
 AGT <i>think with us</i>	PANEL MDF TECHNICAL SPECIFICATION	Yayın Tarihi	17.06.2013
		Revizyon No.	0
	Doküman No: 170-ŞT-002	Revizyon Tarihi	17.06.2013
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Properties and Terms of Use of AGT Sheet Profiles AGT MDF Panel

1	There is the original stretch film on the covered HG folio. Protective stretch film is applied on the PVC folio surfaces.
2	Calibration (sanding) is applied before the process of covering HG fiber sheet panel surfaces.
3	Surface roughness value is 0,08 μ averagely in our HG fiber sheet panel product. At the most 1 piece of pimple having diameter less than 5 mm can exist in 1 m ² surface. However, 2 pieces of pimples having diameter less than 3 mm and the distance of pimples is not less than 25 cm can exist in 1 m ² surface
4	Production tolerance for the defects in tip parts in fiber sheet panels is 7 mm in one side and 10 mm in one side when the production is made with folios sent by customer.
5	Same sized fiber sheet panels are palletized by putting protective carton on the same palette and putting carton with logo on it.
6	Palettes are packaged with stretch film and ring.
7	Each package is labeled with the label indicating its content. In the case of special palette demands, labels defining its content are put on palette.
8	Fiber sheet panels are put on the palette for transportation and sent by covering with shrink protective nylon.
9	Piles of fiber sheet panels should be made carefully against crush, collapse and breakage in sides and corners when processing.
10	While cutting the fiber sheet, circular saw with buttress gear should be used.
11	The angle of the circular saw of the cutting machine should be considered to be 90 degrees.
12	In order to have a better result, saw with plotter jumping should be used during while cutting the fiber sheet.
13	The height of circular saw should be as to block the rolling of the saw while cutting.
14	The production should be performed by blocking the friction of surfaces in order to prevent the damage of the surface in fiber sheet products.
15	Because especially HG fiber sheet is vulnerable to impacts and scratch, it is recommended to be careful during production and assembly processes and usage.
16	It is inconvenient to use fiber sheets in places receiving direct sun light, gardens, places washed with water and humid environments in terms of their lifetimes.
17	Saw with jumper should be used while cutting the fiber sheet panels.
18	The most convenient saw cutting speed is 15 m/min while cutting the fiber sheet panels.
19	Covering with protective stretch film on the fiber sheets should be removed after the completion of the assembly. High gloss fiber sheet should be cleaned

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	with wet rag or wood cleaner after the removal of the stretch film.
19	The products should be kept waiting for at least 3 days for control after order and production. In the order planning, the duration for 3 days shall be taken into consideration.
20	The products shall be stored in appropriate conditions. The relative humidity of the storage environment shall be 50 % and the humidity rate of the product should be 7-9 %.

Return Conditions of AGT Fiber Sheet Panels

1	The problems should be notified to AGT at the latest 1 month after the delivery of the product. The notifications exceeding 1 month shall not be taken into account.
2	Our firm cannot be held responsible for the omission of the instruction manuals described above, user errors and other inappropriate conditions. In this case, return shall be inadmissible.
3	Written statements as "appropriate loading is made" is taken from the relevant transport company during the delivery of the products. Return shall be inadmissible in the case of damages caused by the transport company during the delivery. In the case of the determination of this condition, the damages of the both two firms shall be compensated by the transport company.
4	Claim for return shall be sent with the error definition, test results, if available, and document indicating the error visually and clearly about the product of which is wanted to be returned. After the examination of the documents pertaining to the error in the return demand, if needed a sample shall be demanded and its analysis and controls shall be performed. Return condition shall be determined in the direction of the result of "Returned Product Examination Report". Without "Returned Product Examination Report", no product shall be taken for return.
5	Anyone outside the firm cannot suggest a different guarantee condition except these conditions and cannot demand.

Properties of AGT Fiber Sheet Panels


Technical Properties	Unit	Value	Test Method
Adhesion Resistance	N/mm ²	≥ 0,55	ASTM D6862-04
Temperature Resistance	°C	≤ 90	---

Properties of Fiber Sheet

Technical Properties	Unit	Value	Test Method
Intensity	kg/m ³	7.7-12-16-18 mm: 750 ± 7% 22-25-30 mm: 720 ± 7%	EN 323

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Thickness Tolerance	mm	7.7-12-16-18 mm: $\pm 0,20$ mm 22-25-30 mm: $\pm 0,30$ mm	EN 324-1 EN 622-1
Aspect Tolerance	mm/m	± 2 mm/m, maximum ± 5 mm	EN 324-1 EN 622-1
Squareness Tolerance	mm/m	2 mm/m	EN 324-2 EN 622-1
Side Smoothness Tolerance	mm/m	1.5 mm/m	EN 324-2 EN 622-1
Inflation in Thickness 24 hours	%	7.7 mm $\leq 17\%$ 12 mm $\leq 15\%$ 16-18 mm $\leq 12\%$ 22-25-30 mm $\leq 10\%$	EN 317 EN 622-5
Inflection Resistance	N/mm ²	7.7 mm ≥ 23 N/mm ² 12 mm ≥ 22 N/mm ² 16-18 mm ≥ 20 N/mm ² 22-25-30 mm ≥ 18 N/mm ²	EN 310 EN 622-5
Inner Adhesion	N/mm ²	7.7 mm $\geq 0,65$ N/mm ² 12 mm $\geq 0,60$ N/mm ² 16-18-22-25-30 mm $\geq 0,55$ N/mm ²	EN 319 EN 622-5
Formaldehyde Content	mg/100g	≤ 8 mg/100g	EN 120 EN 622-1
Humid Content	%	4 \div 11%	EN 322 EN 622-1

Properties of PVC and HG Folio

Technical Properties	Unit	Value	Test Method
Thickness (PVC)	mm	0,20 \pm 10%	EN ISO 11833-2
Thickness (HG)	mm	0,30 \pm 10%	EN ISO 11833-2
Glossiness (HG)	60°	≥ 90	EN ISO 2813
Surface Roughness (HG)	R _a , μ m	$\leq 0,10$ μ m	EN ISO 4288
Surface Tension (PVC, HG)	mN/m	≥ 38 mN/m	ISO 8296
Color Measurement (ΔE)	---	≤ 0.65	DIN 5033-4
Scratch Resistance (PVC)	N	1,1 – 1,5 N	ISO 4586-2
Scratch Resistance (HG)	N	0,5 – 1,0 N	ISO 4586-2

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UV Resistance (ΔE)	200 hours	≤ 0.80	TS EN 4892 (1-2-3)
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Properties of Polyurethane Glue

- ✓ Polyurethane based reactive hot melt adhesive system
- ✓ White heat resistance (> 150 °C) and elasticity in cold
- ✓ High first adhesion power
- ✓ Chemical bond formation in a couple of days
- ✓ Perfect resistance against water
- ✓ Thermoset formation of adhesion connection
- ✓ Resistance against several solvers

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