

Technical Information Sheet TIS 01 Annex B

GENERAL FABRICATION TOLERANCES – LAMINATED BLOCKS

Zotefoams products that are sold as blocks thicker than the standard dimensions of the sheet require fabrication via lamination processes.

Due to the heated blade and roller system used to laminate sheets to the required thickness deviations in the alignment of the sheets and overall achieved thickness are expected. The tolerances offered for these block products are provided in the tables below:

Table 1 - Fabrication Tolerances – Lamination thickness of Skin/Skin; Skin/Cell; & Cell/Cell Products

Skin/Skin (S/S) and Skin/Cell (S/C)							
Nominal Thickness (mm)	LD18 & LD29		HD & SD Grades			All Other Grades	
	Min (mm)	Max (mm)	Nominal Thickness (mm)	Min (mm)	Max (mm)	Min (mm)	Max (mm)
50	- 1	+ 4	< 50	- 1	+ 8	- 2	None
70	- 1	+ 4.5	< 70	- 1	+ 8	- 3	None
100	- 2	+ 9	< 100	- 2	+ 10	- 3	None
140	- 2	+ 10	< 140	- 3	+ 12	- 4	None
170	- 2	+ 10	< 170	- 3	+ 12	- 5	None
200	- 5	+ 10	< 200	- 5	+ 12	- 10	None

Cell/Cell (C/C)							
Nominal Thickness (mm)	LD18 & LD29		HD & SD Grades			All Other Grades	
	Min (mm)	Max (mm)	Nominal Thickness (mm)	Min (mm)	Max (mm)	Min (mm)	Max (mm)
50	- 1	+ 3.5	< 50	- 1	+ 5	- 4	None
70	- 2	+ 3.5	< 70	- 1	+ 5	- 5.5	None
100	- 3	+ 5.5	< 100	- 2	+ 6	- 5.5	None
140	- 4	+ 6	< 140	- 3	+ 7	- 6.5	None
170	- 5	+ 6	< 170	- 3	+ 8	- 8	None
200	- 5	+ 10	< 200	- 5	+ 10	- 10	None

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Table 2 - Fabrication Tolerances – Length and Width

Block Finish	LD18, LD29, HD, & SD Grades	All Other Grades	
	Length & Width Tolerance (minimum)	Nominal thickness (mm)	Trimmed Length & Width Tolerance (minimum)
Trimmed	Nominal – 0mm	0 mm < t < 100 mm	nominal – 50 mm
		101 mm < t < 200 mm	nominal – 100 mm
		201 mm < t < 300 mm	nominal – 150 mm
Untrimmed	Nominal – 0mm	All thicknesses up to 300 mm	nominal – 150 mm

Note: Customer should specify Trimmed or Untrimmed, skin/skin, cell/cell or skin/cell when ordering, e.g. Trimmed s/s, Untrimmed s/c, along with length, width and nominal thickness requirements. For sizes and tolerances outside those specified please consult the Zotefoams Sales Team.

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