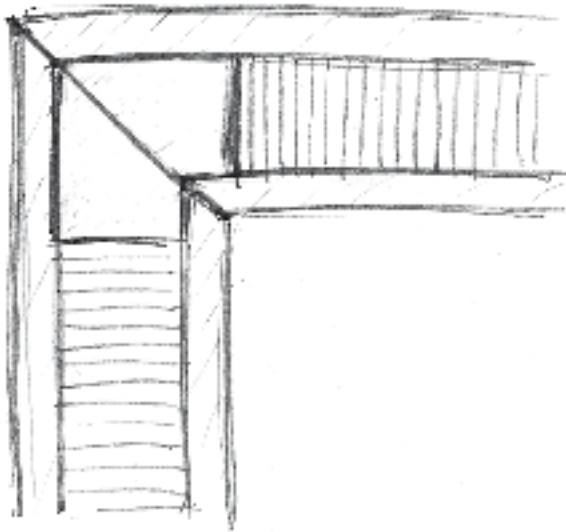


**MORE FROM WOOD.**



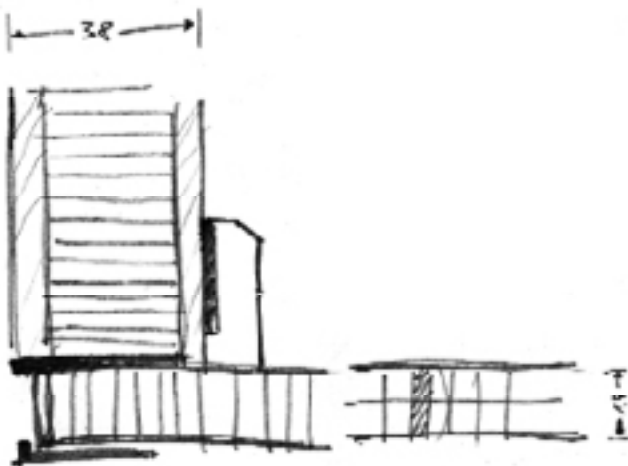
**EUROLIGHT®**  
**PROCESSING INSTRUCTIONS AND**  
**TECHNICAL SPECIFICATIONS**  
**SURFACE LAYER 8 mm**



Mitre joint with frame



Frameless mitre joint



Hinge



Sliding door fitting attachment

**PROCESSING INSTRUCTIONS AND  
TECHNICAL SPECIFICATIONS**

**Surface layer 8 mm**

**Contents**

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# EGGER EUROLIGHT®

## Storage information

The following recommendations apply to EUROLIGHT® lightweight boards. The recommendations are designed to help you produce technically and visually perfect furniture and interior design products. The surface layers of EGGER EUROLIGHT® consist of high-quality 8 mm EUROSPAN® 2000 thin chipboard that conforms to EN 312 board type P2 with a raw, sanded surface or high-quality EURODEKOR® melamine coating to EN 14322. Gluing to a hexagonal honeycomb core takes place using a high-quality formaldehyde-free polyurethane adhesive system. The 15 mm hexagonal honeycombs are made from 100% recycled paper.

### DELIVERY

Careful inspection of incoming goods is an essential part of proper order processing and is included in the EGGER Group's payment and delivery terms. EGGER recommends that this inspection is carried out using statistical stock control methods.

A suitable unloading facility must be provided (e.g. fork lift truck). EUROLIGHT® lightweight boards must be carefully transported and stored.

### DIRT

EUROLIGHT® lightweight boards should be protected from dirt with suitable covers during transportation, storage and assembly.

### PROTECT AGAINST MOISTURE

When storing EUROLIGHT® lightweight boards, take appropriate measures to ensure that the material is not exposed to the weather. We recommend storage in heated, draught-free, dry rooms with a relative humidity between 40 and 75 % and an air temperature of 15 – 18 °C.

Open-air storage or storage under lean-to roofs is not advisable.

The boards should be stored for a while before being processed so that their humidity level when installed corresponds to the level expected during their service life.

## STORAGE AND TRANSPORT

Due to their large size, EUROLIGHT® lightweight boards should ideally be stored flat on dry, level ground in a closed moisture-free building under normal climatic conditions. Bearers should be of the same height and arranged, according to board thickness, with gaps of 0.8 m to 1.1 m.

Once the pack is opened, protection for the edges must also be provided. Storage and transport must be carried out in line with the information provided under "Stacking" and in accordance with transport, storage and safety regulations.

## STACKING

Local stacking and safety regulations apply. The following are the maximum possible stacks based on a pressure test on a EUROLIGHT® pack of identical thickness and surface layer thickness as the packs to be stacked:

EUROLIGHT® packs should not be stacked underneath other wood-based material packs during storage or transportation.

EUROLIGHT® DECOR with 8 mm surface layer – HALFBOARD 2800 x 2070 mm					
Board thickness [mm]	EUROLIGHT® per pack	Height/mm inc. spacers and cover board	Weight per pack in tons	Number of stacked EUROLIGHT® 550 mm packs	Stack height in m
38	12	513	0.91	7	4.10
50	9	507	0.70	9	5.07
60	8	537	0.64	10	5.91

## DISPOSAL

EUROLIGHT® lightweight boards can be disposed of in the usual manner for wood-based products:

- Materials can be recycled
- Materials can be burnt and used as energy, resulting in minimal damage to the environment from carbon emissions.

# EGGER EUROLIGHT®

## Processing

### CUTTING

When cutting EUROLIGHT® lightweight boards, chips may fall into the honeycomb core. These must be removed before processing the edges.

If the honeycomb boards are cut using horizontal cutting machines that use a pressure bar and slider with pressure grippers, the pressure applied by the grippers must either be decreased or shims inserted close to the grippers to ensure the pressure is distributed more evenly. The maximum compressive rigidity of EUROLIGHT® lightweight boards is 0.15 N/mm<sup>2</sup> (1.5 kg/cm<sup>2</sup>).

Depending on the size of the workpiece and the number and shape of the grippers, the pressure should be reduced to 1-2 bar according to the type of machine.

### VENEER/LAMINATE

Veneering or laminating EUROLIGHT® lightweight boards is possible with all normal bonding systems. As a basic rule, a maximum press temperature of 90°C for a maximum duration of 3 min. should be applied for both dispersion and condensation glues. To avoid a build up of heat in the centre layer of the board, suitable openings must be provided to ensure heat can be dissipated.

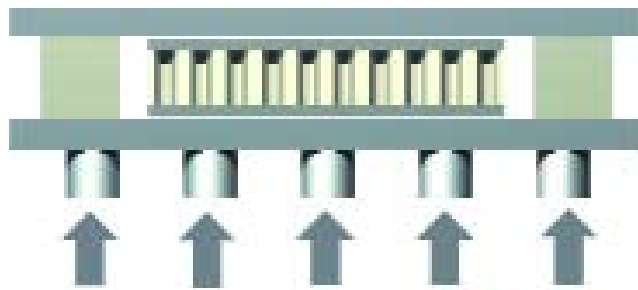
Press conditions for veneering or laminating of EGGER EUROLIGHT® RAW (with a surface layer thickness of 8 mm):

	Frameless EUROLIGHT® board	EUROLIGHT® board cut with 2 or 4 sided frame
Veneering with dispersion or condensation glues	Max. press temperature: 90°C Max. press duration: 3 min. Max. specified press pressure: 1.5kg/cm <sup>2</sup>	Max. press temperature: 80°C Max. press duration: 3 min. Max. specified press pressure: 3-5 kg/cm <sup>2</sup>
Laminating with EGGER EUROFORM® laminate	Max. press temperature: 70°C Max. press duration: 3 min. Max. specified press pressure: 1.5 kg/cm <sup>2</sup>	Max. press temperature: 70°C Max. press duration: 3 min. Max. specified press pressure: 3-5 kg/cm <sup>2</sup>

If necessary, contact the adhesive manufacturer for information on suitable adhesive systems.

#### Press pressure:

On frameless EUROLIGHT® boards, we recommend a specific press pressure of 0.15 N/mm<sup>2</sup> workpiece surface (1.5 kg/cm<sup>2</sup> or 1.5 pounds per square inch). As the honeycomb structure of the core could be damaged at higher pressures, we recommend the use of shims to prevent buckling if the press pressure exceeds 0.2 N/mm<sup>2</sup>.



## EDGING

### EGGER ABS Security Edging and EGGER accent edging

EUROLIGHT® lightweight boards with 8 mm surface layers (38 mm and 50 mm thick) can be edged with 8 mm EGGER ABS Security Edging and EGGER accent edging using normal edge banding machines.

The processing instructions for EGGER ABS Security Edging and EGGER accent edging must always be observed when edging EUROLIGHT® lightweight boards.

From our experience, EUROLIGHT® lightweight boards (38 and 50 mm thick) can be edged directly using EGGER ABS Security Edging (45 x 2 and 54 x 2 mm) or EGGER accent edging (43 x 1.5 and 54 x 2 mm).

If, however, the edging results are unsatisfactory, the following steps (recommended by HOMAG) can improve the result when edging using continuous flow systems:

- Reduce contact pressure of trimming unit
- Reduce pressure of upper belt
- Use a form cutter with a slightly hollow section for 2.0 mm edge bandings

### Veneer edges

EUROLIGHT® lightweight boards with 8 mm surface layers (38 mm and 50 mm thick) can be edged with multi-layer veneeredges. For thicknesses of 38 mm, edge thicknesses from 1.5 mm are suitable and for a thickness of 50 mm, edge thicknesses of 2 mm are suitable. The processing recommendations of the veneer edging manufacturer must be observed for this type of edging.

On edge gluing machines that apply the glue through nozzles, this type of application may cause creases in the edge surface of 50 mm EUROLIGHT® lightweight boards. These creases can only be prevented by using supporting edges or frames or by milling back the honeycomb.

## FRAMES FOR FURNITURE MANUFACTURE

When gluing the frame material, ensure that the surface layers have also been milled in order to obtain better gluing results. Suitable frame materials are wood-based materials, such as chipboards and MDF, or knot-free, dried solid wood.



## TEMPERATURE RESISTANCE

Built in lighting systems can be used with furniture made from EUROLIGHT®.

# EGGER EUROLIGHT®

## Fittings

All types of fittings generally available can be used with EUROLIGHT® lightweight boards that have 8 mm surface layers. The suppliers of the fittings will be able to provide further information.

Product		EUROLIGHT® 38 mm	EUROLIGHT® 50 mm	EUROLIGHT® 60 mm
<b>Cup hinge</b>		Cup hinges can be attached using standard chipboard screws		
<b>Drawer runner (Full extension)</b>		Extension can be attached using standard chipboard screws		
<b>Drawer runner (Partial extension)</b>		Extension can be attached using standard chipboard screws		
<b>Rear panel connector</b>		Rear panel can be connected using standard chipboard screws		
<b>Shelving support</b>		Shelving support for chipboard		
<b>Wardrobe rail supports</b>		Wardrobe rail supports can be attached using standard chipboard screws		

Carcass connectors recommended and available from the fittings supplier		EUROLIGHT® 38 mm	EUROLIGHT® 50 mm	EUROLIGHT® 60 mm
<b>Hettich VB 36/38 HT</b>		# 906 638 900 *		
<b>Hettich VB 36/50 HT</b>			# 906 638 100 *	# 906 638 100 *
<b>Häfele TAB 20/32 HC</b>		Black # 263.95.332 * Nickel-plated # 263.95.732 *		
<b>Häfele TAB 20/40 HC</b>			Black # 263.95.335 * Nickel-plated # 263.95.735 *	Black # 263.95.335 * Nickel-plated # 263.95.735 *
<b>Häfele Rafix 20 with dowel plugs</b>		Nickel-plated with lip # 263.17.705 * Nickel-plated without lip # 263.13.705 *		

The processing instructions of the fittings supplier should be observed

\* Article numbers of the corresponding fittings supplier

# EGGER EUROLIGHT®

## processing instructions check list

<b>STORAGE</b>	✓
The storage area must be flat and dry	
No heavy packs should be placed on top of this product (max. 3 to)	
The maximum stack height of EUROLIGHT® packs is as follows (subject to the maximum stack height of the respective building) With 38mm boards: 7 packs / 50mm boards: 9 packs / 60mm boards: 10 packs	
<b>Cutting</b>	✓
The pressure of the grips and of the pressure beam must be reduced to 1-2 bars	
If the pressure is not regulated, increase the surface area of the grips	
If the pressure is not regulated, insert shims to distribute the pressure more evenly	
<b>Laminating/veneering</b>	✓
In principle all existing gluing systems can be used with product specific press conditions	
EUROLIGHT® RAW with frames	
Maximum specific pressure of 3-5kg/cm <sup>2</sup>	
Maximum press temperature of 80°C (With EUROFORM® Laminate max. 70°C)	
Maximum press time – 3 minutes	
EUROLIGHT® RAW without frames	
Maximum specific pressure of 1.5kg/cm <sup>2</sup>	
Maximum press temperature of 90°C (With EUROFORM® Laminate max. 70°C)	
If the pressure cannot be reduced accordingly, insert spacing strips in the press	
Maximum press time – 3 minutes	
<b>Edging</b>	✓
Reduce the pressure of the track	
Minimise the pressure of the trimming track	
Direct edging of frameless boards is possible with EGGER ABS Security Edging in size 45 x 2 mm and 54 x 2 mm or EGGER Accent Edging in size 43 x 1.5 mm and 54 x 2 mm.	
Direct edging of frameless boards is possible with 2 mm multi-layer veneered edging	

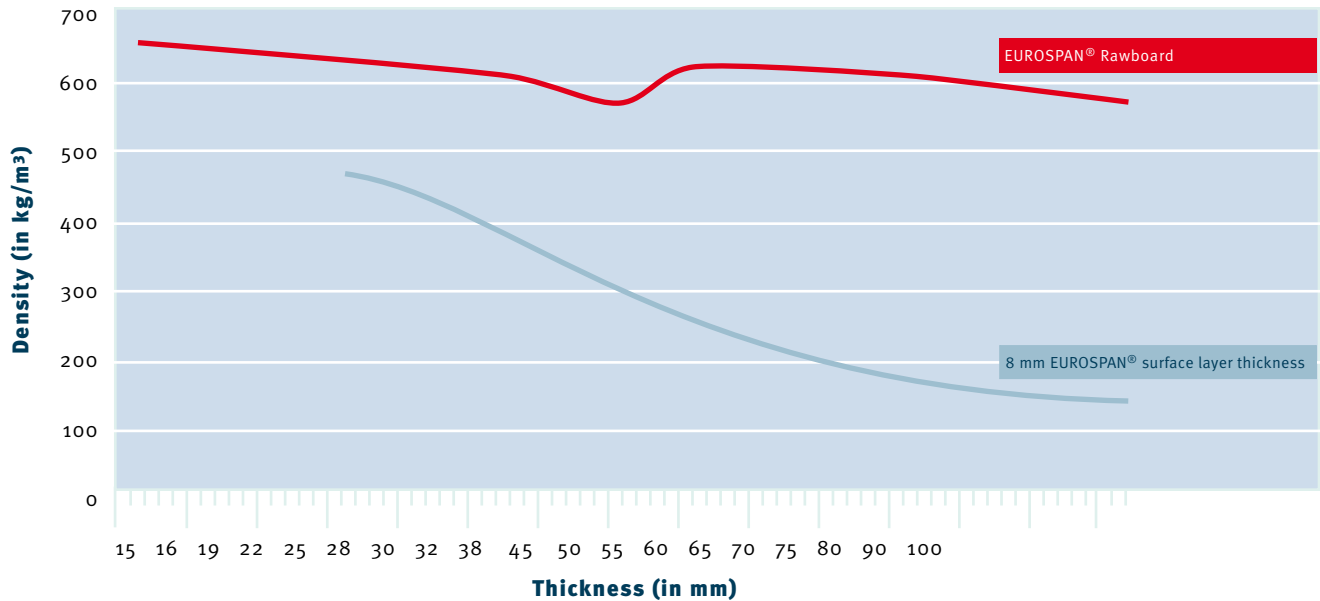
# EGGER EUROLIGHT®

## Properties

General tolerances	Standards used	Unit	Value
<b>Thickness tolerance</b> Applying to the nominal dimension	EN 324	mm	± 0.3
<b>Length and width tolerance</b> - Full board - Cut framed elements	EN 324	mm	± 5.0 ± 2.0
<b>Curvature</b> - Full board - Cut framed elements	EN 14322	mm/m	≤ 2.0 ≤ 2.0
<b>Squareness</b> - Full board - Cut framed elements	EN 324	mm/m	≤ 2.0 ≤ 2.0
<b>Edge straightness</b> - Full board - Cut framed elements	EN 324	mm/m	± 1.5 ± 1.5
<b>Bonding strength</b> - Cover board for honeycomb	according to EN 319	N/mm <sup>2</sup>	> 0.15
<b>Screw withdrawal resistance</b> - Full board with 8 mm surface layer	EN 320	N	> 570
<b>Edge nicks</b> - Full board - Cut-to-size boards	EN 14323	mm	≤ 10 ≤ 3.0
<b>Limit deviation density to mean value</b>	EN 323	%	±10
<b>Formaldehyde content</b>	EN 120	mg/100g	E1
<b>Temperature resistance</b>		°C	≤ 80°C

Properties EUROLIGHT® with 8 mm surface layer	Unit	Board thickness (mm)		
		38	50	60
Density	kg/m <sup>3</sup>	325	255	220
Bonding strength according to EN 319	N/mm <sup>2</sup>	≥ 0.15		
Deflection Permanent load acc. to DIN 68874-1 ISO 7170 after 28 days - Test load 150 kg/m <sup>2</sup> Centre-to centre distance 1000 mm Board size 1025 mm x 400 mm	mm	≤ 7	≤ 3	≤ 2.5
Sound insulation index (R'w)	dB	28	26.5	25.5
Compression strength	kg/cm <sup>2</sup>	1.5		
Fire class according to EN 13501-1		D-s1,do		

### Density diagram



### Climatic test EUROLIGHT® in alternating climatic conditions

	Starting climate	Measure-ment 1 after 14 days	Additional thickness with respect to starting climate		Measure-ment 2 after 18 days	Additional thickness with respect to starting climate		Measure-ment 3 after 34 days	Additional thickness with respect to starting climate	
Climate setting	25°C/24% Humidity	25°C/68% Humidity			23°C/50% Humidity			23.5°C/24% Humidity		
Measurement point	Thickness (mm)	Thickness (mm)	mm	%	N/mm <sup>2</sup>	mm	%	N/mm <sup>2</sup>	mm	%
Mean value	30.00	30.40	0.40	1.35	30.30	0.30	1.02	30.06	0.06	0.22

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