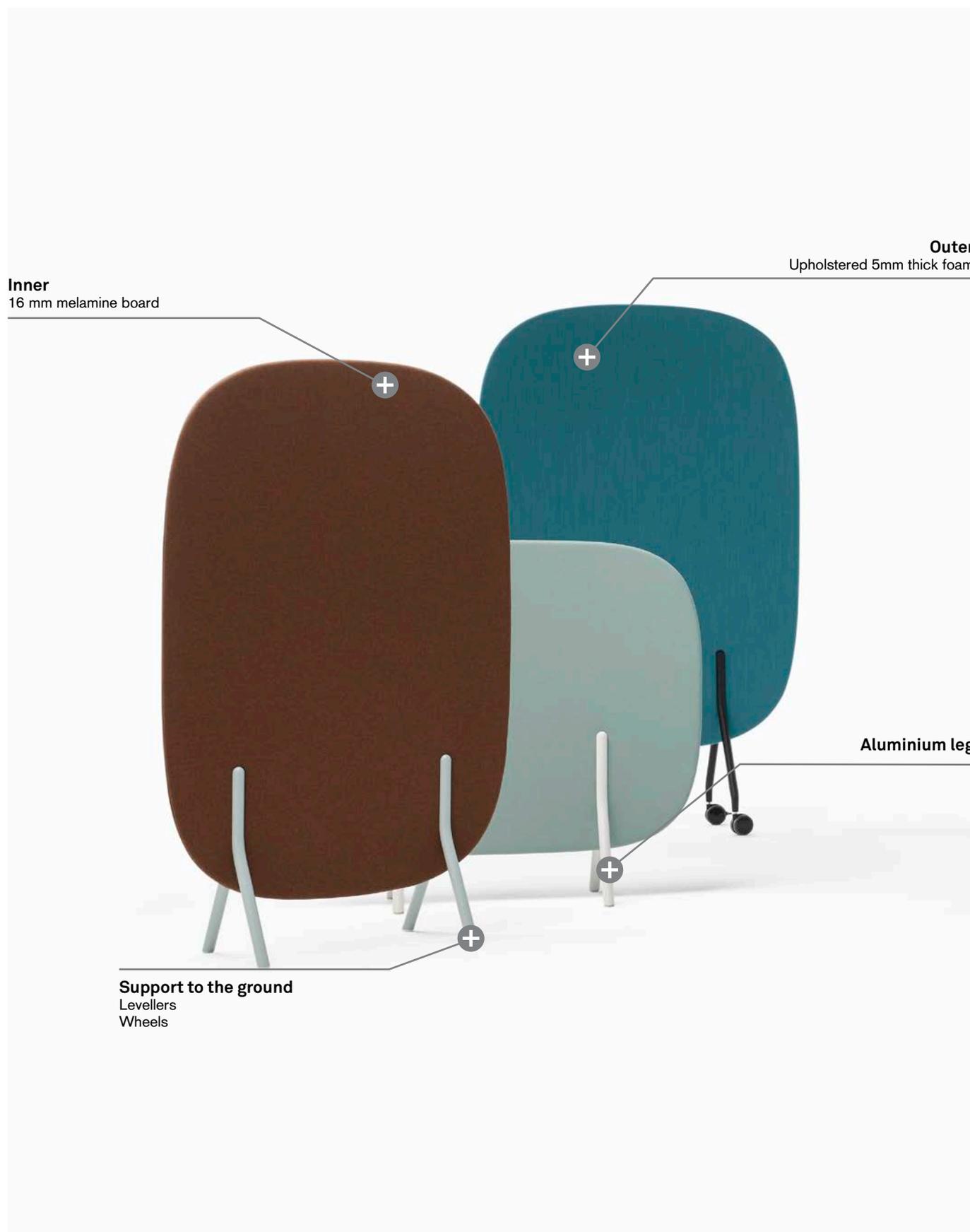


Forma 5

TECHNICAL FEATURES

**NORAY**





## JOINING SYSTEM



**Panel joining system**  
Knob, cap and connector

## ELEMENT DESCRIPTION

### PANELS

16 mm thick melamine board with 2 mm PVC thermofused edge. Board machined perimeter on the edge to allow upholstering the panel. Holes for mounting support legs, connectors and accessories.

Textile cover made of 5 mm thick foam with a density of 60 kg / m<sup>3</sup> and fabric. PP plastic profile sewn in the lower part to make the upholstery on the melamine support.

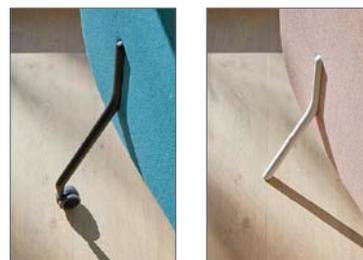
PP bushings placed on the panel to facilitate the assembly of the legs and the connector system.



### LEGS

The support of the panels is made by aluminum legs with levellers or wheels. AL43400 injection mold aluminum parts painted with a smooth matte finish. Translucent PP floor levellers or 75mm diameter wheels with and without brake.

Legs are assembled by screws on the threaded.



Pies de aluminio con ruedas

Pies de aluminio con conteras

### PANEL JOINING SYSTEM

The panel joining system is made of plastic pieces mounted on the panel allowing angular adjustment in the different joints or even the joining of 3 panels. The system is made of different parts: knob (PP), cap (PP) and elastic bands

The system is mounted by screws.



### ACCESORIES

1.5mm thick sheet metal blackboard fixed to the panel using M5x15mm welded threaded bolts. Special paint for dry cleaning whiteboard markers. 2mm thick sheet steel pencil holder.

Lower shelf in 23mm thick MDF board with lacquered chamfered edge.



### UPHOLSTERY

Backrest and seat available for all the fabrics range of Forma 5, including a wide range of fabrics (yarn, fireproof fabrics) and leathers Consult fabrics brochure and Forma 5 Pricelist.

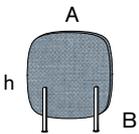
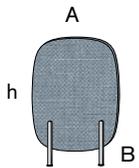
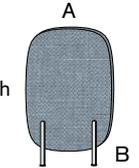
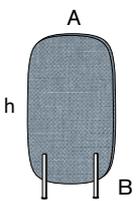
The Group 1, 2, 3 and 5 fabrics of Forma 5 are supplied by the manufacturer company Camira. Although our fabrics brochure includes a selection of the Camira fabrics, if the customer requires another specific, Forma 5 will upholster any of its fabrics in any fabric from Camira catalog.

### SOUND ABSORBENCY

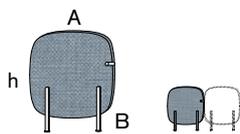
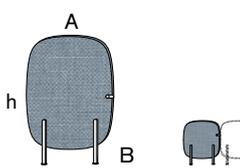
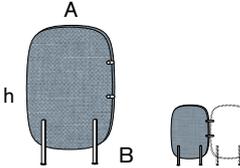
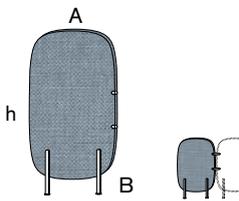
Noray provides optimal sound absorbtion, thanks to its construction. Its panels are made up from a 16 mm particle board and then covered with 5 mm of high-density foam and upholstered on both sides. The absence of metallic interiors or profiles of other materials helps to absorb sound and provide an acoustic improvement in the space.

# CONFIGURATIONS AND DIMENSIONS

## SINGLE FIXED PANEL WITHOUT CONNECTORS

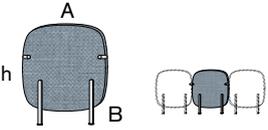
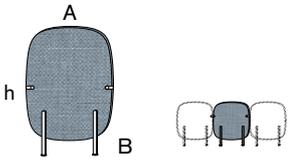
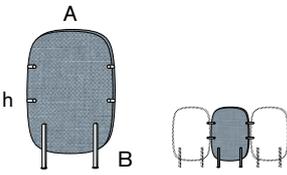
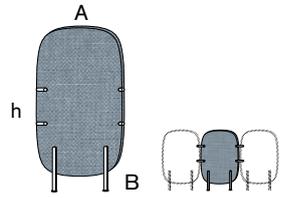
			
<p>LOW PANEL, h 110</p> <p>A x B x h</p> <p>65 x 2,5 x h:110 80 x 2,5 x h:110 100 x 2,5 x h:110 120 x 2,5 x h:110 135 x 2,5 x h:110</p>	<p>INTERMEDIATE PANEL, h 140</p> <p>A x B x h</p> <p>65 x 2,5 x h:140 80 x 2,5 x h:140 100 x 2,5 x h:140 120 x 2,5 x h:140 135 x 2,5 x h:140</p>	<p>MEDIUM PANEL, h 160</p> <p>A x B x h</p> <p>65 x 2,5 x h:160 80 x 2,5 x h:160 100 x 2,5 x h:160 120 x 2,5 x h:160 135 x 2,5 x h:160</p>	<p>HIGH PANEL, h 180</p> <p>A x B x h</p> <p>65 x 2,5 x h:180 80 x 2,5 x h:180 100 x 2,5 x h:180 120 x 2,5 x h:180 135 x 2,5 x h:180</p>

## FIXED INITIAL / FINAL PANEL WITH CONNECTORS

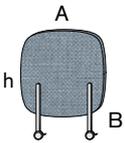
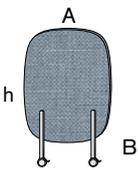
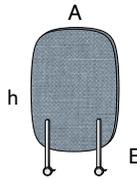
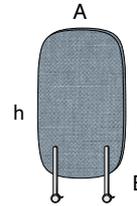
			
<p>LOW PANEL, h 110</p> <p>A x B x h</p> <p>65 x 2,5 x h:110 80 x 2,5 x h:110 100 x 2,5 x h:110 120 x 2,5 x h:110 135 x 2,5 x h:110</p>	<p>INTERMEDIATE PANEL, h 140</p> <p>A x B x h</p> <p>65 x 2,5 x h:140 80 x 2,5 x h:140 100 x 2,5 x h:140 120 x 2,5 x h:140 135 x 2,5 x h:140</p>	<p>MEDIUM PANEL, h 160</p> <p>A x B x h</p> <p>65 x 2,5 x h:160 80 x 2,5 x h:160 100 x 2,5 x h:160 120 x 2,5 x h:160 135 x 2,5 x h:160</p>	<p>HIGH PANEL, h 180</p> <p>A x B x h</p> <p>65 x 2,5 x h:180 80 x 2,5 x h:180 100 x 2,5 x h:180 120 x 2,5 x h:180 135 x 2,5 x h:180</p>

# CONFIGURATIONS AND DIMENSIONS

## ADD-ON PANEL WITH CONNECTORS

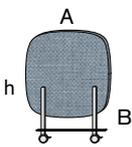
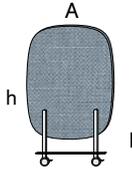
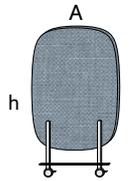
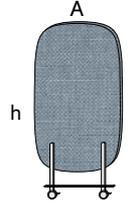
			
<p>LOW PANEL, h 110</p>	<p>INTERMEDIATE PANEL, h 140</p>	<p>MEDIUM PANEL, h 160</p>	<p>HIGH PANEL, h 180</p>
<p>A x B x h</p>			
<p>65 x 2,5 x h:110 80 x 2,5 x h:110 100 x 2,5 x h:110 120 x 2,5 x h:110 135 x 2,5 x h:110</p>	<p>65 x 2,5 x h:140 80 x 2,5 x h:140 100 x 2,5 x h:140 120 x 2,5 x h:140 135 x 2,5 x h:140</p>	<p>65 x 2,5 x h:160 80 x 2,5 x h:160 100 x 2,5 x h:160 120 x 2,5 x h:160 135 x 2,5 x h:160</p>	<p>65 x 2,5 x h:180 80 x 2,5 x h:180 100 x 2,5 x h:180 120 x 2,5 x h:180 135 x 2,5 x h:180</p>

## MOBILE SINGLE PANEL WITH WHEELS AND WITHOUT CONECTORS

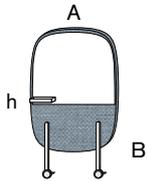
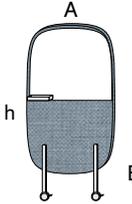
			
<p>LOW PANEL, h 126</p>	<p>INTERMEDIATE PANEL, h 156</p>	<p>MEDIUM PANEL, h 176</p>	<p>HIGH PANEL, h 196</p>
<p>A x B x h</p>			
<p>65 x 2,5 x h:126 80 x 2,5 x h:126 100 x 2,5 x h:126 120 x 2,5 x h:126 135 x 2,5 x h:126</p>	<p>65 x 2,5 x h:156 80 x 2,5 x h:156 100 x 2,5 x h:156 120 x 2,5 x h:156 135 x 2,5 x h:156</p>	<p>65 x 2,5 x h:176 80 x 2,5 x h:176 100 x 2,5 x h:176 120 x 2,5 x h:176 135 x 2,5 x h:176</p>	<p>65 x 2,5 x h:196 80 x 2,5 x h:196 100 x 2,5 x h:196 120 x 2,5 x h:196 135 x 2,5 x h:196</p>

# CONFIGURATIONS AND DIMENSIONS

## MOBILE SINGLE PANEL WITH WHEELS AND LOWER SHELF, WITHOUT CONNECTORS

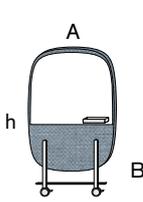
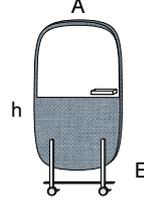
			
<p>LOW PANEL, h 126</p> <p>A x B x h</p> <p>65 x 2,5 x h:126 80 x 2,5 x h:126 100 x 2,5 x h:126 120 x 2,5 x h:126 135 x 2,5 x h:126</p>	<p>INTERMEDIATE PANEL, h 156</p> <p>A x B x h</p> <p>65 x 2,5 x h:156 80 x 2,5 x h:156 100 x 2,5 x h:156 120 x 2,5 x h:156 135 x 2,5 x h:156</p>	<p>MEDIUM PANEL, h 176</p> <p>A x B x h</p> <p>65 x 2,5 x h:176 80 x 2,5 x h:176 100 x 2,5 x h:176 120 x 2,5 x h:176 135 x 2,5 x h:176</p>	<p>HIGH PANEL, h 196</p> <p>A x B x h</p> <p>65 x 2,5 x h:196 80 x 2,5 x h:196 100 x 2,5 x h:196 120 x 2,5 x h:196 135 x 2,5 x h:196</p>

## MOBILE SINGLE PANEL WITH WHEELS, BLACKBOARD AND MARKER HOLDER, WITHOUT CONNECTORS

	
<p>MEDIUM PANEL, h 176</p> <p>A x B x h</p> <p>100 x 2,5 x h:176 120 x 2,5 x h:176 135 x 2,5 x h:176</p>	<p>HIGH PANEL, h 196</p> <p>A x B x h</p> <p>100 x 2,5 x h:196 120 x 2,5 x h:196 135 x 2,5 x h:196</p>

# CONFIGURATIONS AND DIMENSIONS

## MOBILE SINGLE PANEL WITH WHEELS, BLACKBOARD, MARKER HOLDER AND LOWER SHELF, WITHOUT CONNECTORS

	
MEDIUM PANEL, h 176	HIGH PANEL, h 196
A x B x h	A x B x h
100 x 2,5 x h:176 120 x 2,5 x h:176 135 x 2,5 x h:176	100 x 2,5 x h:196 120 x 2,5 x h:196 135 x 2,5 x h:196



Life Cycle Analysis  
**NORAY Program**



RAW MATERIALS		
Raw Material	Kg	%
Wood	15,37 Kg	74%
Aluminium	3,16 Kg	15,24%
Upholstery / Fill material	2 Kg	9,6%
Polypropylene	0,2 Kg	1%

% Recycled materials= 68%  
 % Recyclable materials= 76,8%

# Ecodesign

Results reached during the life cycle stages



## MATERIALS

**Woods**  
 Woods with 70% recycled material and certified with PEFC/FSC and E1

**Aluminium**  
 60% recycled material.

**Upholstery / Fill material**  
 Fill without HCFC and upholstered without emissions COVs. accredited by Okotext.

**Polypropylene**  
 30%-40% recycled material.

**Packings**  
 100% recyclable with inks with no solvents.



**PRODUCTION**

**Raw materials use optimization**

Board, upholstery and steel tubes cut.

**Renewable energies use**

reducing the CO2 emissions. (Photovoltaic pannels)

**Energy saving measures**

in all production process

**COV global emission reduction**

of the production processes by 70%.

**Podwer painting**

ecovery of 93% of the non deposited painting

**Glue removal from the upholstery**

The facilities have an internal sewage for liquid waste.

**Green points**

at the factory

**100% waste recycling**

at production process ans dangerous waste special treatment.



**TRANSPORT**

**Cardboard use opmitization**

of the packings

**Cardboard and packing materials use reduction**

**Flat packings and small bulks**

to optimize the space.

**Solid waste compacter**

which reduces transport and emissions.

**Light volumes and weights**

**Transport fleet renewal**

reducing by 28% the fuel consumption.

**Suppliers area reduction**

Local market power and less pollution at transport.



**USE**

**Easy maintenance and cleaning**

without solvents.

**Forma 5 guarantee**

**The highest quality**

for materials to provide a 10 year average life of the product.

**Useful life optimization**

of the product due to a standarized and modular design.

**The boards**

with no E1 particle emission.



**END LIFE**

**Easy unpacking**

for the recyclability or compound reuse.

**Piece standarization**

for the use.

**Recycled materials used for products (% recyclability):**

Wood is 100% recyclable.  
Steel is 100% recyclable.

**With no air or water pollution**

while removing waste.

**Returnable, recyclable and reusable packing**

**Product recyclability 99%**

# MAINTENANCE AND CLEANING GUIDE

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## PLASTIC PIECES

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Rub the dirty spots with a wet cloth with PH neutral soap.

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## FABRICS

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- 1 Vacuum often
- 2 Rub the dirty spot with a wet cloth with PH neutral soap.  
Test first on a hidden spot.
- 3 Dry foam for carpets can be alternatively used.

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## METAL PIECES

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- 1 Rub the dirty spots with a wet cloth with PH neutral soap.
- 2 Polished aluminium pieces can have their polish bak by covering and rubbing them with a dry cotton cloth.

Do not use abrasive products in any case.

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Developed by JORGE HERRERA STUDIO