

**Product data sheet**

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**dekoplus**

**dekolor**

**dekonova**

**dekocore**

**magic touch**

**Product Description**

The names *dekoplus* – *dekolor* / *dekonova* / *dekocore* stand for decorative high pressure laminates, as specified in EN 438-1, in solid colours, in fantasy print, as well as replicas of natural materials such as linen, wood, marble etc.

As defined in the standard, core sheets impregnated with phenolic and/or melamine synthetic resins and a surface layer are impregnated with an aminoplast resin (mainly melamine synthetic resin) and are then pressed together to a high pressure laminate. The surface layer is a plain coloured paper melamine film in the products with the name *dekolor*.

The plain coloured paper (*dekolor*) is uniformly coloured throughout. The colour range is from white to black with a large range of colours inbetween. By later ordering a colour matching is guaranteed in these colours. The papers are free from heavy metals and have a high degree light-fastness.

Hardened by a special process, the surface of Magic Touch is extremely resistant. It is scratch resistance according to EN 438/3 reaches level 2 i.e.  $\geq 3$  Newton. This surface can therefore be recommended for horizontal use (e.g. tables, desks, work-tops, etc.). Magic Touch is produced in format 305 x 122 cm and 305 x 132 cm (on request). Five standard colours are available from stock: MT01/white, MT02/beige, MT03/light grey, MT04/dark grey, MT05/black.

In *dekonova* the surface film is printed paper melamine film. The printed papers are printed using engraved printing cylinders. By later ordering a colour matching is guaranteed in these prints. The papers are free from heavy metals and have a high degree light fastness.

According to the Standard the HPL products are classified according to their specific basic properties in:

- |    |   |  |
|----|---|--|
| 1. | Standard quality                                  | = Type S (thickness less than 2.0 mm)    |
| 2. | Standard quality                                  | = Type S (thickness greater than 2.0 mm) |
| 3. | Postforming quality                               | = Type P                                 |
| 4. | Standard quality with specified behaviour by fire | = Type F                                 |

**All *dekoplus* colours can be pressed with 25 surface structures (see *dekovario* prospectus).**

**Backing sheets for *dekoplus*: RS 16 GLA 008.**

This backing sheet is a plain white melamine laminate with a smooth surface and of lower quality.

## Dimensions and Quality

All *dekoplus* sheets are delivered in the standard dimensions 2440 mm x 1220 mm. **The waffel surface structure (WAF) has an effective width of only 1200 mm and a length of 2440 mm.**

(If other measurements are required direct contact with DEKODUR® is advised)

The tolerance limits for the dimensions along and across the sheets as required in EN 438 are:

- 0 mm and +10 mm

The *dekoplus* sheets can be produced in thickness from 0.6 mm to 3.0 mm. The standard of thickness is 0.8 mm, giving a density of 1.4 kg/m<sup>2</sup>.

The limits for variations in thickness are governed by EN 438

<b>Nominal thickness</b>	<b>Maximum tolerances</b>
0.6 – 1.0 mm	± 0.10 mm
> 1.0 – 2.0 mm	± 0.15 mm
> 2.0 – 2.5 mm	± 0.18 mm
> 2.5 – 3.0 mm	± 0.20 mm

If thicker sheets of *dekoplus* are required, direct contact with **Dekodur®** is advisable.

Behaviour in case of fire – the standard quality is classified as B2 – B1 when tested according to DIN 4102. For *dekoplus* sheets in the quality “Flame retardant” a direct contact with **Dekodur®** is advised.

This quality is certified by Lloyd’s Register and fulfils the requirements of IMO FTC.

**All *dekoplus* sheets are available not only in standard grade but also in postforming quality.**

When the article number includes the Symbol: “**NF**,” the product is postformable. The sheets can be delivered with a heat-resistant protection foil, if required. The processing of *dekoplus* forming quality is influenced by a number of factors: thickness of material, colour and surface structure, temperature, rate of feeding, profile to be obtained and the radius required. The specific parameters together with properties of the material as well as that of the plant and the choice of bonding agent must all be brought into consideration.

**A general guidance: the forming temperature for the sheet is between 140° - 160°C, and the rate of feeding should lie between 10 – 20 m/min.**

**The sheets can in general be postformed to a radius of 10 times their thickness.**

**The sheets should be stored under normal climatic conditions (ca. 18° - 23°C and 50 – 65% relative humidity). Under these conditions the postforming properties remain practically unchanged for up to one year.**

## **Application and Processing**

*Dekoplus* is intended for use as decorative surfaces which are exposed to wear in interior application and also for furniture. The melamine resin surface guarantees the usage of *dekoplus* in horizontal as well as in vertical applications. The surface of the laminate is easy to clean, a completely closed surface and a construction without joints fulfils the most stringent hygienic demands. The mechanical and chemical properties (e.g. resistance to scratching, impact, heat and staining) make *dekoplus* ideal for usage in situations where the demands are high.

Typical applications are: Wall cladding, ceiling cladding, doors, staircases, windows, kitchen furniture, bathroom furniture, home furniture, hotel and restaurant furniture, laboratories, operating theaters and in hospitals.

**The *dekoplus* laminates can be sawed, routed and drilled using carbide tipped tools.**

**Glue types suitable for bonding:**

- dispersion glues (PVAc)
- condensation resin glues (Urea resin)
- contact glues
- 2 component glues
- hot melt glues

When using dispersion glues and condensation resin glues, a glue spread of ca. 100 – 150 g/m<sup>2</sup> and a pressure of 2 – 5 bar must be used. The press temperature can be chosen between 60 – 80 °C. However, the higher the press temperature the

higher the risk of warping. When using contact glues, 2 component glues, and hot melt glues the manufacturers instructions should be followed.

When manufacturing compound elements a symmetrical construction is necessary. This is obtained by bonding a backing sheet on the reverse side. This can be a sheet of the same quality in a 2<sup>nd</sup> quality or by using the backing sheet RS 16 HGL 008.

## **Cleaning and Maintenance**

Cleaning the surface of a *dekoplus* sheet is best carried out using a clean cloth, or a soft sponge or a soft brush. Washing powder or soap may be used. Paper towels can be used to dry the surface.

**Abrasive cleaners should never be used.**

## **Storage**

The *dekoplus* sheets should be stored in a closed room with a temperature of 18-25°C and 50-60% relative humidity. Furthermore, they have to be stored full-laminar and horizontally with a distance of 200 mm to the ground.

The sheets

- are to be protected from moisture
- should not be exposed to direct sunlight
- should not be stored in a warm-air-stream

Should horizontal storage not be possible a skew of 80°, with the surface being entirely supported by a fully covering back-support, is recommended.

## **Waste disposal**

*Dekoplus* waste can be **burnt** in official accepted incinerators.

*Dekoplus* waste can also be disposed of in landfills in accordance with the local regulations.

The German authorities classify high pressure laminate waste as “other hardened plastic waste material”, which means that it is similar to household waste.

**Should you have any questions, please do not hesitate to contact our service department.**

**If you need samples you can order these in the form of chains, A5 or A4 from Dekodur®.**