



# TECHNICAL DATA SHEET

## ALPI

### Technical data sheet /

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ALPI leader in the production of decorative engineered wood surfaces, thanks to constant R&D activities, provides highly diversified solutions in terms of types of wood, perfectly replicating the colors and grain of natural wood, or creating patterns that cannot be found in nature, with utterly original chromatic effects, also when combined with materials of other kinds. The range includes over 90 catalogue proposals available in stock\*, which ALPI constantly updates and enriches to respond to all the creative needs of designers, alongside the unlimited selection of bespoke solutions. The continuity of supply of the same articles over time represents an important plus for the world of design, together with absolute certification of the origin of the materials.

Infinite design potential: continuously upgraded and enhanced, ALPI woods can be combined in an enormous variety of wood types, textures and color variants. The catalogue collections are subdivided into the Wood and Designer lines, where the latter includes creations from some of the outstanding names on the international design scene.

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\*Availability of Alpi veneers may vary and require minimum quantities and technical delivery times. We suggest to contact Alpi Customer Service to check veneer availability.

# ALPIlignum Veneer /

ALPI veneer is the core and symbol of the ALPI universe, the highest expression of the R&D activities, and the perfect combination between technological innovation and fine craftsmanship. This product offers unlimited customization and aesthetic variety. It can be applied to any surface, and supplied in different thicknesses for different uses. It is therefore extremely versatile, ready to respond to any design needs in terms of function and looks. By request, ALPI wood is available with FSC® certification, the most authoritative on an international level, guaranteeing the sustainability of the raw materials. ALPI veneer also comes in the ALPIform version, bonded with non-woven fabric, thus combining the aesthetic virtues of wood with the great flexibility made possible by the special fabric backing, making the product ideal for soft-forming. ALPIform permits very narrow curvature and reduction of waste. It is easy to stain and varnish, making it ideal for the cladding of curved surfaces or the creation of wrapping edge banding.

## Usage sectors /

Surfaces for furnishings; surfaces and facings for interior architecture; hotels, multi-apartment and residential complexes, shops, retail outlets, offices, public spaces; wood for floors, window and door frames, wall paneling, acoustic paneling; surfaces and facings for the interiors of yachts and cruise ships; dashboard surfaces and interior finishing for automobiles; objects.

# ALPIlignum Technical Features /

## ALPIlignum /

ALPIlignum is a decorative multilaminar wood veneer that complies with standard ISO 18775.

### Average Weight Composition /

Poplar wood and/or Ayous wood, and/or Basswood	70-80%
Resins	16-26%
Dyes	< 1%
Moisture content	min 4% - max 14%

Being a wood product, ALPIlignum's moisture content may vary depending on environmental conditions during transport and storage.

### Possible Dimensions /

Ayous Veneer	length 2000-2200-2300-2500-2600 mm width 620-680 mm*
Poplar Veneer	length 2000-2200-2500-2800-3150 mm width 620-680 mm*
Basswood Veneer	length 2200-2500-2800-3150 mm width 620-680 mm*

Veneer dimension may be customized upon request and for specific product lines. 18.42, 18.15, 18.16 Delivered already backed with a fleece paper.

\*With the exception of some product lines.

### Thickness /

0.5-2.5 mm	with the following nominal thickness intervals
Up to 1.5 mm (included)	nominal interval 0.05 mm
Over 1.5 mm	nominal interval 0.10 mm

We can customize veneer dimensions for specific product lines upon request.

### Dimensional Tolerances /

Length and Width	pursuant to sales agreements
Thickness	complies with standard ISO 18775

### Wood Density /

450-900 kg/m3 (measured in compliance with standard IS9427)

## ALPllignum Technical Features /

### ALPllignum /

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#### Formaldehyde Emission /

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In compliance with E1 (analyzed according to EN 717).

On request ALPI can supply ALPllignum with two levels of formaldehyde emissions below the E1 standard:

BE - ALPllignum with a formaldehyde emission level equal to a fraction of the E1 standard.

ZeroF - ALPllignum without added formaldehyde. It is in any event impossible to guarantee a complete absence of formaldehyde in ALPllignum wood veneers as formaldehyde is a naturally-occurring substance in wood.

#### Light Fastness /

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ALPllignum is not a finished product and therefore its resistance to light in part depends on the cycle and chemical nature of the finish. On demand, ALPI can supply a version of ALPllignum Radiant which, if nished with an appropriate varnishing cycle, can achieve values of > 3 on the grey scale(EN438-2/27). The buyer is advised that discoloring may occur. It is recommended that the buyer perform advance tests depending upon the particular purpose and intended use in order to optimize results.

#### Mechanical Specifications /

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The mechanical characteristics of ALPllignum depend on the cycle and chemical nature of the finish and the type of backing. It is recommended that the buyer perform prior tests depending upon the particular purpose and intended use in order to optimize results.

#### Colour and Structure /

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Being a natural wood product, ALPllignum may vary in its reference colour. It is recommended that before use the buyer check both the colour and the grains of the delivered product as against the ordered product.

#### Storage /

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ALPllignum is mainly made of wood and its moisture content may therefore be subject to variation depending on the storage and work environment. It is therefore advisable to maintain humidity in the range between 40% and 70% (RH) and a reference ambient temperature of 20°C.

#### Warnings /

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Avoid - even temporarily- any contact with water and other liquids. Avoid any moisture condensation on product surface. The product must be stored on a flat surface at least 200 mm from the ground. ALPllignum must be protected from direct and indirect light.

## ALPllignum Recommendations for Use /

### ALPllignum /

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#### Veneering /

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##### Glueing With Urea Glues

ALPllignum veneer can be glued on all wood backing using by means of urea glues. Different kinds of backing must be tested and assessed on a case-by-case basis. The quantity of glue to be used per square meter depends on the base type and thickness, on the veneer structure (quartered cut, tangential cut, burl, etc.), on its thickness and on the type of pressing. It is generally advisable not to use more than 150 g/m<sup>2</sup> of glue at pressures ranging from 1.5 to 5 bars. The recommended veneering temperature may range between 85°C and 120°C. The glue may be added with organic or inorganic fillers to modify its rheological properties in order to control bleeding through the veneer layer. The use of pigments with similar shades to the veneer base color is always recommended. Basswood-based products should be laminated on panels, using urea glue with an application of at least 120/140g/m<sup>2</sup>.

##### Glueing With Vinyl Glues

ALPllignum veneer can be glued on all wood support using vinyl glues. Different kinds of support need to be previously tested. Because of the thermoplastic features of this type of glue, the quantity to be applied must be carefully measured according to the type of veneering in order to avoid undesirable pass-through of the glue which would prove difficult to eliminate through sanding. It is generally advisable to use between 80 and 100g/m<sup>2</sup> of glue at pressures ranging from 1.5 to 3.5 bars. The advisable veneering temperature may vary between 60°C and 90°C. The use of pigments with similar shades to the veneer base color is always recommended.

##### Glueing With Hot Melt Glues

ALPllignum veneer can be glued on all wood backing using hot melt glues such as polyolefin, EVA and reactive polyurethane. Different kinds of backing need to be tested. This type of glueing is mainly used to bond small surfaces, such as edges, with the help of automatic systems that have a mechanical clamp. The use of other veneering systems must be checked through preliminary testing. In every case, however, it is advisable to follow the instructions provided by the glue supplier.

#### Sanding /

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After the veneering process ALPllignum must be sanded in order to prepare and clean the surface for the varnish application. This process must be carried out with 120-150-180 grit sandpaper in a single step or in sequence using manual or automatic sanding machines. The use of 100 grit or 220/240 grit sandpaper is advised only for special decorative effects. The transversal sanding process with 120-150-180 grit sandpaper must be carried out at low strength and in any case may cause some microgroove traces and superficial rifts mainly on basswood-based ALPllignum, it is advisable to follow the instructions provided by the glue supplier.

#### Varnishing /

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Like all other types of wood, the varnishing process for ALPllignum must be performed with a suitable product capable of protecting and preserving the wood as much as possible from chemical and physical deterioration (photodegradation, thermal decay, etc.) as well as from mechanical degradation (scratches, dents, etc.). Wood veneer can be stained without any particular problems. ALPllignum can be varnished with any product or method recommended for wood treatments. However, the best results are achieved by selecting, among the various classes of products, those with the following characteristics:

- High wetting power
- High yellowing retardation power
- High UV protection

As for water paints, it is advisable to use products that are stable at a moderately acid pH (4-6), such as specific products destined for acid hardwoods. It is common practice to follow the instructions provided by finish manufacturers and to carry out preventive tests before proceeding to varnishing.

Please contact ALPI's technical office for any further clarification. This technical data sheet supersedes and replaces any previous version. The information and recommendations herein have been compiled from the current information held by ALPI and may be our best knowledge updated to perform the higher results of the applications.

## ALPllignum Radiant Technical Features /

### ALPllignum Radiant /

ALPllignum Radiant is a wood veneer alternating plastic lines and wood.

#### Average Weight Composition /

Poplar wood and/or Ayous wood, and/or Basswood	74%
Resins	22%
Dyes	1%
Plastic	3%

#### Possible Dimensions and Structure /

Poplar Wood	length 2500 mm width 320 mm (usable width 290 mm)
Ayous Wood	length 2500 mm width 320 mm (usable width 290 mm)
Bass Wood	length 2500 mm width 320 mm (usable width 290 mm)
Veneer Nominal Thickness	0.6 - 0.8 mm
Board Nominal Thickness	min 3 mm - max 300 mm
ALPllignum pattern	Striped

#### Transparent Lines /

Transparent Line Width	0.25 mm - 0.375 mm - 0.5 mm
Minimum Spacing Transparent Line	4 mm
Transparent Line Number	max 75 on the width

## ALPllignum Radiant Technical Features /

### ALPllignum Radiant /

#### Formaldehyde Emission /

In compliance with E1 (analyzed according to EN 717).

On request ALPI can supply ALPllignum Radiant with two levels of formaldehyde emissions below the E1 standard:

BE - ALPllignum Radiant with a formaldehyde emission level equal to a fraction of the E1 standard.

ZeroF - ALPllignum Radiant without added formaldehyde. It is in any event impossible to guarantee a complete absence of formaldehyde in ALPllignum Radiant wood veneers as formaldehyde is a naturally occurring substance in wood.

#### Light Fastness /

ALPllignum Radiant is not a finished product and therefore its resistance to light in part depends on the cycle and chemical nature of the finish. On demand, ALPI can supply a version of ALPllignum Radiant which, if varnished with an appropriate varnishing cycle, can achieve values of > 3 on the grey scale(EN438-2/27). The buyer is advised that discoloring may occur. It is recommended that the buyer perform advance tests depending upon the particular purpose and intended use in order to optimize results.

#### Mechanical Specifications /

The mechanical characteristics of ALPllignum Radiant depend on the cycle and chemical nature of the finish and type of backing. It is recommended that the buyer perform advance tests depending upon the particular purpose and intended use in order to optimize results.

#### Colour and Structure /

Being a natural wood product, the reference color of ALPllignum Radiant may vary. It is recommended that before use the buyer check both the color and the grain of the delivered product against the product ordered.

#### Storage /

ALPllignum Radiant is mainly made of wood and its moisture content may be subject to variation depending on the storage and work environment. It is therefore advisable to maintain humidity in a range of between 40% and 70% (RH) and a reference ambient temperature of 20°C.

#### Warnings /

Avoid - even temporarily - any contact with water and other liquids. Avoid any moisture on the product surface. The product must be stored on a flat surface at least 200 mm to the ground. ALPllignum Radiant must be shielded from direct and indirect light.

## ALPllignum Radiant Recommendations for Use /

### ALPllignum Radiant /

#### Backing /

ALPllignum Radiant may be applied to the following backing: Polymethyl methacrylate (PMMA), Polycarbonate, Co-Polyester (PETG), Polyvinylchloride, (PVC), Polyester (PET) and Glass. Greater attention is required if the rear of the panel has a aesthetical function: in such cases, it is advisable to use opal, smoked, coloured or textured backing. The product may be applied on other types of backing. We suggest anyway to carry out some previous test.

#### Cutting /

ALPllignum Radiant may be trimmed using a professional cutter machine with a simple bevelling blade to ensure a cut that is orthogonal to the plane. Another option is to cut using a high-powered laser to guarantee accurate rectilinear results. A further alternative is to cut using the assistance of a hand blade with metal reference squaring. In any event, it is advisable to undertake the cut along the centre line of the wooden section in order to minimize processing tolerances.

#### Splicing Multiple Sheets /

The seaming process may be undertaken manually with the assistance of masking tape, which should always be applied on the face-up side, and then subsequently be removed after the plating process. Automatic seaming systems may be used as an alternative.

#### Veneering /

ALPllignum Radiant may be glued to plastic backing using hot melt polyurethane glue. For aesthetically-optimal gluing, it is advisable that after calendering ALPlradiant to the backing, the sheet be placed under a cold press to ensure that the glue is spread as evenly as possible. Glueing with solvent based acrylic glues and double-sided foam tape are advisable only if the back of the sheet is not exposed. For glueing on glass, it is advisable to adopt a vacuum glueing process using EVA-based glue. Different types of gluing and backing must be tested in advance on a case-by-case basis.

#### Sanding /

ALPllignum is a composite material and the sanding step has to be operated to avoid excessive development of heat, on the decorative surface. To optimize the process, it is advisable to reduce 20% - 30% the speed of Sand-Paper Belt and selecting an appropriate Sand-Paper Grit Index (150-180 grit).

#### Varnishing /

ALPllignum Radiant may be varnished using two-pack acrylic cycles of various glosses, or two-pack polyurethane cycles of various glosses, and ultra-violet drying acrylic cycles of various glosses. It may also be varnished using water-based cycles of various glosses. Different types of varnishing must be tested on a case-by-case basis.

#### Practical Advice /

To avoid possible alignment anomalies, during seaming it is possible to insert a section of ALPllignum between the two portions of ALPllignum Radiant to be seamed in order to make the coupling gap less visible. When assembling the ALPllignum Radiant panels, it is possible to use sections of wood as a joint between the panels, or alternative materials such as aluminium. Heat generated by sources of backlighting may be detrimental to the atness of ALPllignum Radiant panels; it is advisable to use LED based lighting. Appropriate ventilation is recommended for heat dissipation.

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## ALPllignum Silver Rail Technical Features /

### ALPllignum Silver Rail /

ALPllignum Silver Rail is a reconstituted wood veneer alternating metal lines and wood.

#### Average Weight Composition /

Poplar wood and/or ayous wood, and/or basswood	57-75%
Resins	22%
Dyes	1%
Alluminum	2-20%

#### Possible Dimensions and Structure /

Poplar Wood	length 2500 mm width 320 mm (usable width 290 mm)
Ayous Wood	length 2500 mm width 320 mm (usable width 290 mm)
Bass Wood	length 2500 mm width 320 mm (usable width 290 mm)
Veneer Nominal Thickness	0.6 - 0.8 mm
Board Nominal Thickness	min 3 mm - max 300 mm
ALPllignum pattern	Striped

#### Metal Line /

Metal Line Width	0.1 mm - 0.3 mm
Minimum Spacing Metal Line	4 mm
Metal Line Number	max 75 on the width

## ALPllignum Silver Rail Technical Features /

### ALPllignum Silver Rail /

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#### Formaldehyde Emission /

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In compliance with E1 (analyzed according to EN 717).

On request ALPI can supply ALPllignum Silver Rail with two levels of formaldehyde emissions below the E1 standard:  
BE - ALPllignum Silver Rail with a formaldehyde emission level equal to a fraction of the E1 standard.

ZeroF - ALPllignum Silver Rail without added formaldehyde. It is in any event impossible to guarantee a complete absence of formaldehyde in as formaldehyde is a naturally occurring substance in wood.

#### Light Fastness /

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ALPllignum Silver Rail is not a finished product and therefore its resistance to light in part depends on the cycle and chemical nature of the finish. On demand, ALPI can supply a version of ALPllignum Silver Rail which, if finished with an appropriate varnishing cycle, can achieve values of > 3 on the grey scale (EN438-2/27). The buyer is advised that discoloring may occur. It is recommended that the buyer perform advance tests depending upon the particular purpose and intended use in order to optimize results.

#### Mechanical Specifications /

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The mechanical characteristics of ALPllignum Silver Rail depend on the cycle and chemical nature of the finish and type of backing. It is recommended that the buyer perform advance tests depending upon the particular purpose and intended use in order to optimize results.

#### Colour and Structure /

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Being a natural wood product, the reference color of ALPllignum Silver Rail may vary. It is recommended that before use the buyer check both the color and the grain of the delivered product against the product ordered.

#### Storage /

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ALPllignum Silver Rail is mainly made of wood and its moisture content may therefore be subject to variation depending on the storage and work environment. It is therefore advisable to maintain humidity in a range of between 40% and 70% (RH) and a reference ambient temperature of 20°C.

#### Warnings /

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Avoid - even temporarily - any contact with water and other liquids. Avoid any moisture on the product surface. The product must be stored on a flat surface at least 200 mm off the ground. ALPllignum Silver Rail must be shielded from direct and indirect light.

## ALPllignum Silver Rail Recommendations for Use /

### ALPllignum Silver Rail /

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#### Veneering /

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##### Glueing With Urea Glues

ALPllignum Silver Rail veneer can be glued on all wood backing using urea glues. Different kinds of backing must be tested and assessed on a case-by-case basis. The quantity of glue to be used per square meter depends on the base type and thickness, on the veneer structure (quartered cut, tangential cut, burl, etc.), on its thickness and on the type of pressing. It is generally advisable not to use more than 150 g/m<sup>2</sup> of glue at pressures ranging from 1.5 to 5 bars. The recommended veneering temperature may range between 85°C and 120°C. The glue may be blended with organic or inorganic fillers to modify its rheological properties in order to control bleeding through the veneer layer. The use of pigments with similar shades to the veneer base color is always recommended. Basswood-based products should be veneered on panels, using urea glue with an application of at least 120/140g/m<sup>2</sup>.

##### Glueing With Vinyl Glues

ALPllignum Silver Rail veneer can be glued on all wood backing using vinyl glues. Different kinds of backing need to be tested. Because of the thermoplastic features of this type of glue, the quantity to be applied must be carefully measured according to the type of veneering in order to avoid undesirable pass-through which would prove difficult to eliminate through sanding. It is generally advisable to use between 80 and 100g/m<sup>2</sup> of glue at pressures ranging from 1.5 to 3.5 bars.

The advisable veneering temperature may vary between 60°C and 90°C. The use of pigments with similar shades to the veneer base color is always recommended. It is advisable to undertake a glueing test in advance.

#### Sanding /

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After the veneering process ALPllignum Silver Rail must be sanded in order to free the surface from traces of handling and glue. This process must be carried out with 120-150-180 grit sandpaper in a single step or in sequence using manual or automatic sanding machines. The use of 100 grit or 220/240 grit sandpaper is advised only for special decorative effects.

#### Varnishing /

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Like all other types of wood, the varnishing process for ALPllignum Silver Rail must be performed with a suitable product that is capable of protecting and preserving the wood as much as possible from chemical and physical deterioration (photodegradation, thermal decay, etc.) as well as from mechanical degradation (scraping, dents, etc.). ALPllignum Silver Rail can be varnished with any product or method recommended for wood treatments (not water-based varnishes). However, the best results are achieved by selecting from the various classes of products that have the following characteristics:

- Wetting power
- Yellowing retardation power
- UV protection

ALPllignum Silver Rail may be varnished using two-pack acrylic cycles of various glosses, two-pack polyurethane cycles of various glosses, and ultra-violet drying acrylic cycles of various glosses. It is always sound practice strictly to follow the instructions provided by paint manufacturers and to carry out advance tests before proceeding to varnishing.

Please contact ALPI's technical office for any further clarification. This technical data sheet supersedes and replaces any previous version. The information and recommendations herein have been compiled from the current information held by ALPI and may be our best knowledge updated to perform the higher results of the applications.

## ALPllignum Silver Technical Features /

### ALPllignum Silver /

ALPllignum Silver is a reconstituted wood veneer with an iridescent effect.

#### Average Weight Composition /

<b>Poplar wood and/or Ayous wood, and/or Basswood</b>	70-80%
<b>Resins</b>	16-26%
<b>Dyes</b>	< 1%
<b>Moisture content</b>	min 4%- max 14%

Being a wood product, ALPllignum Silver 's moisture content may vary depending on environmental conditions during transport and storage.

#### Possible Dimensions /

<b>Poplar Wood</b>	length 2500 mm width 640 mm
<b>Ayous Wood</b>	length 2500 mm width 640 mm
<b>Bass Wood</b>	length 2500 mm width 640 mm

#### Thickness /

<b>0.5-2.5 mm</b>	with the following nominal thickness intervals
<b>Up to 1.5 mm (included)</b>	nominal interval 0.05 mm
<b>Over 1.5 mm</b>	nominal interval 0.10 mm

We can customize veneer dimensions for specific product lines upon request.

#### Dimensional Tolerances /

<b>Length and Width</b>	pursuant to sales agreements
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## ALPllignum Silver Technical Features /

### ALPllignum Silver /

#### Formaldehyde Emission /

In compliance with E1 (analyzed according to EN 717).

On request ALPI can supply ALPllignum Silver with two levels of formaldehyde emissions below the E1 standard:

BE - ALPllignum Silver with a formaldehyde emission level equal to a fraction of the E1 standard.

ZeroF - ALPllignum Silver without added formaldehyde. It is in any event impossible to guarantee a complete absence of formaldehyde in as formaldehyde is a naturally occurring substance in wood.

#### Light Fastness /

ALPllignum Silver is not a finished product and therefore its resistance to light in part depends on the cycle and chemical nature of the finish. On demand, ALPI can supply a version of ALPllignum Silver which, if finished with an appropriate varnishing cycle, can achieve values of > 3 on the grey scale (EN438-2/27). The buyer is advised that discoloring may occur. It is recommended that the buyer perform advance tests depending upon the particular purpose and intended use in order to optimize results.

#### Mechanical Specifications /

The mechanical characteristics of ALPllignum Silver depend on the cycle and chemical nature of the finish and type of backing.

It is recommended that the buyer perform advance tests depending upon the particular purpose and intended use in order to optimize results.

#### Colour and Structure /

Being a natural wood product, the reference color of ALPllignum Silver may vary. It is recommended that before use the buyer check both the color and the grain of the delivered product against the product ordered.

#### Storage /

ALPllignum Silver is mainly made of wood and its moisture content may therefore be subject to variation depending on the storage and work environment. It is therefore advisable to maintain humidity in a range of between 40% and 70% (RH) and a reference ambient temperature of 20°C.

#### Warnings /

Avoid - even temporarily - any contact with water and other liquids. Avoid any moisture on the product surface. The product must be stored on a flat surface at least 200 mm off the ground. ALPllignum Silver must be shielded from direct and indirect light.

## ALPllignum Silver Recommendations for Use /

### ALPllignum Silver /

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#### Veneering /

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##### Glueing With Urea Glues

ALPllignum Silver veneer can be glued on all wood backing using urea glues. Different kinds of backing must be tested and assessed on a case-by-case basis. The quantity of glue to be used per square meter depends on the base type and thickness, on the veneer structure (quartered cut, tangential cut, burl, etc.), on its thickness and on the type of pressing. It is generally advisable not to use more than 150 g/m<sup>2</sup> of glue at pressures ranging from 1.5 to 5 bars. The recommended veneering temperature may range between 85°C and 120°C. The glue may be blended with organic or inorganic fillers to modify its rheological properties in order to control bleeding through the veneer layer. The use of pigments with similar shades to the veneer base color is always recommended. Basswood-based products should be veneered on panels, using urea glue with an application of at least 120/140g/m<sup>2</sup>.

##### Glueing With Vinyl Glues

ALPllignum Silver veneer can be glued on all wood backing using vinyl glues. Different kinds of backing need to be tested. Because of the thermoplastic features of this type of glue, the quantity to be applied must be carefully measured according to the type of veneering in order to avoid undesirable pass-through which would prove difficult to eliminate through sanding. It is generally advisable to use between 80 and 100g/m<sup>2</sup> of glue at pressures ranging from 1.5 to 3.5 bars. The advisable veneering temperature may vary between 60°C and 90°C. The use of pigments with similar shades to the veneer base color is always recommended. It is advisable to undertake a gluing test in advance.

#### Sanding /

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The choice of grits of the sandpapers and of the sanding methods must be carried out taking into account that the wood surface contains pearlescent components that could be damaged / removed if the sanding is too aggressive. We therefore recommend that, in case of automatic sanding machines, to test the entire process taking care to verify the optimization of the following parameters:

- Grit sandpaper (150 to 220)
- Contact pressures
- Feed speed of the pieces
- Peripheral speed of the belts

#### Varnishing /

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Like all other types of wood, the varnishing process for ALPllignum Silver must be performed with a suitable product that is capable of protecting and preserving the wood as much as possible from chemical and physical deterioration (photodegradation, thermal decay, etc.) as well as from mechanical degradation (scratches, dents, etc.). ALPllignum Silver can be varnished with any product or method recommended for wood treatments. However, the best results are achieved by selecting from the various classes of products that have the following characteristics:

- Wetting power
- Yellowing retardation power
- UV protection

ALPllignum Silver may be varnished using two-phase acrylic cycles of various glosses, or two-phase polyurethane cycles of various glosses, and ultra-violet drying acrylic cycles of various glosses. It is always sound practice strictly to follow the instructions provided by paint manufacturers and to carry out advance tests before proceeding to varnishing.

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## ALPIkord Prefinished veneer /

The ALPI veneer is prefinished with state-of-the-art products and varnishes to bring out its natural beauty. The result is a large wood panel ready for application to any surface, permitting reduction of time devoted to installation, varnishing and finishing. The practicality of prefinished wood is joined by the properties of quality, uniqueness and customization, with the environmental certifications assigned to all ALPI veneers.

### Usage sectors /

Surfaces for furnishings; surfaces and facings for interior architecture; hotels, multi-apartment and residential complexes, shops, retail outlets, offices, public spaces; surfaces and facings for the interiors of yachts and cruise ships; dashboard surfaces and interior finishing for the automotive sector.

### Finishes /

ALPIkord veneers come in a range of finishes.

The four standard finishes combine and enhance different tactile and visual sensations:

**Groove** (5 gloss), achieved by brushing the wood to bring out texture and consistency, for an incredible tactile effect associated with a sensation of great natural character, similar to that of unfinished wood.

**Wax** (5 gloss), matte varnish gives the wood a delicate look typical of wax-based treatments and natural oils.

**Light Gloss** (15 gloss), enhanced by a delicate sheen, this elegant and refined solution offers the classical tone of the crafts tradition for the hand and the eye.

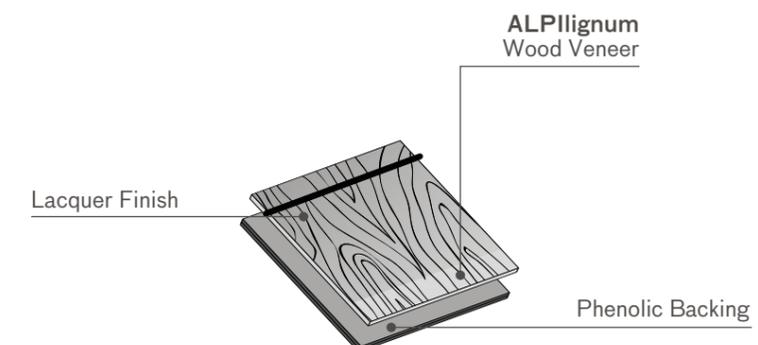
**Bright Gloss** (40 gloss), lustrous, illuminating finish.

## ALPIkord Technical Features /

### ALPIkord /

	Groove /	Light Gloss-Bright Gloss /	Wax /
<b>Nominal Thickness</b>	1.0 mm	1.0 mm	1.0 mm
<b>Grade</b>	Postformable	Postformable	Postformable
<b>Bending Radius*</b>			
Longitudinal	20 mm	20 mm	20 mm
Transversal	20 mm	20 mm	20 mm
<b>Postforming Temperature</b>	145°C (288 F)	145°C (288 F)	145°C (288 F)
<b>Weight Per Sqm</b>	1.1 kg	1.1 kg	1.1 kg
<b>Dimensional Variations</b>			
Longitudinal	0.4 %	0.4 %	0.4 %
Transversal	1.2 %	1.2 %	1.2 %
En 438-2, 17 (2005)			
<b>Abrasion Resistance*</b>	> 80 Taber turns	> 100 Taber turns	> 100 Taber turns
En 438-2, 10 (2005)			
<b>Stain Resistance</b>	No effect	Halo caused by acetone	No effect
En 438-2, 26 (2005)			
<b>Lightfastness (Xenotest)</b>	> 2 Grey scale	> 2 Grey scale	> 2 Grey scale
En 438-2, 27 (2005)			
<b>Formaldehyde Emission</b>	0.2 mg/m <sup>2</sup> h	0.2 mg/m <sup>2</sup> h	0.2 mg/m <sup>2</sup> h
En 717-2			

### ALPIkord /



# ALPIrobur

## High-resistance prefinished veneer /

A particular finish is applied to the ALPI veneer to respond to the demand for high resistance surfaces. By request, it is also available in a flameproof version, in compliance with IMO MED, CLASSE 1 and CLASSE B-s1.do standards.

### Usage sectors /

Surfaces for furnishings; surfaces and facings for interior architecture; hotels, multi-apartment and residential complexes, shops, retail outlets, offices, public spaces; surfaces and facings for the interiors of yachts and cruise ships; dashboard surfaces and interior finishing for the automotive sector.

### Finishes /

ALPIrobur veneers come in a range of finishes:

- Brushed** a three-dimensional, very materic finish with a brushed effect
- Soft** a finish with a natural effect in terms of touch and image
- Matt** an almost imperceptible matt finish
- Pore** open-pore finish

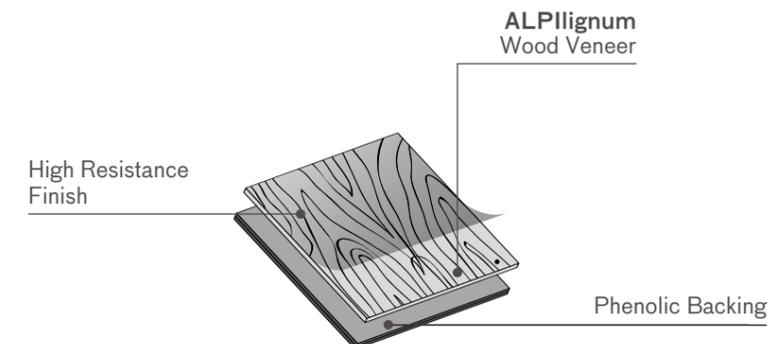
### ALPIrobur

#### Technical Features /

#### ALPIrobur /

	Soft-Matt-Pore-Brushed /	Soft-Matt-Pore-Brushed / 🔥 Fireproof IMO MED Certificate /
<b>Nominal Thickness</b>	1.0 mm	1.0 mm
<b>Weight Per Sqm</b>	1.2 kg	1.3 kg
<b>Dimensional Variations</b>		
Longitudinal	0.4 %	0.9 %
Transversal	1.1 %	1.4 %
En 438-2, 17 (2005)		
<b>Abrasion Resistance*</b>	> 350 Taber turns	> 350 Taber turns
En 438-2, 10 (2005)		
<b>Stain Resistance</b>	No effect	No effect
En 438-2, 26 (2005)		
<b>Lightfastness (Xenotest)</b>	> 2 Grey scale	> 2 Grey scale
En 438-2, 27 (2005)		

#### ALPIrobur /



## ALPIkord - ALPIrobur Recommendations for Use /

### Application Tips /

To ensure appropriate counterbalancing it is advisable to use the same type of product, although the process may also be conducted using HPL matching the characteristics of the face. In any case, specific production tests should be carried out to evaluate the suitability of the product utilized over time (48/72 hours).

### Application with Steel Plate Press /

The utmost attention is required when using a steel plate press. It is necessary a perfect cleaning of the plates to avoid dents or damage to the finished surface. Damages to a varnished or melamine surface may be caused by particles left between the metal plates and are difficult to repair. During the application of ALPIkord, the protective film must be perfectly laid out on the surface to avoid thickness-related marks. Veneering glue must be applied in a quantity such as to avoid lateral leakage under pressure and damage to the decorative surface. When using thermo-hardening glues, the press temperature should never exceed 105°/110°C for longer than 1/2 minutes. Application of ALPIkord to supports with a high thermic expansion coefficient (metallic and other surfaces) may result in alterations to its flatness and possible delamination due to rapid changes in temperature and humidity.

### Application with Contact Adhesive /

Contact adhesives may be applied by hand or machine, taking care to wait the complete evaporation of solvent. ALPIkord/ALPIrobur sheets must be applied with a firm contact pressure using roller presses or hand rollers.

### Postforming (ALPIkord only) /

In the static postforming process, an excessive speed of hot bar in conjunction with a not proper temperature can cause micro and macro fractures on the curved part. The long contact of hot forming bar on the wooden surface may cause a blistering effect on the film of varnish. In the dynamic postforming process, if the panel moves too quick fractures may be caused in the curved part of the pattern. The mould that is being wrapped must be of regular and constant shape along its entire length. Glue applied to the surface must be of appropriate grammage in order to avoid detachment and surface defects. The pressure rollers and bars creating the curve envelope must be kept very clean, accurately regulated along the outline of the curved edge, and be fully wrapped in rubber (between 50 and 80 Shore hardness). Sheets of ALPIkord must be conditioned at temperatures of at least 15°/20°C for a period of 24/48 hours in order to avoid the excessive fragility of patterns when curved. Changes of decorative wooden pattern may need to update the postforming parameters.

### Warnings /

As with natural wood, for ALPIkord/ALPIrobur surfaces it is not possible to guarantee absolute colour consistency between different manufacturing lots. Any slight difference in colour between two or more production batches cannot be considered a defect. Just like natural wood, ALPIkord/ALPIrobur react to direct and indirect, solar and artificial light. A gradual change of colour appearance over time, is accelerated by heat and moisture, since it is a natural phenomenon rather than a defect.

With its melamine finish, ALPIrobur guarantees high levels of resistance to abrasion, and it is particularly suitable for horizontal surfaces. The colors of an ALPIrobur code cannot be perfectly matching the corresponding ALPIkord code, since this last one is coated with a transparent varnish. In consequence, it is advisable not to place panels with different finishes side by side.

### Cleaning /

ALPIkord/ALPIrobur surfaces are easy to clean with a damp natural fibre cloth dipped in distilled water. If necessary add non-abrasive detergent. For more heavy stains, use alcohol, ammonia or other light solvents. Never use acetone or varnish solvent on the ALPIkord Light Gloss and Bright Gloss finish.

### Storage /

ALPIkord/ALPIrobur must be stored horizontally, face-to-face, in an environment where the temperature is between 10°C and 30°C and the relative humidity between 40% and 60%; all sheets on a pallet but never be laid directly on the floor. Like all wooden surfaces, to ensure good conservation over time, it should be protected from light with non-transparent and if possible dark coverings. Sheets should always be handled by two people.

Please contact ALPI's technical office for any further clarification. This technical data sheet supersedes and replaces any previous version. The information and recommendations herein have been compiled from the current information held by ALPI and may be our best knowledge updated to perform the higher results of the applications.

## ALPIdecos Edgeband /

To complete the range of all the decorative of ALPI's surfaces, the ALPIdecos edgeband are the ideal solution for consumers requiring a full range of high-quality products to obtain a maximum focus on their production details.

**ALPIdecos-ABS** it is a wooden edgeband, backed by an ABS support, coordinated in the same color as the wood surface. It is supplied matching ALPIkord products in terms of colors and finishes.

**ALPIdecos-FBK** it is a wooden edgeband backed by non-woven fabric, suitable for soft-forming and finishing of curved surfaces. It may be coordinated with the products of the ALPIlignum range.

Available in different options as raw and pre-varnished finishes.

**ALPIdecos-STR** it is an edgeband made with multiple wooden layers.

It fits perfectly for those who require a product of greater thickness matching with the products of the ALPIlignum range.

Available in different options as raw and pre-varnished finishes.

[www.alpi.it](http://www.alpi.it)

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# ALPI Collection /

Collection Wood / Collection Designer /	Code	Product	Texture	ALPIIignum	ALPIkord/ALPIrobur	ALPIkord				ALPIrobur*			
						Wax	Groove	Light Gloss	Bright Gloss	Soft	Matt	Pore	Brushed
Nordic	10.02	ALPI Erable	Burl	2500x640	2500x1250	✓	NA	✓	✓	✓	✓	✓	NA
Nordic	10.03	ALPI Erable Frisé	Burl	2500x640	2500x1250	✓	NA	✓	✓	✓	✓	✓	NA
Nordic	10.08	ALPI Myrtle Burl	Burl	2500x640	2500x1250	✓	NA	✓	✓	✓	✓	✓	NA
Nordic	10.09	ALPI Pure White Erable	Burl	2500x640	2500x1250	✓	NA	✓	✓	✓	✓	✓	NA
Nordic	10.61	ALPI Oak	Quartered	2500x640 / 3150x640	2500x1250 / 3050x1300	✓	✓	✓	✓	✓	✓	✓	✓
Nordic	10.63	ALPI Balanced Oak	Quartered	3150x640	2500x1250 / 3050x1300	✓	✓	✓	✓	✓	✓	✓	✓
Nordic	10.64	ALPI Décapé Oak	Quartered	2500x640 / 3150x640	2500x1250 / 3050x1300	✓	✓	✓	✓	✓	✓	✓	✓
Nordic	10.82	ALPI Icecool Oak	Quartered	2500x640 / 3150x640	2500x1250 / 3050x1300	✓	✓	✓	✓	✓	✓	✓	✓
Nordic	10.96	ALPI Planked Oak	Planked	3150x640	2500x1250 / 3050x1300	✓	✓	✓	✓	✓	✓	✓	✓
Evergreen	10.05	ALPI Elm Burl	Burl	2500x640	2500x1250	✓	NA	✓	✓	✓	✓	✓	NA
Evergreen	10.07	ALPI Walnut Burl	Burl	2500x640	2500x1250	✓	NA	✓	✓	✓	✓	✓	NA
Evergreen	10.24	ALPI Santos Rosewood	Crown	3150x640	2500x1250 / 3050x1300	✓	✓	✓	✓	✓	✓	✓	✓
Evergreen	10.74	ALPI Teak	Quartered	3150x640	2500x1250 / 3050x1300	✓	✓	✓	✓	✓	✓	✓	✓
Evergreen	10.84	ALPI Slavony Oak	Planked	3150x640	2500x1250 / 3050x1300	✓	✓	✓	✓	✓	✓	✓	✓
Evergreen	10.86	ALPI Straight Oak	Quartered	2500x640 / 3150x640	2500x1250 / 3050x1300	✓	✓	✓	✓	✓	✓	✓	✓
Evergreen	10.88	ALPI Zingana	Quartered	3150x640	2500x1250 / 3050x1300	✓	✓	✓	✓	✓	✓	✓	✓
Evergreen	15.01	ALPI Marquise	Design	2500x640	NA	NA	NA	NA	NA	NA	NA	NA	NA
Evergreen	15.02	ALPI Carrè	Design	2500x640	NA	NA	NA	NA	NA	NA	NA	NA	NA
Evergreen	15.03	ALPI Asscher	Design	2500x640	NA	NA	NA	NA	NA	NA	NA	NA	NA
Evergreen	15.04	ALPI Ceylon	Design	2500x640	NA	NA	NA	NA	NA	NA	NA	NA	NA
Chocolate	10.06	ALPI California Burl	Burl	2500x640	2500x1250	✓	NA	✓	✓	✓	✓	✓	NA
Chocolate	10.16	ALPI American Walnut	Quartered	3150x640	2500x1250 / 3050x1300	✓	✓	✓	✓	✓	✓	✓	✓
Chocolate	10.18	ALPI Balanced American Walnut	Quartered	3150x640	2500x1250 / 3050x1300	✓	✓	✓	✓	✓	✓	✓	✓
Chocolate	10.19	ALPI Wavy American Walnut	Planked	3150x640	2500x1250 / 3050x1300	✓	✓	✓	✓	✓	✓	✓	✓
Chocolate	10.23	ALPI Indian Rosewood	Quartered	2500x640 / 3150x640	2500x1250 / 3050x1300	✓	✓	✓	✓	✓	✓	✓	✓
Chocolate	10.31	ALPI Balanced Wenge	Quartered	3150x680/740	2500x1250 / 3050x1300	✓	✓	✓	✓	✓	✓	✓	✓
Chocolate	10.32	ALPI Dark Wenge	Quartered	3150x680/740	2500x1250 / 3050x1300	✓	✓	✓	✓	✓	NA	✓	✓
Chocolate	10.41	ALPI Makassar Ebony	Quartered	2500x640 / 3150x640	2500x1250 / 3050x1300	✓	✓	✓	✓	✓	NA	✓	NA
Chocolate	10.42	ALPI Ammara Ebony	Quartered	2500x640 / 3150x640	2500x1250 / 3050x1300	✓	✓	✓	✓	✓	NA	✓	NA
Chocolate	10.67	ALPI Dark Oak	Quartered	3150x640	2500x1250 / 3050x1300	✓	✓	✓	✓	✓	NA	✓	✓
Chocolate	10.68	ALPI Thermo Oak	Planked	3150x640	2500x1250 / 3050x1300	✓	✓	✓	✓	✓	✓	✓	✓
Chocolate	10.85	ALPI Smoked Oak	Planked	3150x640	2500x1250 / 3050x1300	✓	✓	✓	✓	✓	NA	✓	NA
Chocolate	13.01	ALPI Crown Tundra	Crown	2500x640	2500x1250	✓	NA	✓	✓	✓	✓	✓	✓
Chocolate	10.95	ALPI Planked Walnut	Planked	3150x640	2500x1250 / 3050x1300	✓	✓	✓	✓	✓	✓	✓	✓
Chocolate	10.94	ALPI Moka Oak	Planked	3150x640	2500x1250 / 3050x1300	✓	✓	✓	✓	✓	✓	✓	✓
Chocolate	10.35	ALPI Wenge	Quartered	3150x640	2500x1250 / 3050x1300	✓	✓	✓	✓	✓	NA	✓	NA
Chocolate	10.97	ALPI Deep Oak	Quartered	3150x640	2500x1250 / 3050x1300	✓	✓	✓	✓	NA	NA	NA	NA
Sand	10.69	ALPI Breeze Oak	Planked	3150x640	2500x1250 / 3050x1300	✓	✓	✓	✓	✓	✓	✓	✓
Sand	10.81	ALPI Ivory Oak	Planked	2500x640	2500x1250	✓	NA	✓	✓	✓	✓	✓	✓
Sand	10.83	ALPI Sand Oak	Quartered	2500x640 / 3150x640	2500x1250 / 3050x1300	✓	✓	✓	✓	✓	✓	✓	✓
Sand	10.87	ALPI Sand Oak	Quartered	3150x640	2500x1250 / 3050x1300	✓	✓	✓	✓	✓	✓	✓	✓
Sand	11.05	ALPI Titanium Oak	Quartered	3150x640	2500x1250 / 3050x1300	✓	✓	✓	✓	✓	✓	✓	✓
Sand	11.06	ALPI Sand Oak	Quartered	3150x640	2500x1250 / 3050x1300	✓	✓	✓	✓	✓	✓	✓	✓
Sand	11.07	ALPI Sand Erable	Burl	2500x640	2500x1250	✓	NA	✓	✓	✓	✓	✓	NA
Sand	13.09	ALPI Living Rock	Quartered	2500x640	2500x1250	✓	NA	✓	✓	✓	✓	✓	✓
Sand	11.12	ALPI Light Grey Lati	Quartered	3150x640	2500x1250 / 3050x1300	✓	✓	✓	✓	✓	✓	✓	✓

# ALPI Collection /

Collection Wood / Collection Designer /	Code	Product	Texture	ALPIlignum	ALPIkord/ALPIrobur	ALPIkord				ALPIrobur*			
						Wax	Groove	Light Gloss	Bright Gloss	Soft	Matt	Pore	Brushed
Grey	10.43	ALPI Gabon Ebony	Quartered	3150x640	2500x1250 / 3050x1300	✓	✓	✓	✓	NA	NA	NA	NA
Grey	10.65	ALPI Smoke Grey Oak	Quartered	3150x640	2500x1250 / 3050x1300	✓	✓	✓	✓	✓	✓	✓	✓
Grey	10.66	ALPI Balanced Grey Oak	Quartered	3150x640	2500x1250 / 3050x1300	✓	✓	✓	✓	✓	✓	✓	✓
Grey	11.02	ALPI Platinum Oak	Quartered	3150x640	2500x1250 / 3050x1300	✓	✓	✓	✓	✓	✓	✓	✓
Grey	11.04	ALPI Dark Grey Oak	Quartered	3150x640	2500x1250 / 3050x1300	✓	✓	✓	✓	✓	✓	✓	✓
Grey	11.08	ALPI Grey Vavona	Burl	2500x640	2500x1250	✓	NA	✓	✓	✓	✓	✓	NA
Grey	13.02	ALPI Savannah	Crown	2500x640	2500x1250	✓	NA	✓	✓	✓	✓	✓	✓
Grey	13.06	ALPI Fossil Forest	Burl	2500x640	2500x1250	✓	NA	✓	✓	✓	✓	✓	NA
Grey	13.07	ALPI Ebony and Ivory	Crown	3150x640	2500x1250 / 3050x1300	✓	✓	✓	✓	✓	NA	✓	✓
Grey	11.11	ALPI Dark Grey Lati	Quartered	3150x640	2500x1250 / 3050x1300	✓	✓	✓	✓	✓	✓	✓	✓
Textiled	14.01	ALPI Day and Night Twill	Design	2500x640	2500x620	✓	NA	✓	✓	✓	✓	✓	NA
Textiled	14.02	ALPI Smoky Velvet	Design	2500x640	2500x620	✓	NA	✓	✓	✓	✓	✓	NA
Textiled	14.03	ALPI Frame	Design	2500x640	2500x620	✓	NA	✓	✓	✓	✓	✓	NA
Textiled	14.04	ALPI Concrete Pinstripe	Design	2500x640	2500x620	✓	NA	✓	✓	✓	✓	✓	NA
Wood+	16.01	ALPI Radiant Black	Quartered	2500x320	NA	NA	NA	NA	NA	NA	NA	NA	NA
Wood+	16.02	ALPI Radiant Natural	Quartered	2500x320	NA	NA	NA	NA	NA	NA	NA	NA	NA
Wood+	16.03	ALPI Radiant Sand	Quartered	2500x320	NA	NA	NA	NA	NA	NA	NA	NA	NA
Wood+	16.11	ALPI Silver Rail Black	Quartered	2500x320	2500x300	✓	NA	✓	✓	NA	NA	NA	NA
Wood+	16.12	ALPI Silver Rail Brown	Quartered	2500x320	2500x300	✓	NA	✓	✓	NA	NA	NA	NA
Wood+	16.13	ALPI Silver Rail wavy - Black	Quartered	2500x320	2500x300	✓	NA	✓	✓	NA	NA	NA	NA
Silver	17.01	ALPI Silver Black	Quartered	2500x640	2500x1250	NA	NA	✓	✓	NA	NA	NA	NA
Silver	17.02	ALPI Silver Natural	Quartered	2500x640	2500x1250	NA	NA	✓	✓	NA	NA	NA	NA
Silver	17.03	ALPI Silver Sand	Quartered	2500x640	2500x1250	NA	NA	✓	✓	NA	NA	NA	NA
Silver	17.04	ALPI Silver Brown	Quartered	2500x640	2500x1250	NA	NA	✓	✓	NA	NA	NA	NA
Silver	17.05	ALPI Silver Dark Brown	Quartered	2500x640	2500x1250	NA	NA	✓	✓	NA	NA	NA	NA
Designer Campana Brothers	18.31	ALPI Pirarucu	Design	3150x620	2500x600/3050x600	✓	✓	✓	✓	✓	✓	✓	✓
Designer Campana Brothers	18.32	ALPI Piacava	Design	3150x640	2500x1250/3050x1300	✓	✓	✓	✓	✓	✓	✓	✓
Designer Front	18.41	ALPI Drapery Wood	Design	2500x600	NA	NA	NA	NA	NA	NA	NA	NA	NA
Designer Front	18.42	ALPI Grid wood	Design	1500x600	NA	NA	NA	NA	NA	NA	NA	NA	NA
Designer Piero Lissoni	18.01	ALPI Xilo 2.0 striped White	Quartered	3150x640	2500x1250/3050x1250	✓	✓	✓	✓	✓	✓	✓	✓
Designer Piero Lissoni	18.02	ALPI Xilo 2.0 striped Sand	Quartered	3150x640	2500x1250/3050x1250	✓	✓	✓	✓	✓	✓	✓	✓
Designer Piero Lissoni	18.03	ALPI Xilo 2.0 striped Grey	Quartered	3150x640	2500x1250/3050x1250	✓	✓	✓	✓	NA	NA	NA	NA
Designer Piero Lissoni	18.04	ALPI Xilo 2.0 striped Black	Quartered	3150x640	2500x1250/3050x1250	✓	✓	✓	✓	NA	NA	NA	NA
Designer Piero Lissoni	18.09	ALPI Xilo 2.0 flamed WHITE	Crown	3150x640	2500x1250/3050x1250	✓	✓	✓	✓	✓	✓	✓	✓
Designer Piero Lissoni	18.10	ALPI Xilo 2.0 flamed SAND	Crown	3150x640	2500x1250/3050x1250	✓	✓	✓	✓	✓	✓	✓	✓
Designer Piero Lissoni	18.11	ALPI Xilo 2.0 flamed GREY	Crown	3150x640	2500x1250/3050x1250	✓	✓	✓	✓	NA	NA	NA	NA
Designer Piero Lissoni	18.12	ALPI Xilo 2.0 flamed BLACK	Crown	3150x640	2500x1250/3050x1250	✓	✓	✓	✓	NA	NA	NA	NA
Designer Piero Lissoni	18.13	Tarsie 2 White	Design	2500x600	NA	NA	NA	NA	NA	NA	NA	NA	NA
Designer Piero Lissoni	18.14	Tarsie 2 Black	Design	2500x600	NA	NA	NA	NA	NA	NA	NA	NA	NA
Designer Piero Lissoni	18.15	Tarsie 3 Sand	Design	2500x600	NA	NA	NA	NA	NA	NA	NA	NA	NA
Designer Piero Lissoni	18.16	Tarsie 3 Black	Design	2500x600	NA	NA	NA	NA	NA	NA	NA	NA	NA
Designer Piero Lissoni	18.17	Tarsie 1 Sand	Design	2500x600	NA	NA	NA	NA	NA	NA	NA	NA	NA
Designer Piero Lissoni	18.18	Tarsie 1 Grey	Design	2500x600	NA	NA	NA	NA	NA	NA	NA	NA	NA

\* IMO MED Certificate on demand