





PROCESSING GUIDELINES

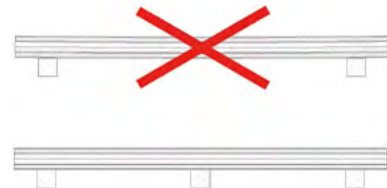


 High acoustic performance
 Maximum Stability
 Fire rated BS 476 Pt.22

LAMINESSE FireSound 44 mm | 54 mm | 59 mm

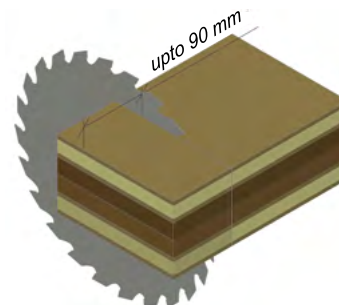
STORAGE

LAMINESSE FireSound door blanks are to be carefully stored on evenly-set bearers in order that they do not bow or delaminate.



SIZE REDUCTION / SPECIFIC ADHESIVE PATTERN

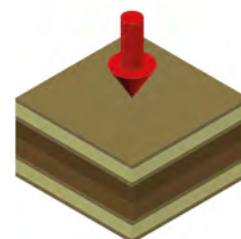
In order that FireSound's extremely high acoustic value is achieved, the individual layers of the blank around the acoustic layers are glued in a specific pattern. **This gluing is not across the full surface of all the layers. Areas around the acoustic core that are not glued are not a reason for a product deficiency claim.** The FireSound blank is however fully glued around its perimeter so that 90 mm could be trimmed away. We would recommend that if the blank is shortened in excess of this, glue is applied along the edge prior to lipping.



PRESSING PRESSURE / VENEERING

The highly-performing acoustic core will 'give' under excessive pressure. The maximum required pressing pressure to enable adequate veneering and lipping is 5,0 N/cm².

To assure that the extremely high acoustic value is achieved, all papers, veneers, HPL and other surface materials should be applied in a 'cold way' with PU or PVAC glue at maximum temperature of a maximum of 60° Celsius.

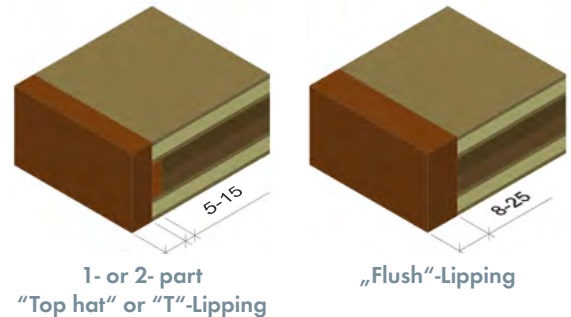


LIPPING DETAILS

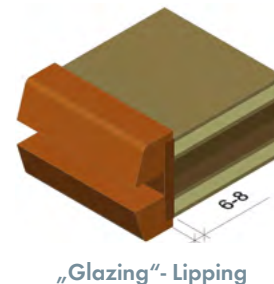
Flush timber lippings are certified from 6-10 mm for FireSound 44 mm and from 8-25 mm thickness for FireSound 54 mm and 59mm.

For FireSound 59 mm Moralt recommends the use of a 1- or 2-part "Top hat" or "T"-Lipping, so that the best purchase for locks and hinges is achieved.

If the blank is cut-down beyond the perimeter glue (see note "Size reduction/specific adhesive pattern") or **if it is veneered before it is lipped, we would recommend a timber insert** (or the first part of a 2-part "Top-hat" or "T"-Lipping) along the 2 long edges of the door.



For glazing inserts a lipping detail in thickness 6 - 8 mm should be used. This lipping is important for a high-end, quality, secure finish for a fire retardent doorset. Moralt would recommend applying the lipping detail prior to veneering.



ADHESIVE

Lippings and face layers should be applied using PVAC, PU or urea-formaldehyde resins. PU HOTMELT is generally possible, but on account of its delayed action, Moralt would advise against using this adhesive.



TEST REPORTS / ASSESSMENTS

Please consider our test reports, both acoustic and fire, from IFC and SRL.

Please note: The specifications of the different Fields of Application can deviate from each other. In this case, the specification in the Global Assessment/Field of Application is obligatory.



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