

# Interforest

## Compact HPL technical data sheet EN 438

property	test procedure	measure unit	Test result
specific weight	weight in kg of a dm <sup>3</sup> of laminate or of 1 m <sup>2</sup> in thickness 1mm	kg/dm <sup>3</sup>	1,4
thickness tolerance	measures the difference between the nominal thickness and the actual laminate thickness	mm	2.0 ≤ t ≤ 3.0 mm : ± 0.2 mm 3.0 ≤ t ≤ 5.0 mm : ± 0.3 mm 5.0 ≤ t ≤ 8.0 mm : ± 0.4 mm 8.0 ≤ t ≤ 12.0 mm : ± 0.5 mm 12.0 ≤ t ≤ 16.0 mm : ± 0.6 mm 16.0 ≤ t ≤ 20.0 mm : ± 0.7 mm 20.0 ≤ t ≤ 25.0 mm : ± 0.8 mm 25.0 mm ≤ t: According To Agreement customer / producer
surface wear resistance	the taber test measures the number of cycles necessary to abrade the laminate surface with sand paper. IP is initial point, when colour begins disappearing FP is final point, when colour has disappeared at 95%. IP+FP divided 2 is the AP average point.	Taber cycles IP starting point AP medium point	≥ 150 ≥ 350
resistance to immersion in boiling water	measures the mass and thickness increase of a laminate after a two hour immersion in boiling water	% mass % thickness % mass %thickness appearance gloss appearance non-gloss	2.0 ≤ t ≤ 5.0 mm Max. 5% 2.0 ≤ t ≤ 5.0 mm Max. 6% t ≥ 5.0 mm Max. 2% t ≥ 5.0 mm Max. 2% 4 5
resistance to water vapour	measures the appearance of a laminate exposed to water vapour for 1 hour	appearance gloss appearance non-gloss	4 5
resistance to dry heat at 160° C	measures the aesthetic properties of a laminate bonded onto an 18 - 20 mm chipboard upon which a metal block at the initial temperature of 160° C is placed and left to cool for 20 minutes.	appearance gloss appearance non-gloss	3 4
dimensional stability at high temperature	measures the changing in length and width after 24 hours at 70°C and 96 hours at 40°C and 90 - 95 % relative humidity	max mm longitudinal max mm transversal max mm longitudinal max mm transversal	2.0 ≤ t ≤ 5.0 mm 0,4 mm 2.0 ≤ t ≤ 5.0 mm 0,8 mm t > 5.0 mm 0,3 mm t > 5.0 mm 0,6 mm
resistance to impact by big ball	measures the maximum damage caused by a steel ball dropped from a set height	mm mm	2.0 ≤ t ≤ 6.0 mm, 1400 mm height, max 10 mm t > 6.0 mm, 1800 mm height, max 10 mm
resistance to scratching	measures the minimum strength necessary to a diamond point to scratch the laminate surface	rating	3
resistance to cigarette burns	measures the resistance of a laminate bonded to a particle board to a burning cigarette	appearance	4
stains and dirt	measures the maximum area of stains and dirt admitted per sqm of laminate. Such an area can be concentrated in a single point or subdivided in numerous number of small faults.	min. level Group 1 + 2 min. level Group 3	5 4
flatness tolerance	measures the maximum curvature of a Compact laminate layed flat with the concave side up	max mm / linear meter max mm / linear meter max mm / linear meter	2.0 ≤ t < 6.0 mm 8mm 6.0 ≤ t < 10.0 mm 5 mm t ≥ 10.0 mm 3mm