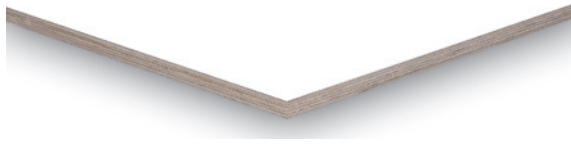


TEBOPRIME OKOUME



Wall cladding, facades, gables, barge boards, fascias, constructions in exposed exterior environments. Any exterior end-use where the plywood product is going to receive a paint application. TEBOPRIME is a pre-painted panel that allows the finish coat to be applied up to 2 months after installation.



DESCRIPTION

Base board: Okoume throughout Plywood

Faces: both sides with a white pre- paint coating system 110 / 110 μ

Average density (IAW EN 323): 500 kg/m³ (+/- 10%)

Bonding (IAW EN 314-2): class 3

Service (IAW EN 636): class 3 exterior conditions

Formaldehyde release classification (IAW EN 717-1): E0,5 (\leq 0,062 mg/m³)

Content of Pentachlorophenol (IAW EN 13986): PCP \approx 0 ppm

SIZES, NUMBER OF PLYS & PACKAGING

Thicknesses (mm)	Number of plies	Sizes (mm)	Packing
10	(5)	2500 x 1220 3100 x 1530	45
12	(5)		37
15	(7)		30
18	(9)		25
22	(11)		20

Other sizes & thicknesses: on request

OPTIONS

Preservative treatments, fungicide & Insecticide, antitermite: optional on request

Cutting & TG processing: optional on request

STORAGE

Flat, on intermediate bearers, in an enclosed dry and ventilated building, clear of the ground. As far as storage on site is concerned, provision should be made to cover the panels with an opaque waterproof sheeting with the underside of the stacks clear of the ground.

FURTHER PROCESSING & INSTALLATION

Compliance with standard practice, with regulations and with health and safety rules should be maintained at all times.

Cutting and machining in the workshop possible except laser technology.

Compatibility with other paint coatings

TEBOPRIME is pre-painted with a water based primer. We therefore strongly recommend to privilege the selection of water based acrylic type finishing paints because of proven compatibility factors. However previous tests should always been carried out to verify suitability and compatibility on a sample piece in co-ordination with the paint supplier.

Non water based finishing type paints should be strictly submitted to previous compatibility tests on a sample piece to verify suitability and in co-ordination with the paint supplier.

PRODUCTION SITES

Production on Thébault's sites in France



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TECHNICAL PROPERTIES

Characteristic values (MPa) IAW EN 789 - 1058 for structural calculations IAW Eurocodes

		10	12	15	18	22
Modulus of elasticity (E_m)	//	3597	4136	3464	3240	3828
	-L	5653	5114	5786	6010	5422
Bending strength (f_m)	//	22,4	22,4	18,7	17,4	19,7
	-L	42,2	36,5	40,3	39	34,6
Others characteristic values	Available on DOP Strength in: Tension (f_t), Compression (f_c), Panel shear (f_v) and Planar shear (f) Modulus of elasticity in: Tension (E_t), Compression (E_c), Panel shear (G_v) and planar shear (G)					

Uses

Use in structural applications (IAW EN 13986, EN 636-3, EN 636-2, EN 636-1)	Suitable for use as structural element in exterior conditions (service class 3), humid conditions (service class 2) and interior conditions (service class 1)
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Nail and screw holding (t = 15 mm)

Nail	Face and edge: 300 N	
	Face	Edge
Screw	1450 N	1150 N

Bending radius (mm)

Thicknesses	10	12	15	18
//	2000	2400	3000	3800
-L	2000	2400	3000	3800

Nail and screw holding (t = 15 mm)

Nail	Face and edge: 35 daN	
	Face	Edge
Screw	180 daN	100 daN

Bending radius (mm)

Epaisseur	4	5	8	10	12	15	18
//	800	1000	1600	2000	2400	3000	3800
-L	800	1000	1600	2000	2400	3000	3800

Sound absorption coefficient

IAW EN 13986 Table N°10	Frequency range	
	250 Hz to 500 Hz	1000 Hz to 2000 Hz
	0,10	0,30

Thermal conductivity

IAW EN 13986	$\lambda = 0,13$
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Characteristic density

IAW EN 789	430 kg/m ³
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Vapour permeability

IAW EN 13986 Table 9	Wet cup	Dry cup
	70 μ	200 μ

Reaction to fire

End use condition In reference to table 8 of EN 13986 - 2004+A1:2015	Minimum thickness	Class excluding floorings	Class floorings
Without an air gap behind the panel	9 mm	D-s2,d0	D _{fl} -s1
With a closed or an open air gap not more than 22 mm behind the woodbased panel	9 mm	D-s2,d2	-
With a closed air gap behind the wood-based panel	15 mm	D-s2,d1	D _{fl} -s1
With an open air gap behind the wood-based panel	18 mm	D-s2,d0	D _{fl} -s1
Any	3 mm	E	E _{fl}

Airbone sound absorption

IAW EN 13986 Paragraph 5.10	The sound transmission loss R of a single wood-based panel, measured in dB, is related the mean surface mass m_A en kg/m ² according to the following equation (which is only valid for the frequency range of 1 kHz to 3 kHz and at a surface mass > 5 kg/m ²): $R = 13 \times \lg(m_A) + 14$
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TECHNICAL SUITABILITY & CERTIFICATION

CE Structure attestation of conformity 2+	0380 - DOP* - CPR - EN 13986 : 2004 + A1 : 2015 - EN 636-3 S E1 * DOP : Declaration of Performance available on www.groupe-thebault.com
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Quality marks (country)	Ecocertification	CE Marking
NF Extérieur CTB-X (F)	FSC®	CE S (Structural)

FURTHER PROCESSING & PRECAUTION FOR USE

Surface characteristics

TEBOPRIME OKOUME is a semi-finished surfaced with an UV-sealant and a water-based primer. The sealant coat is tight whilst the primer remains soft and open to allow a good adhesion of the finishing coats. In a complete painting system final paint coats are those that give the final hardness to the surface finish.

This has 3 advantages on site: time saving, labour saving, temporary protection.

Handling

Due to its open and soft structure, the panel surface has low abrasion and impact resistance. It is therefore recommended to avoid all types of friction, shocks and impacts during transport and handling in the workshop and on site.

Preparation of the plywood substrate for the finishing coats.

Preparation of the plywood substrate for the finishing coats.

Visually inspect the face and back sides. Slight touch - sand the surface to a grit of 180 or finer to remove dirt & marks. After sanding remove the dust. No cleaning products (thinner or water) are allowed. The use of high-pressure cleaners is prohibited.

The moisture content of TeboPrime should not exceed 15% to maximum 18%. After periods of bad weather on site, it may take several days for the panel to stabilize at this humidity level.

Cutting and further processing

Cutting and further processing in the workshop are possible except laser cutting.

The woodgrain direction of the face veneer should be identified under the primer prior to any further processing operation.

The use of a scoring saw is recommended to prevent damage to the coating.

During cutting and machining operations, e.g. chamfer/ bevel ensure the quality and type of tools in order to prevent surface splinters.

Make sure to close possible gaps, voids on the edges and open screwheads on the surface, with a non-shrinking filler that is suitable for over-painting.

Use randsealer, to seal the edges 2 times with a paint-brush, before installation of the panels

Application time for finish coats

The time limit for applying finish coats from the date of installation on site must not exceed 60 days

Panel installation and processing

Proceed in accordance with the state of the art, the national regulations and refer to the THEBAULT Group recommendations available on our website using the following link: https://www.groupe-thebault.com/en/download/963/teboprime-okoume/11230/fp-meo_2020_prime-cp_gb.pdf

When painting on site has been carried out in accordance with:

- ▶ The recommendations in this guide (i.e. compliance with the humidity level of the substrate, slight sanding, checking surfaces, preliminary compatibility tests).
- ▶ Installation in accordance with good practice and THEBAULT recommendations.
- ▶ Respect the recommendations for applying the finishing coat (outdoor environment).

TEBOPRIME with its finish coat can then remain exposed for a long-time in-service class 3 (regular inspection and maintenance of surfaces is required).

Selection of the finish coats

TeboPrime plywood is delivered with a water-based priming system and can be finished with conventional oil-based and water-based paints applied by spray, brush or roller. Water-based, acrylic type, finishing coats are compatible after preliminary usual tests have been carried out to verify suitability and compatibility on a sample piece in co-ordination with the paint supplier. Oil-based finishing coats may be used but are strictly subject to preliminary tests to verify suitability and compatibility on a sample piece in very close co-ordination with the paint supplier.

Certain categories of solvents or dilution degree (solvent or water) may disturb the adhesion of the finishing system. Virtually all paints have a tendency to draw away from a sharp edge or corner.

It is therefore recommended that all corners and edges be rounded to a radius of at least 3 mm by machining or light sanding to enhance paint retention. This is particularly important with panels exposed to exterior conditions (Service Class 3). The edges of TeboPrime plywood are more porous than its surface. As a result, moisture absorption at edges is greater than on the face. Therefore, the edges need to be adequately sealed.

It is recommended to refer to the sealant manufacturer's literature. Proceed in accordance with the state of the art and conform to the national regulations and / or standards in place.

Take specific care of not pulling off the primer when filling with putty the screw heads or mechanical connectors. This operation should be carried out with caution.

Following rules should be followed at all times:

- Ambient and substrate temperature to range between 5 and 35 °C
- Relative Humidity of the atmosphere (RH) to be inferior to 80 %

TeboPrime Plywood, surfaced with a water-based primer, may become wet during after an unfavourable climatic period. It is necessary to wait until the panel has dried before continuing the finishing process.

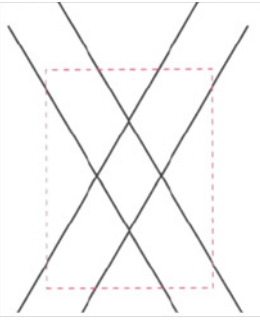
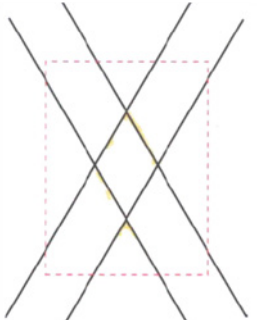
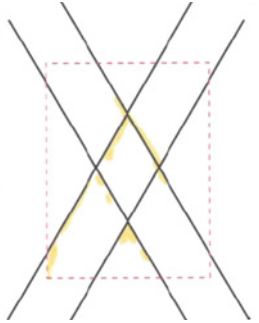
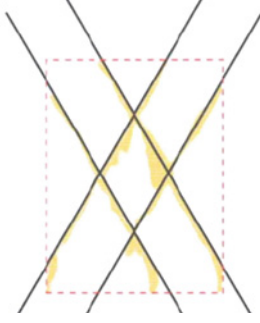
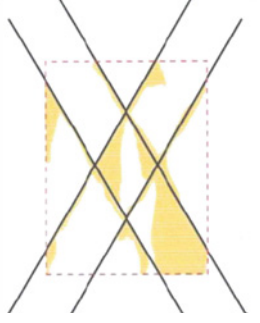
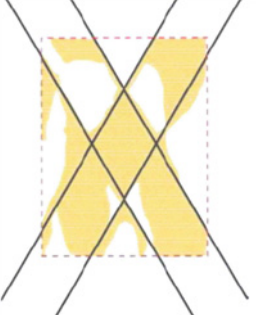
A regular maintenance program has to be established in accordance with the paint supplier's recommendations in order to ensure an optimal lifetime of the building works.

Specifying the adhesion of paint to wood

The adhesion performance of the priming coat can exclusively be evaluated in accordance with the following test method: SKH publication 05-01 (10-10-2005) - Determination of the adhesion of paint on wood.

SKH PUBLICATION 05-01 - DETERMINATION OF THE ADHESION OF PAINT ON WOOD - 2005 -10 -10

Procedure: a double cross cut is made by mean of sharp cutter into the coating on which and adhesive paper tape applied. The paper tape characteristics are width: 25 mm - Adhesion strength 10 N (+/-1) IAW ASTM D 3330.

Scale 0	Scale 1	Scale 2
The edges around the cuts are smooth. None of the crosscuts intersections have delaminated.	Small parts of the coating have delaminated around the crosscut intersections. Not more than 5 % of the coating is removed.	Along the cuts and around the crosscut intersections the coating has delaminated. Between 5 and 15 % of the coating is removed.
		
Scale 3	Scale 4	Scale 5
Along the cuts and around the crosscut intersections and /or other places the coating is removed. Between 15 and 35 % of the coating is removed.	Along the cuts and around the crosscut intersections and /or other places the coating is removed. Between 35 and 65 % of the coating is removed.	More than 65 % of the coating is removed.
		

An adhesion strength corresponding to scale 0 and 1 will ensure a good paint grip

An adhesion strength corresponding to scale 2 and 3 requires prior contact and technical advice from the supplier

An adhesion strength corresponding to scale 4 and 5 is not compatible and requires full sanding and re-application of a primer.

Test in accordance with ISO 2409 (grid pattern) is admissible

Tests with a putty- knife, key, coin or other blunt objects are not normative. They are therefore not valid.

The UV coating combined with the water-based primer does not constitute a finishing system, but only one of its components. This means that the surface coat is somewhat fragile and more likely to become dirty or chalky, but it does guarantee good adhesion of the subsequent finish coats. It is the final finish coats, at the very least carried out according to the rules of the trade, which give the surface rigidity to the finishing system, which must be appreciated in its entirety.

The instructions and recommendations in this document apply exclusively to TEBOPRIME brand products manufactured by the THEBAULT Group.