

VARNISHED ENGINEERED WOOD VENEER ON LAMINATE

BOIS FINIS

COLLECTIONS
HUBLER'S LEGNOSTRAT®
VARNISHED ENGINEERED WOOD

hubler
la matière pour la création

COMPOSITION

Sheets consisting of a natural wood veneer and a laminate backing.

VENEER	The surface, made of FSC-certified engineered wood veneer (Legnotech®), is coated with several layers of acrylic polyurethane varnish. There are two finishes available: a smooth “Waxed Effect” surface or a brushed surface (“Groove” matte—approximately 5 gloss). A transparent film protects the varnished surface. The veneer sheets are joined using a “slip joint.”
PRIMER	The backing consists of sheets of kraft paper impregnated with phenolic resin, which makes them highly flexible to work with. This laminated backing ensures excellent adhesion to suitable substrates.
DEVELOPMENT	Engineered wood veneers (Legnotech®) are natural wood veneers processed using a highly sophisticated technique. The first step involves slicing top-quality light-colored woods (poplar, ayous, etc.) according to the grain patterns of the desired finishes. Once these woods have been sliced, the veneers are cut to a uniform width to form a block. Most of the veneers are then bleached to give them a uniform base color. The veneers are stained using water-based dyes. They are then stacked and bonded under high pressure to form a block, the shape of which is determined by a mold incorporated into the press. Each block reproduces the desired wood species with uniformity in color and structure. The sheets (Legnotech®) may occasionally contain small knots, cracks, splits, etc., which are inherent to the manufacturing process and should not be considered defects. Traditional slicing then takes place, and depending on the angle of the cut, the desired grain pattern is achieved (quarter-sawn, flat-sawn, etc.).

STANDARD DIMENSIONS

SIZES: 305 X 125 CM
Note: The first dimension indicates the grain direction of the wood
Upon request: Other sizes may be available

THICKNESS: APPROXIMATELY 10/10 MM.
Note: Approximate dimensions (wood veneers)

ESTIMATED WEIGHT: 1.7 kg/m²

EQUIPMENT

Although the industrial manufacturing process ensures consistency within each production lot, it is recommended that all sheets be inspected and matched before installation.

Each sheet is identified by its product code and date of manufacture.

Any variations in structure and/or color between different production lots should not be considered a nonconformity.

PLEASE CONTACT US IF YOU WISH TO RECEIVE DELIVERIES FROM THE SAME BATCH FOR YOUR CONSTRUCTION SITES.

No claims will be considered once the cutting and/or pressing has been completed.

TECHNICAL SPECIFICATIONS

BENDING	Concave or convex when cold-bent, with a radius of curvature that varies depending on the specifications and the direction of the bend. Cold bending up to a radius of 20 cm.
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	Legnostrat® products can be FSC®-certified upon request (FSC® license -C201649).
SURFACE RESISTANCE	The protective coating on their surface gives these sheets limited resistance to abrasion and scratches
FIRE RESISTANCE	Products with a thickness of less than 2 mm are not subject to the Euroclass standards (see EN 438-7). Our single-sheet laminates do not have a fire-retardant treatment on the kraft layer.
LIGHT RESISTANCE	Given their nature, the veneers used in the designs of these sheets undergo a uniform change in color over time, which varies depending on the product code. Without adequate protection from sunlight or moonlight, irregular discoloration of the veneer may occur in some cases. This should not be considered a nonconformity.

STORAGE

Before installation, and to prevent warping, the sheets must be stored and packaged for several days in a closed, dry room along with the backing materials and balancing sheets.

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 up 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 standard decorative laminates, with the following exceptions:

SUPPORT	Given the reduced thickness of the sheets (to minimize the darker edge), use backing panels that are perfectly clean and flat (properly calibrated).
PROTECTION	Writing on the surface with a marker or pen could damage the veneer. During the fabrication process in the workshop, it is recommended to always protect the surfaces of the veneers exposed to moonlight and sunlight to prevent discoloration. Do not leave any accessories on the veneers to prevent marks from forming on the wood.
BALANCING	To counterbalance the panels, do not use standard decorative laminates, as their coefficients of expansion differ. Use the counterbalances 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.

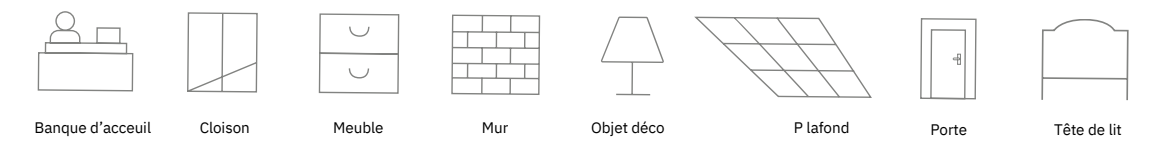
APPLYING ADHESIVE AND ALLOWING IT TO DRY:
This must be done simultaneously and evenly over 100% of the surface of the substrates and the back of the Hubler Legnostrat® sheets. Wait until the solvents have completely evaporated and the adhesive has dried
before applying the sheet to its substrate (in this regard, observe the specified open times).

MANUAL PRESSING (SMOOTHING):
Always apply the Hubler Legnostrat® sheet to its substrate, starting from the center and working toward the edges. Smooth the sheet using even pressure in both directions and across the entire surface to gradually force 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 Legnostrat® sheet and the substrate are fully in contact) with a double-handled, very hard rubber-coated smoothing roller.

INSPECTION AND POTENTIAL PROBLEMS AFTER GLUING AND BEFORE FINISHING:
Once the Hubler Legnostrat® sheet has been glued, check for any gluing-related imperfections 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 by 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, which could discolor the wood. After this step, re-press 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 decorative finish on the sheets.

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.