

## Technical data sheet

### Alfa Wood HPL (High Pressed Laminate)

HPL laminates are produced in sheets and made of a decorative paper, impregnated with melamine resin. They have plastic properties and it is supported by kraft paper, impregnated with special thermosetting resins.

HPL laminates are available in the following types (specifications in accordance with Standard EN 438-1):  
 VGS (Vertical General purpose Standard) recommended for vertical use.  
 VGP (Vertical General purpose Postforming) recommended for vertical use.  
 HGS (Horizontal General purpose Standard) recommended for horizontal use.  
 HGP (Horizontal General purpose Postforming) recommended for horizontal use.

### MATERIALS TECHNICAL CHARACTERISTICS

Properties	Test Method	Attributes	Unit	Value
Surface quality	EN 438/2	Stains, dirt, other imperfections	mm/m	≤1
		Fibers, abrasions	mm/m	≤10
Dimensional tolerances	EN 438/2	Thickness tolerance	mm	0,5 ≤ t ≤ 1 ± 0,10
		Length / Width tolerances	mm	1,5 ≤ t ≤ 2 ± 0,15
		Tolerance of edge straightness	mm/m	+10/-0
		Tolerance of squareness	mm/m	≤1,5
		Flatness	mm/m	≤1,5
Resistance to surface wear	EN 438/2	Initial point	Revolutions	150
		Wear size	Revolutions	350
Resistance to immersion in boiling water	EN 438/2	Glossy surface	Minimum classification	3
		Back surface	Minimum classification	4
Resistance to steam	EN 438/2	Glossy surface	Minimum classification	3
		Back surface	Minimum classification	4

Resistance to dry heat (180° C)	EN 438/2	Glossy surface	Minimum classification	3
		Back surface	Minimum classification	4
Resistance to wet heat (100° C)	EN 438/2	Glossy surface	Minimum classification	3
		Back surface	Minimum classification	4
Dimensional stability at elevated temperatures	EN 438/2	Cumulative dimension change	Longitudinal %	≤0,55
		Cumulative dimension change	Transversal %	≤1,05
Impact resistance with a small diameter ball	EN 438/2	Rotational force	N	≥20
Impact resistance with a large diameter ball	EN 438/2	Drop height	mm	≥800
Resistance to fracture under stress	EN 438/2	Diameter of created cavity	mm	≤10
Resistance to abrasions	EN 438/2	Appearance	Minimum classification	4
Resistance to staining	EN 438/2	Group 1 & 2	Minimum classification	3
		Group 3	Minimum classification	5
Resistance to cigar burn	EN 438/2	Appearance	Minimum classification	4
		Time to blistering	Minimum classification	3
Resistance to blistering	EN 438/2		L (parallel to the direction of the fibers)	≥10
			T (perpendicular to the direction of the fibers)	≥15
Lightfastness (Xenon arc lamp)	EN 438/2	Contrast	Grayscale rating	4 to 5
Formability	EN 438/2	Radius	Seconds for nominal dimension <0.8mm	≤10 x nominal thickness
		Radius	Seconds for nominal dimension ≥0.8mm	≤20 x nominal thickness
Density			g/cm <sup>3</sup>	≥1,35

## CARE AND CLEANING RECOMMENDATION

Due to its resistant, hygienic and dense surface, Alfa Wood laminates does not require any special form of care. The surface is generally easy to clean. Do not use sanitary cleaners or detergents with abrasive components; as such cleaners may lead to changes in the gloss level and/or scratching of the material.

Provisional note:

This technical data sheet has been carefully drawn up to the best of our knowledge. We accept no liability for any mistakes, errors in standards or printing errors. In addition, technical modifications can result from the continuous further development, as well as

## INSPIRING MATERIALS

from changes in standards and documents originating from statutory bodies. The contents of this technical leaflet should therefore not be considered as instructions for use or as legally binding.