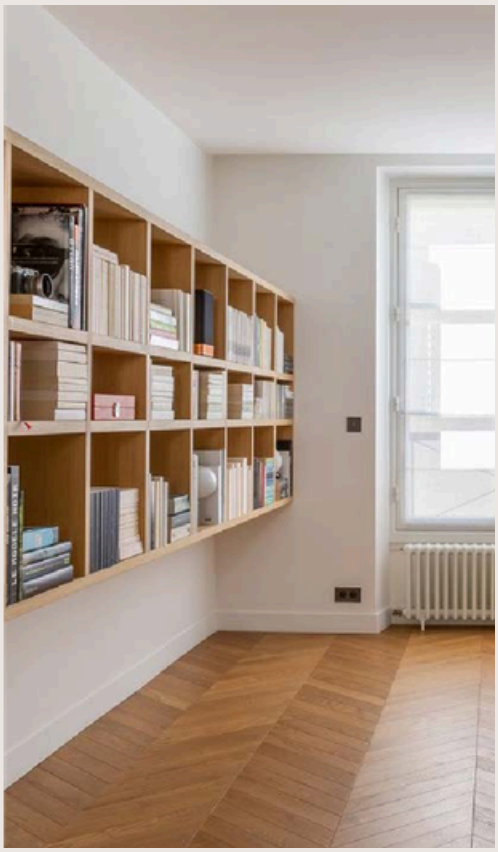




VARNISHED NATURAL WOOD VENEER ON A WOOD BASE LAYER

BOIS FINIS

hubler
la matière pour la création

COMPOSITION

VENEER	These are sheets whose surface consists of natural wood veneers that have been sliced and joined in a solid-layer configuration (with glued joints).
PRIMER	These veneers are then applied to a natural wood substrate using a proprietary process. The resins and technique used prevent any moisture or solvents from seeping through during subsequent veneering operations (gluing the back of the panels and applying the veneer to a substrate by the user).
DEVELOPMENTRATION	Hubler's Bilegno® veneers are delivered with a matte varnish finish (8 to 10 gloss) made from a two-component polyurethane system. The wood backing ensures a uniform edge finish after trimming. The natural veneers, rigorously selected for the manufacture of these sheets, are generally assembled by mixing bundles of veneers (2 to 3 on average) from the same log, sliced on the flat (figured veneer) or on the quarter (quarter-sawn veneer). This method is commonly referred to as "single-layer assembly." Upon request: Other types of assembly (slid, open book, or mixed lay) can be accommodated. The sheets are delivered with a protective film.

STANDARD DIMENSIONS

SIZES: 250 x 125 cm and 305 x 125 cm (see price list for availability of the Hubler offer)
Note: The first dimension indicates the grain direction.
We can also produce a sheet with the grain running "across."
Upon request: We can accommodate other formats, including the "porte" format.

THICKNESS: approximately 11/10 mm (varies depending on the wood species). Note: approximate dimensions (wood veneers).

ESTIMATED WEIGHT: 1.2 kg/m²



EQUIPMENT

SINCE WOOD IS A NATURAL PRODUCT, DIFFERENCES IN STRUCTURE AND COLOR MAY BE NOTICED BETWEEN SAMPLES AND SHEETS
FROM THE SAME DELIVERY.

These variations in structure and/or color cannot be considered a nonconformity.
HUBLER recommends inspecting and matching all sheets before installation.
Each sheet is identified with its product reference and a manufacturing lot number on a label affixed to the end of the sheet on the back side.

This batch does not guarantee a homogeneous set.

It is important to inspect the goods and identify any batches before installation.
However, it is possible to request a homogeneous delivery of up to 10 or 20 sheets, depending on the wood species, for an additional charge.

This internal, subjective sorting process does not preclude inspection by the customer upon delivery. Beyond that, please consult us if you wish to receive veneer from the same batch for your projects. No claims will be accepted once cutting and/or pressing have been completed.

COMPOSITION

BENDING	Can be bent to a concave or convex shape when cold, with a radius of curvature that varies depending on the wood species and the direction of bending (on average, approximately 5 cm in the longitudinal direction and 12 cm in the transverse direction; to be verified on a case-by-case basis).
POST-FORMING	Our sheets are not of post-formable quality.
DIMENSIONAL VARIATIONS	Given their composition and manufacturing techniques, these sheets are relatively sensitive to temperature and humidity conditions. As a result, they may exhibit some warping. Dimensional variations Longitudinal: 0.4% Transverse: 1.2%
FORMALDEHYDE EMISSIONS	Sheet classified under the VOC A+ label.
ENVIRONMENTAL CERTIFICATION	Bilegno® products can be FSC®-certified upon request (FSC® license -C201649).
FIRE RESISTANCE	Products less than 2 mm thick are not subject to the Euroclass standards (see EN 438-7). Our Bilegno® sheets do not have a fire-retardant treatment on the wood substrate.
LIGHT RESISTANCE	Given their nature, the regular or irregular aging of veneers is strongly influenced by the stains and finishes applied by the user, regardless of whether the finished panels need to be protected from sunlight and moonlight.

STOCKAGE

Before installation, and to prevent moisture absorption and warping, the sheets must be stored and packaged for several days in a closed, dry room along with the backing materials and leveling materials. The conditions to be observed are:

TEMPERATURE: 18 to 25°C.
RELATIVE HUMIDITY: 40 to 60%.

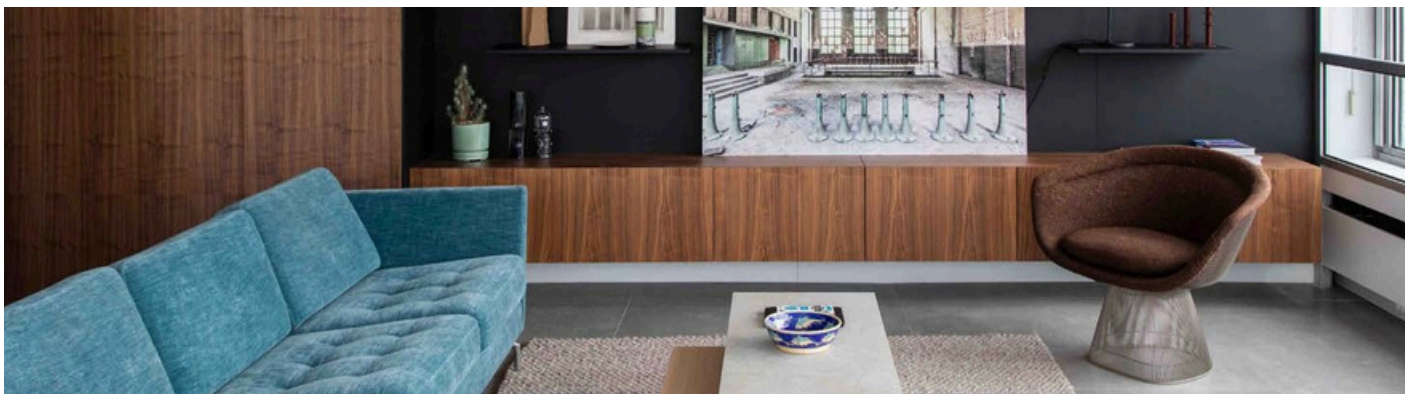
They should be laid flat (without touching the floor), in stacks or in racks.
The decorative sides should face each other, and the top sheet should be placed face down and covered to keep the stack flat.

They must also be protected from sunlight and moonlight.

IMPLEMENTATION

In general, these sheets are processed and installed in the same way, using the same tools and adhesives and on the same substrates as traditional decorative laminates, with the following exceptions:

SUPPORT	Use substrates that are flat (well-calibrated), clean, and porous. However, thanks to the low density of its underlayer, the Hubler® BILEGNO sheet can compensate for some surface irregularities in the substrates used.
PROTECTION	All of these sheets are protected on the surface by a clear plastic film. This film should not be removed by the user until the veneering and panel fabrication are complete. Writing on the veneer with a marker or pen could damage it. During the fabrication process in the workshop, it is recommended to always protect the veneer surfaces exposed to moonlight and sunlight to prevent discoloration. Do not leave any accessories on the veneers to prevent marks on the wood.
BALANCING	To counterbalance the panels, do not use standard decorative laminates, as their coefficients of expansion are different. Use the counterbalancing materials recommended by Hubler (see Hubler price list).



COLLAGE

Vinyl adhesive or PVAC D3-type white glue using a heat press: a pressure of 3 kg/cm², a maximum temperature of 60 to 70°C, and a pressing time of 1 minute and 30 seconds are recommended.
• Cold pressing: a pressing time of at least 20 to 30 minutes.

Bonding with neoprene-based adhesive (solvent-based): Follow the adhesive manufacturer's instructions carefully, and verify the compatibility of the finishing varnishes (solvent-based PU) to prevent any damage to the veneer. Neoprene adhesive stains must be removed immediately without using solvents.

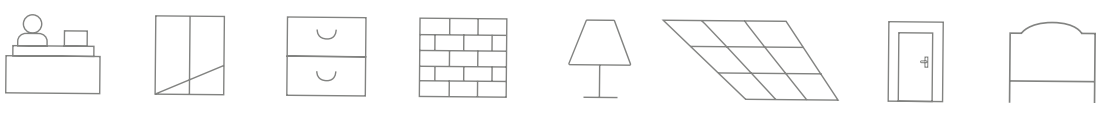
APPLYING AND DRYING THE ADHESIVE: This should be done simultaneously and uniformly over 100% of the surface of the substrates and the back of the Hubler Bilegno® sheets. Wait until the solvents have completely evaporated and the adhesive has dried before applying the sheet to its substrate (in this regard, observe the specified open times).

MANUAL PRESSING (SMOOTHING): Always apply the Hubler Bilegno® sheet to its substrate, starting from the center and working toward the edges. Smooth the sheet with even pressure in both directions and across the entire surface to gradually push the air toward the edges (where pressure should be even greater). This operation must be performed using your full body weight (and repeated after the Hubler Bilegno® sheet and the backing have made full contact) with a double-handled, very hard rubber-coated smoothing roller.

INSPECTION AND POTENTIAL PROBLEMS AFTER GLUING AND BEFORE FINISHING: Once the Hubler Bilegno® sheet has been glued, check for any imperfections related to the gluing process using oblique lighting. The presence of blisters in some areas is due to a lack of adhesive, insufficient drying of the adhesive (which can also cause cracks in the veneer), or insufficient pressure during bonding (pressure is essential for a satisfactory bond). In this case, try to reactivate the adhesive using an iron (applied with light pressure and with the veneer surface protected by a piece of fabric of sufficient thickness), taking care to avoid excessive heat that could discolor the wood. After this step, reapply pressure to the affected area(s).

USE

Wide range of applications in vertical and horizontal interior design
(precautions should be taken in cases of heavy loads).
Avoid humid environments unless proper adhesive and substrate are used.
Not for outdoor use.



MAINTENANCE

Clean with lukewarm, slightly soapy water and a soft cloth.
Avoid abrasive products, polishes, and harsh solvents (such as acetone or trichloroethylene). However, you may use alcohol or a very low-concentration ammonia solution. Any product suitable for cleaning varnished wood furniture may be used.

WARRANTY

HUBLER guarantees that the sheets it sells possess the characteristics defined in this document. It is specified that surface irregularities or imperfections should be considered normal and do not constitute a defect in the products due to the use of natural wood as the sheet's decorative finish.

Given the use of veneers, these sheets, if subjected to excessive heat or an overly dry environment, may develop cracks, which, if they occur, would not constitute a defect in the products. The sheets behave like any other wood, and discoloration (whether uniform or uneven) resulting from excessive exposure to sunlight or moonlight cannot be considered a material defect.
In the event of a dispute, HUBLER's warranty and liability shall be limited to the free supply of unpatterned sheets to replace those found to be defective,

as the installation and intended use of the products are otherwise beyond its control.
Technicians are available to assist customers with specific technical issues.