

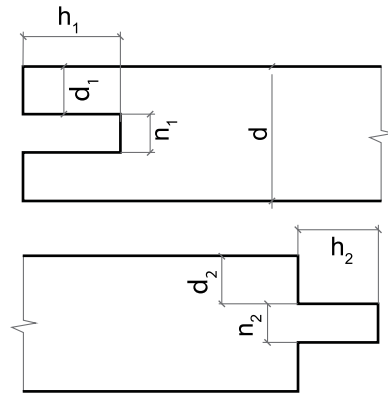
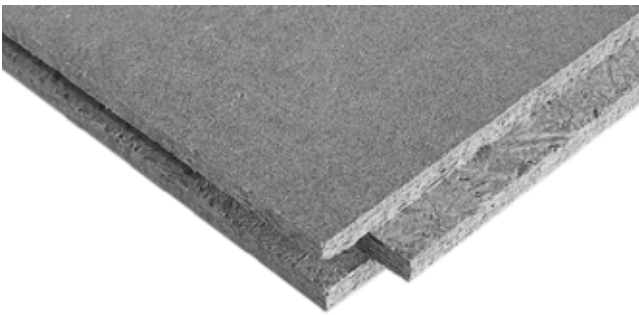
BZSPlus+TG cement-bonded particleboards

BZSPlus+TG cement-bonded particleboards are made by milling the edges of BZSPlus and BZSPlus+ boards. CELASCHI tenoning machines are used for milling of cement-bonded particleboard edges and cutting tongue and groove joints. This joint is a traditional fitting method where a projecting ridge (tongue) of one element fits into the slot (groove) of the corresponding shape of the other element.

Main requirements for milling:

- ◆ The required thickness of cement-bonded particleboards for milling is 16 to 24 mm.
- ◆ There is no minimum length requirement for milling of two edges of cement-bonded particleboards.
- ◆ If four sides of cement-bonded particleboard are milled, the maximum board length is 3050 mm, and the minimum board size is 600 x 600 mm.

Diagram and dimensions of tongue and groove. Tolerances for different board thicknesses (mm):



Board thickness (d)	16	18	20	22	24	Tolerance
Groove width (n_1)	6	6	8	8	8	0 / +0.5
Tongue thickness (n_2)	5.5	5.5	7	7	7	-0.5 / 0
Groove depth (h_1)	10	10	10	10	10	0 / +2
Tongue length (h_2)	8.5	8.5	8.5	8.5	8.5	-2 / 0
Distance from board surface to the groove (d_1)	5	6	6	7	8	± 0.5
Distance from board surface to the tongue (d_2)	5.25	6.25	6.5	7.5	8.5	± 0.5

The company manufactures 1200 x 600 mm boards with four machined edges for floor construction and repairs.