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VAT. No. 826947683

## SPECIFICATION

### FLEXOKORE® End Grain Balsa Panels

#### Description

This specification describes requirements for FLEXOKORE® select quality, kiln-dried, end grain balsa wood panels suitable for use as a structural core material in composite sandwich structures.

Panels are supplied as Rigid panels or scrimmed and slit to fit contoured surfaces.

FLEXOKORE® is approved by Lloyds Register for use above and below the waterline in marine applications, and by Germanischer Lloyd.

#### Bonded Core Block

Treatment against decay, insects and fungal attack:

Once cut, balsa logs immediately have the bark removed and are sawn into lumber for kiln drying. The kiln drying begins within 8 days of cutting the wood. The kiln drying process serves to sterilise the balsa; stopping the growth of mould and killing fungi and wood destroying insects. The process also dries the lumber to the required level.

Gluing:

After Kiln drying the Bonded Core Block (BCB) is fabricated according to ASTM D-4690 using adhesive to MIL Spec MMMA-188 designed to work with wood.

This information is believed to be correct but no warranty is made, either expressed or implied, regarding its accuracy or results obtained from the use of such information. Also that any such use will not infringe any patent is made.





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Panels

Panels are cut from the BCB. A sample of 12 panels are selected at random from the BCB and inspected to the following standard.

Physical Dimensions	Length	1219.2	+/-3mm
	Width	609.6	+/-3mm
	Diagonals	1363.1	+/-3mm
	Thickness	Nominal	+0.2/-0.3mm

Panels are micro sanded both sides to thickness tolerance.

Moisture ≤ 12%

Balsa will readily absorb moisture from the atmosphere and care must be taken to avoid moisture absorption during storage and during the production process.

Density	Nominal	150 Kg/m <sup>3</sup>
	Range	130-160 Kg/m <sup>3</sup>

Panel density is achieved by measuring each balsa block prior to bonding into the BCB. The table below shows the corresponding minimum and maximum panel weights.

Thickness		Minimum Weight	Maximum Weight
Inches	mm	Kg	Kg
1/4"	6.35	0.61	0.76
3/8"	9.50	0.92	1.13
1/2"	12.70	1.23	1.51
5/8"	15.90	1.54	1.89
3/4"	19.05	1.84	2.27
1"	25.40	2.45	3.02
1-1/4"	31.75	3.07	3.78
1-1/2"	38.10	3.68	4.53

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Wood Quality	Defect	Acceptance
	Pith	Not allowed
	Decay	Not allowed
	Blue stains	Allowed
	Mineral stains	Allowed
	Healthy knots $\leq 5\text{mm}$	Allowed
	Gaps	$\leq 1\text{mm}$ allowed 1-2mm repaired with putty 2-4mm repaired with ply of putty and balsa, maximum 4 per panel

Scrim                      Glass fabric specifically designed for core materials and adhered to panel with styrene soluble glue

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