



HOLZMANUFAKTUR HÖXTER

Spezialverbundplatten für technische Türen

Datasheet Lead Core Sandwich Panel

Range of application:

Lead core sandwich panels are being used in the construction of interior doors with special requirements for radiation shielding and soundproofing. 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 Sheet of lead, Thickness 500 μ /1000 μ /1500 μ /2000 μ
- **Bonding:** PVAc D-3 Glue

Handling and Storage:

- **Handling:** The lead 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 lead core sandwich panels cannot absorb moisture. This could result in the delamination of the lead 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 lead 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 lead core during the processing of the door (steam bubble).

Subject to changes Status: April 2016