

	AGT PROFILE TECHNICAL SPECIFICATIONS	Release Date	6.02.2014
		Revision No	5
		Revision Date	20.12.2021
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PROPERTIES OF PROFILE

SPECIFICATION	UNIT	TEST STANDARD	REQUIRED VALUE	TEST RESULTS
ADHESIVE RESISTANCE	N/mm ²	ASTM D6862-04	≥ 0,55	≥ 0,55
TEMPERATURE RESISTANCE	°C	---	≤ 80	≤ 80
SURFACE STRENGTH	N/mm ²	EN 311	≥ 1 N/mm ²	≥ 1 N/mm ²
FORMALDEHYDE RELEASE (COATED SHEET)	mg/ m ³	TS EN 717-1	E0 sınıf	0,018 mg/ m ³ - E0 Class
EVALUATION OF SURFACE RESISTANCE TO MICRO-SCRATCHES	% change	TS CEN / TS 16611 (Method A)	≤ 10	≤ 10
RESISTANCE TO COLD LIQUIDS (RESISTANCE TO CHEMICALS)	Class	EN 12720+A1	5	5
SURFACE RESISTANCE TO DRY HEAT (70OC)	Class	EN 12722	5	5

PROPERTIES OF MDF

SPECIFICATION	UNIT	TEST STANDARD	REQUIRED VALUE	TEST RESULTS
INTENSITY	kg/m ³	EN 323	12 mm S: 740 ± 20 Kg/m ³ , 16 mm S: 690 ± 20 Kg/m ³ , 18 mm Pro: 670 ± 20 Kg/m ³ , 18 mm Prf: 740 ± 20 Kg/m ³ , 22-25 mm S: 710 ± 20 Kg/m ³ , 30 mm S: 725 ± 20 Kg/m ³	12 mm S: 740, 16 mm S: 690, 18 mm Pro: 660 Kg/m ³ , 18 mm Prf: 740 Kg/m ³ , 22-25 mm S: 715 Kg/m ³ , 30 mm S: 720 Kg/m ³
THICKNESS TOLERANCE	mm	EN 324-1 EN 622-1	12-16-18 mm: ± 0,20 mm 22-25-30 mm: ± 0,30 mm	12-16-18 mm: ± 0,20 mm 22-25-30 mm: ± 0,30 mm
LENGTH AND WIDTH TOLERANCE	mm/m	EN 324-1 EN 622-1	± 2 mm/m, maksimum ± 5 mm	± 2 mm/m, maksimum ± 5 mm
SQUARENESS TOLERANCE	mm/m	EN 324-2 EN 622-1	2 mm/m	2 mm/m

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PROPERTIES OF MDF

SPECIFICATION	UNIT	TEST STANDARD	REQUIRED VALUE	TEST RESULTS
TOLERANCE OF SIDE SMOOTHNESS	mm/m	EN 324-2 EN 622-1	1.5 mm/m	1.5 mm/m
INFLATION IN THICKNESS 24 HOURS	%	EN 317 EN 622-5	12 mm ≤ %15 16-18 mm ≤ %14 22-25-30 mm ≤ %10	12 mm : 9% 16-18 mm : 8% 22-25-30 mm : 8 %
BENDING RESISTANCE	N/mm ²	EN 310 EN 622-5	12 mm ≥ 22 N/mm ² 16-18 mm ≥ 18 N/mm ² 22-25-30 mm ≥ 18 N/mm ²	12 mm: 36 N/mm ² 16-18 mm: 30 N/mm ² 22-25-30 mm: 32 N/mm ²
FLEXURAL ELASTICITY MODULE	N/mm ²	EN 310 EN 622-5	12 mm ≥ 2500 N/mm ² 16-18 mm ≥ 1600 N/mm ² 22-25-30 mm ≥ 2100 N/mm ²	12 mm: 3200 N/mm ² 16-18 mm: 2800 N/mm ² 22-25-30 mm: 3000 N/mm ²
INNER ADHESION	N/mm ²	EN 319 EN 622-5	12 mm ≥ 0,60 N/mm ² 16-18 ≥ 0,45 N/mm ² 22-25-30 mm ≥ 0,55 N/mm ²	12 mm: 0,98 N/mm ² 16-18: 0,54 N/mm ² 22-25-30 mm: 0,70 N/mm ²
FORMALDEHYDE CONTENT	mg/100g	EN 120 EN 622-1	≤ 8 mg/100g	E1 Class
HUMID CONTENT	%	EN 322 EN 622-1	4% - 11%	4% - 11%

PROPERTIES OF FOLIO

SPECIFICATION	UNIT	TEST STANDARD	REQUIRED VALUE	TEST RESULT
THICKNESS (FINISH FOIL)	mm	EN ISO 11833-2	0,20 ± 10%	0,20 ± 10%
THICKNESS (SOFT TOUCH)	mm	EN ISO 11833-2	0,20 ± 10%	0,20 mm (S.T Siena Ahşap:0,30 mm)
THICKNESS (SUPRAMAT)	mm	EN ISO 11833-2	0,25 ± 10%	0,25 mm
THICKNESS (HG)	mm	EN ISO 11833-2	0,30 ± 10%	0,30 ± 10%
GLOSS (HG)	20°	EN ISO 2813	≥ 80	82
SURFACE ROUGHNESS (HG)	R _a , µm	EN ISO 4288	≤ 0,10 µm	0,2 µm

PROPERTIES OF FOLIO

SPECIFICATION	UNIT	TEST STANDARD	REQUIRED VALUE	TEST RESULT
SURFACE TENSION	mN/m	ISO 8296	≥ 38 mN/m	38 mN/m - 40 mN/m
COLOR MEASUREMENT (ΔE)	---	DIN 5033-4	≤ 0.80	≤ 0.80
SCRATCH RESISTANCE (SUPRAMAT)	H	ISO 15184	≥H	6 H
SCRATCH RESISTANCE (SOFT TOUCH)	H	ISO 15184	≥H	3H
SCRATCH RESISTANCE (HG)	H	ISO 15184	≥H	2H
SCRATCH RESISTANCE (SUPRAMAT)	N	ISO 4586-2	≥0.5 N	1,5 N
SCRATCH RESISTANCE (SOFT TOUCH)	N	ISO 4586-2	≥0.5 N	1 N
SCRATCH RESISTANCE (HG)	N	ISO 4586-2	≥0.5 N	0,5-1 N
UV RESISTANCE (ΔE)	50 hours	TS EN 4892 (1-2-3)	≤ 0.80	≤ 0.80

PROPERTIES OF POLYURETHANE GLUE

- ✓ Polyurethane based reactive hot melt adhesive system
- ✓ White heat resistance (>150°C) and elastically 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

STAIN RESISTANCE TESTS

SUBSTANCE	TIME	FRONT SURFACE	BACK SURFACE
COFFEE	16h	5	5
MILK	16h	5	5
WATER	16h	5	5

STAIN RESISTANCE TESTS

SUBSTANCE	TIME	FRONT SURFACE	BACK SURFACE
ACETONE	10s	2	4
OLIVE OIL	16h	5	5
CLEANING DETERGENT	1h	5	5

<i>Numerical Rating</i>	<i>Description</i>
5	<p><u>No change</u> Test area indistinguishable from adjacent surrounding area</p>
4	<p><u>Minor change</u> Test area distinguishable from adjacent surrounding area, only when the light source is mirrored on the test surface and is reflected towards the observer's eye, e.g. discoloration, change in gloss and colour no change in the surface structure, e.g. swelling, fibre raising, cracking, blistering</p>
3	<p><u>Moderate change</u> Test area distinguishable from adjacent surrounding area, visible in several viewing directions, e.g. discoloration, change in gloss and colour</p>
2	<p><u>Significant change</u> Test area distinguishable from adjacent surrounding area, visible in all viewing directions, e.g. discoloration, change in gloss and colour, and /or structure of the surface slightly changed, e.g. swelling, fibre raising, cracking, blistering</p>
1	<p><u>Strong change</u> The structure of the surface being distinctly changed and / or discoloration, change in gloss and colour, and / or the surface material being totally or partially removed, and / or the filter paper adhering to the surface.</p>