

1.5 Parameters of the Dispatched Boards

1.5.1 Dimensional tolerances

Note: The given tolerances are defined according to ČSN EN 634-1.

Parameter	Board thickness	Requirement
Thickness of a unsanded board	8,10 mm	±0,7 mm
	12,14 mm	±1,0 mm
	16,18 mm	±1,2 mm
	20 – 40 mm	±1,5 mm
Thickness of a sanded board	8 - 38 mm	±0,3 mm
Basic format length and width	8 – 40 mm	±5,0 mm
Sizing precision for length and width	8 – 40 mm	±3,0 mm
Edge straightness tolerance	8 – 40 mm	1,5 mm/m
Rectangularity tolerance	8 – 40 mm	2,0 mm/m

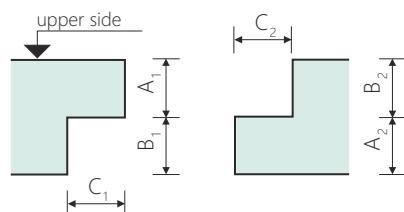
Parameter	1st Class Quality	Lower quality class
Deviation from the right angle	Max. 2 mm / 1 m of length	Max. 4 mm / 1 m of length
Permissible edge damage	Max. to a depth of 3 mm	Max. to a depth of 30 mm
Plane projections	Max. 1 mm, size 10 mm	Max. 2 mm
Depressions	Max. 1 mm, size 10 mm	Max. 2 mm
Others		Corrugated surface up to 30 mm, longitudinal wave >30 mm and transverse wave >20 mm, thin edges, pressed cement, peel in the surface, edges peeled, surfaces damaged by the pallets, edges damaged by the disc and cut-out saws.

1.5.2 Services

Deviations in milling, chamfering, creation of tongues and grooves are determined in such a manner that functional correctness is maintained during assembly.

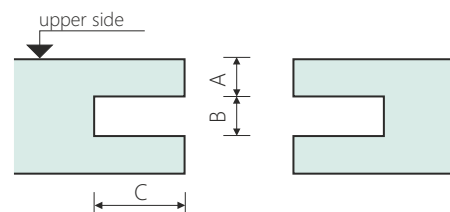
Semi-groove th. 12 - 28 mm

Dimensions	Deviation	Dimensions	Deviation
A1	-1/0	A2	-1/0
B1	0/+1,5	B2	0/+1,5
C1	0/+2	C2	-2/0



Groove th. 16 - 28 mm

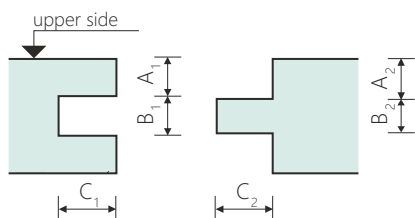
Dimensions	Deviation
A	-/+1,0
B	0/+1,5
C	0/+2



Tongue and groove th. 16 - 28 mm 16 - 32 mm sanded boards

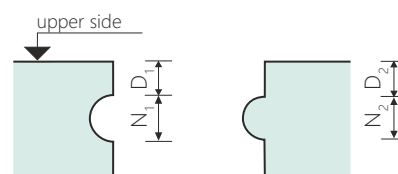
d (mm)	16	18	20	22	24	26	28
A ₁ (mm)	5,0	6,0	7,0	8,0	8,0	9,0	10,0
A ₂ (mm)	5,25	6,25	7,25	8,25	8,5	9,5	10,5
B ₁ (mm)	6,0				8,0		
B ₂ (mm)	5,5				7,0		
C ₁ (mm)	10,0						
C ₂ (mm)	8,5						

Dimensions	Deviation	Dimensions	Deviation
A ₁	±0,5 mm	A ₂	±0,5 mm
B ₁	0/+0,5	B ₂	-0,5/0
C ₁	0/+2	C ₂	-2/0



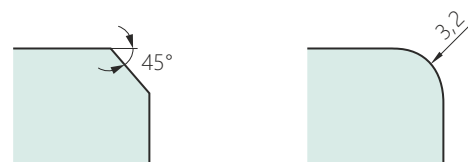
Half-round tongue and groove th. 16 - 28 mm

Dimensions	Deviation	Dimensions	Deviation
D1	±0,5 mm	D2	±0,5 mm
N1	0/+0,5	N2	-0,5/0



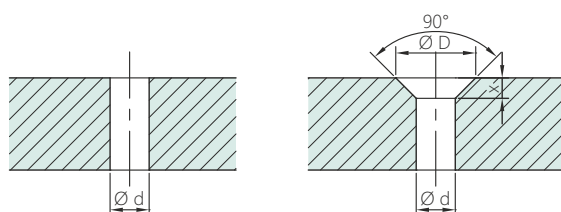
Chamfered and rounded edges

Deviation
Machining accuracy ± 1.0 mm



Drilling

Type of drilling	Hole diameter		Depth x (mm)	Board thickness (mm)
	inner d (mm)	outer D (mm)		
Without recessing	(4,5 - 8,0) ± 0,5	---	---	8 - 40
Without recessing	(10,0 - 12,0) ± 1,0	---	---	8 - 40
With recessing	4,5 ± 0,5	9,5 ± 1,0	2,5 ± 0,5	12 - 40
With recessing	5,5 ± 0,5	1,0 ± 1,0	2,5 ± 0,5	12 - 40
With recessing	6,5 ± 0,5	17,0 ± 1,5	5,0 ± 1,0	12 - 40



Deviation of the distance of the individual holes in the board is not more than ± 5 mm.



Surface Treatment

Guarantee on colour stability (according to the manufacturer of the coats) is at least 3 years. Colour shades of CETRIS® FINISH, PROFIL FINISH and AKUSTIC FINISH boards can be chosen according to the RAL or NCS colour sampler. Colour shades of the CETRIS® LASUR and CETRIS® PROFIL LASUR boards can be chosen according to the CETRIS® LASUR colour sampler. We recommend that you consult the suitability of the chosen colour shade with us. The backside of the CETRIS® FINISH, PROFIL FINISH, LASUR, PROFIL LASUR, AKUSTIC FINISH and DEKOR is provided with a protective primer with irregular structure, raw appearance and insufficient coverage.

The backside coat is provided in an unspecified colour shade, the requirement for white or transparent shade must be specified in the order in advance. The backside surface of the boards may be slightly disrupted by handling related to the manufacturing of the CETRIS® boards. If a sample with the required colour shade is made upon customer request, this sample shall only serve as orientation information about the chosen colour shade and coverage level (difference in the manual application of the coat on the sample and machine application during series production).