

Vorstand
Betr. Oec. Siegfried Kohler
Info@kaufmann-holz.at
www.kaufmann-holz.at

Offenlegung
LG Feldkirch
FN 73273 f
DVR 0310298

AT-6870 Reuthe
Telefon
++43/5574/804-0

Telefax
Verwaltung ++43/5574/804-101
Vorstand ++43/5574/804-200
Vertrieb ++43/5574/804-202

KAUFMANN
Holz GmbH

Quality description Concrete shuttering board K1

Our concrete shuttering boards are produced in accordance with the provisions as given by the standard „ÖNORM B3023 Solid wood boards, three-layer concrete shuttering boards, types and requirements“.

Quality requirements for the outer layers of three-layer concrete shuttering boards:

Assessment features	Quality requirements
Width of strips	Min. 30 mm, max. 180 mm
Species of timber	Spruce (FI), fir (TA), mixing of species of timber is permissible
Edge treatment of the strips	Parallel or conical edge-sawing and square-edged. On the face turned towards the centre layer minor rough edges are permissible provided they do not continue up to the face edge.
Surface	Even before the surface coating the outer layers have to be even (GL) or textured (STR). The individual strips must be placed densely bodied. Scattered junctures with a max. length of 500 mm and a max. width of 1 mm are permissible, provided they are filled by the top coating.
Pegs	Timber defects may be corrected by wooden pegs. The pegs must be clean cut and solidly glued. Max. permissible size of wooden pegs: dia. 40 mm or oval 50 mm x 25 mm. Not more than 15 pegs are permitted per square meter and per face.
Glueing	The glueing between the outer layers and the centre layer must meet the requirements of 4.4.
Knots	Knots of up to 20 mm x 40 mm are permissible. A maximum of 5 healthy, firmly rooted knots up to 40 mm x 80 mm are permitted per square meter. Scattered knotholes up to dia. of 5 mm are permitted (in case of STR boards up to a dia. of 10 mm).
Discolouration, fungal attacks	Discolouration of up to 20 % of the surface are admissible per face. Decay is not allowed.
Stunted wood	Small strips of stunted wood are admissible.
Fissures	Fissures with a max. bent of 1:10 up to 1 mm width and of max. of 500 mm length are admissible. They must however be filled by the top coating (except with type STR boards).
Rosin galls	Rosin galls of max. 5 mm x 50 mm are admissible (with type STR boards: max. 10 mm x 100 mm).
Wood with circular splits inside	Inadmissible
Infestation, shot-holes	Infestation is inadmissible. Individual small shotholes are admissible.

Quality requirements for the centre layer of three-layer concrete shuttering boards:

Assessment features	Quality requirements
Width	Strip width max. 180 mm.
Species of timber	Spruce (FI), fir (TA), pine (KI), larch (LA), mixing of species of timber is admissible.
Edge sawing	The cut on both edges and on the alongside of the boards must be true and square. In the covered area individual rough edges up to 5 mm (measured on the bias) are admissible.
Discolouration, fungal attacks	Discolouration is admissible. Decay is not allowed.

Sizes and dimensional tolerances of three-layer concrete shuttering boards (indicated in mm)

Thickness		Length		Width	
Nominal size	Tolerance	Nominal size	Tolerance	Nominal size	Tolerance
21	+/- 1	1000	+/- 1	500	+/- 1
27		1500		1000	
		2000		1500	
		2500		2000	
		3000	+/- 2		
		3500			
		4000			
		4500			
		5000			
		5500			
		6600			

The permissible allowance of the longitudinal edge from the straight line for boards up to a length of 3000 mm may be 1 mm, for longer boards 1,5 mm. In case of boards of a width of up to 500 mm a parallel bent of the longitudinal edges of up to 1 ‰ of the length is admissible.

Moisture contents of the boards:

The moisture contents of three-layer concrete shuttering boards related to the kiln-dry mass must be 12 +/- 3 % at the delivery.

The flexural strength and Young's bending modulus:

The flexural strength and Young's bending modulus of three-layer concrete shuttering boards must correspond to the limiting values according to table 4.

Table 4: Minimum values of flexural strength and of Young's bending modulus for three-layer concrete shuttering boards with fiber orientation of the outer layers in longitudinal axis of the board.

Nominal tickness	Flexural strength N/mm ²	Young's bending modulus N/mm ²
21 mm	40	8000
27 mm	35	7200



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Vorderreuthe 57
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3-S concrete shuttering board with laminated deck



Standard formats

Advantages

- No adhesion of concrete sludge to the front timber
- Simple cleaning
- Water-repellent edges
- Better sealing of cracks even after repeated use

Formats

Length x width in cm

100	50	
150	50	
200	50	100
250	50	100
300	50	100

Centre layer

21 mm laminated centre layer
27 mm notched board centre layer

Large areas

Centre layer

21 mm laminated centre layer
27 mm laminated centre layer

Edge sealing

shuttering edge varnish

Formats

Length x width in cm

400	50	100	200
500	50	100	200
600	50	100	200

The top product world-wide for the highest demands of concrete appearance and durability.

Unique appearance of concrete

- Completely polished surface with resistant melamine resin coating at approx. 130 g per m² and side
- The narrow cover lamellas mean that cracks are rare even after multiple use
- Cut to shape precisely
- Large knots avoided through selected timber quality and block structure
- Absorbent shuttering areas for optimal pore structure of

the concrete surface

- Smooth appearance of concrete even when small formats are combined, since these are cut from larger formats

Greater durability

- Through our production procedure, mainly vertical year rings in outer layers, no clamps, therefore resistant surface
- Absolutely sealed glued-block outer and centre layer, no edge band

- No breaking off of the longitudinal edges even under high mechanical stresses, since the centre layer is continuously glued right up to the outside
- Can be cut anywhere without impairing the working life. Layer thicknesses stay exactly the same
- Packets delivered suitable for the building site with 40 pce (or 50 pce for 21 mm), for stacking with attached wooden underlay

- Packets can be delivered wrapped in plastic sheet, at an additional charge
- Special formats for column and downstand beam shuttering can be delivered without difficulty

Weight

21 mm approx. 10.5 kg/m²
27 mm approx. 12.5 kg/m²

Standards

Gluing BFU 100 (AW 100)
ÖENORM 83023