

## Iswood® door leaf blanks

<b>Sawing</b>	Use chrome or carbide tipped tools and standard woodworking machines.
<b>Cut-outs</b>	Cut-outs for glass or infill can be realised in many shapes and variations. We recommend lateral frieze widths of 200 mm. For exterior doors with cut-outs with a frieze that is less than 180 mm wide, we cannot guarantee the dimensional stability of the ISWOOD® door leaf blank.
<b>Reinforcements</b>	Any kind of reinforcements like additional panels must be installed floating. Permanently bonded additional panels may lead to warping of the door leaf. Dark coloured doors react stronger to solar radiation. With dark coloured doors, prefix floating reinforcing panels with 10 mm insulation in between.
<b>Veneering</b>	<p>If veneering the Frinorm ISWOOD® door leaf blank, keep the bonding temperatures low. Strong thermal expansion during gluing leads to severe tension in the aluphenol board.</p> <p>Bonding temperature: &lt;70 °C; pressing time: approx. 5 minutes</p> <p>In principle, as cool and fast as possible depending on the applied adhesion system.</p> <p>Apply glue sparingly to keep the risk of glue penetration low.</p> <p>Sanded aluphenol boards must be veneered with D4 powdered glue or PVAc glue with D4 hardener.</p> <p>We recommend contacting your glue supplier prior to veneering the ISWOOD® door leaf blank.</p>
<b>Moisture</b>	<p>Door leaves exposed to moisture (exterior doors, pergola doors, etc.) require functional moisture protection. The cut-outs in the doors (lock, hinges, integrated door closers, floor seals, etc.) must also be treated.</p> <p>To prevent warping of the entrance element in the long term, only readily finished doors with adequate moisture protection may be installed in the building under construction. Mere priming of a door is not sufficient to ensure moisture protection. All fittings and seals must be installed so that moist construction air cannot penetrate the door and condense there.</p> <p>After inserting glass or infill, the joins must be sealed in such a way that water or moisture cannot penetrate.</p>
<b>Storage</b>	The ISWOOD® door leaf blank is delivered without moisture protection. The door leaf blank must be stored in a dry, air-conditioned room with average air humidity. Store flat and horizontally. Do not lean or angle against walls. When storing on a damp surface, ensure sufficient protection.
<b>Warranty</b>	Many factors influence the quality of doors. Surface finishing plays an important role besides the material, the structure and mechanical processing. The dimensional stability and weather resistance of the surface as well as all other attributes depend on the correct processing and selection of the lacquer system. Frinorm AG warrants the quality of the ISWOOD® door leaf blank in the context of the values and test standards stated in this technical information. However, it will expressly not assume any liability for defects occurring during processing and handling.