fibre Board *corr.* DIN EN 622-2 Thickness 1,6 to 4,0 mm
- **Middle layer:** 1 x Aluminum sheet AL 99,5, Thickness 300µ/500µ
- **Bonding:** PVAc D-3 Glue, on request with Isocyanides cross linker

Handling and Storage:

- **Handling:** The aluminum core sandwich panels shall be used in process only when cooled down app. 4 days after production. Static electricity is to be avoided.
- **Storage:** The boards shall be stored only horizontally on a pallet. It has to be insured that the aluminum core sandwich panels cannot absorb moisture. This could result in the delamination of the aluminum due to its reflecting effect. Therefore the storage in a dry and ventilated environment is required. **When Funder Biofibre is being used:** due to the fact that Funder boards do not contain biocides or other preservatives a fungal attack can occur when the boards are disposed to condensation and insufficient ventilation.

Processing:

- Prior to processing the aluminum core sandwich panels have to be acclimatized according to the climatic environment of the production facility
- Suitable glues for processing are urea-based glues, D-3, D-4
- Press temperature is not to exceed 90 °C during processing
- Depending on the used glue the according pressing time is applicable
- Excessive calibration and/or sanding of the surface layer can result in the delamination of the aluminum core during the processing of the door (steam bubble).

Subject to changes Status: April 2016