

Standard Laminate

Technical Bulletin



Product Description

Composition

The Standard Laminate HPL or Liner is manufactured by impregnating decorative paper with melamine resin that confer excellent surface properties and kraft paper with phenolic resin which constitute the core of the laminate. This set is subjected to a specific pressure of 90kg/cm² and a temperature of 135°C (275°F). Once the Standard or Liner laminate is pressed, it is cut in nominal dimensions and sanded on its backrest to provide greater adhesion when applied with adhesive on the wood substrate.

Recommended Uses

The Standard Laminate or Liner of Lamitech S.A.S., is high performance compared to conventional laminates for this application. Standard Laminate or Liner offers high impact resistance, good wear resistance and is easy to maintain. It is mainly used for institutional furniture on work surfaces, in restaurants, cafeterias and in general in elements where rounded edges are not required.

Product identification							
LAMINATE TYPE	LAMITECH GRADE	NOMINAL THICKNESS	SIZES			FINISHES	
		mm. Inch)	4 x 8 pies /+AZ122:BB126 ft (1.22 x 2.44m)	4 x 10 / ft (1.22 x 3.06m)	5 x 12 ft (1.53 x 3.66m)	GLOSS	MATTE
Vertical General Length (VGL)	10	0.5 -0.02	Yes	Yes	Yes	Yes	Yes

BT12 / 02 a 13 / REV 01

* Other finishes and sizes are available. Please contact our current business representative.

Chart Weight/m ²	
Thickness (mm)	kg/m ²
0.5	0.7

Basic Limitations

The Standard Laminate or Liner is a surface for interior use, it is not a structural material, it does not admit extreme humidity or temperatures above 135°C, nor should it be exposed to continuous and direct sunlight. The Standard Laminate or Liner is used to cover straight horizontal or vertical surfaces (not postformable). Check the approved line references in Standard or Liner quality in the current product mosaics. Any additional guidance please consult our commercial representative.

Useful Information

1. The Standard Laminate or Liner should be conditioned and stored in a dry and ventilated place, never in the open, It should be stowed horizontally and stored as much as possible at room temperature below 30°C and relative humidity less than 60%.

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2. In the selection of the adhesive to be used there are several alternatives, the most common is solvent-neoprene based contact cement, which is recommended for manual applications where the pressure exerted is low. When it comes to industrial applications, we recommend PVA (polyvinyl acetate) adhesives, which are not reactivable with heat and have high resistance to moisture. For a good adhesion of the Standard or Liner laminate, we recommend using between 80 and 140gr/m² of PVA adhesive and exerting a pressure of 2 to 3 kg/cm². At the end of the application, if adhesive residue remains on the laminate, clean the surface with a soft cloth dampened with organic solvent varsol or with a 50:50 mixture of alcohol-organic solvent. It should be rinsed with warm water by completely removing the solvent.

3. To prevent the veneered surface with Standard Laminate or Liner from buckling or deforming, we suggest applying the backer or balance laminate on the back of the veneer, in order to obtain the optimum balance in the moisture absorbed by the wood layer. It is recommended that the Standard Laminate or Liner and its backer be the same thickness.

4. The cutting of the Standard Laminate or Liner should be done with disc saws with speeds between 8-12m/min. and 3000 to 5500r.p.m., with flat trapezoidal alternating geometry. For routing work you must use cylindrical drills of 12000rpm, minimum.

5. To drill the Standard Laminate or Liner, use 10000rpm drills. With tungsten carbide drill bits with a biangular tip, the selected drill bit should be 0.002 inches (0.05mm.) larger than the diameter of the hole to be made.

Maintaining And Cleaning Instructions

Daily Maintaining

As many other design materials Standard Laminate or Liner should be cleaned regularly.

Clean out only by using a wet soft cloth, with mild temperature water and, if necessary, use soft detergent. Almost all common non-abrasive household cleaning and disinfection products can be used.

For common blemishes, simply clean the surface with mild temperature water by using a non-abrasive cloth, harder stains can be eliminated aided with non-abrasives domestic solvents and cleaners.

When old stains, dry and accumulate, use a magic sponge or soft cloth to take them out. After using any solvent it is mandatory to rinse the surface with warm water and a mild detergent and repeat the rinse with water.

Useful Cleaning Tips

To obtain the best results when clean Standard Laminate or Liner, it is very important to remind the following tips:

A Standard Laminate or Liner should NEVER be cleaned with products containing abrasives, metal sponges, sanding paper or Steel wool. Avoid strong acid or alkaline substances because the surface can be irreversibly stained.

Chlorinated substances can degrade and discolor the surface. Sodium hypochlorite must be used at concentrations under 5% allowing continuous contact not more than 5 minutes and, after cleaning, surfaces must be rinsed by using enough mild temperature water and soft clothes.

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Hydrogen peroxide must be used at concentrations under 3% allowing continuous contact not more than 10 minutes and, after cleaning, surfaces must be rinsed by using enough mild temperature water and soft clothes.

When solvents are used, cloth should be very clean to avoid residual marks on the Standard Laminate or Liner surface. It is recommended to wash out and rinse with mild temperature water.

Do not use furniture restoration products or wax-based cleaning products because they tend to leave residual grease on the surface that traps dirty particles. Do not use metallic scrapers, metallic brushes or any other metallic tool to remove residuals from Standard Laminate or Liner surfaces, like gypsum or dry paint because surface can irreversibly damage.

At the beginning, use a dry cloth or paper towel, then use water between 35-40°C (95-105°F) with domestic soft soap or detergent, allowing to act until dirt starts to soften.

If dirty and blemishes remain, use a solvent like white spirit and, then use water between 35-40°C (95-105°F) with domestic soft soap or detergent, permitting to act until dirt starts to soften.

If dirty and blemishes remain, clean the surface with a soft cloth or use a 50:50 mixture of alcohol and organic solvent, so as not to affect its original tone and design. The resistance to staining is high however we DO NOT recommend its use on lab type work surfaces where they use oxidizing chemicals, alkalis and strong acids in their daily work.

Maintenance Instructions With Melamine Magic Sponge

Standard Laminate or Liner by having an outer layer of closed porosity allows it to be kept clean with daily care in case of persistent stains the use of a specific cleaning product is recommended to remove any trace of stain. In case of micro scratches, follow the following surface maintenance instructions. After cleaning or after using the magic sponge, rinse thoroughly with clean water, preferably warm, to remove any detergent, solvent or any other residual cleaning agent.



Cleaning And Disinfection Instructions

For routine cleaning of both thin and Standard Laminate or Liner high pressure decorative laminate (HPL), it is recommended to use water, mild non-abrasive soaps and a soft cloth such as microfiber. Do not use the abrasive side of the sponge, it is normally green.

For cleaning difficult stains such as: Tea, coffee, pencil, chalk, grease stains, dust or soap residue, use household cleaning agents such as grease remover soaps, Binner cleaner for dust and shine, odorless varnish, window cleaner, liquid soaps, or 0.1% strength sodium hypochlorite solution. It is important that the cleaning is done for a maximum of 5 minutes and then thoroughly clean the surface with water and a clean cloth.

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Our full range of HPL contains silver phosphate glass antimicrobial technology (Antimicrobial Plus) and is resistant to highly effective common disinfectants for the removal of SARS-CoV-2, the cause of Human Coronavirus disease, meeting the criteria of the EPA (United States Environmental Protection Agency (2*)). For disinfection work, use disinfecting agents such as:

- Sodium hypochlorite, brands such as Clorox Bleach, which comes in concentration between 4.5% and 5.5%. This product should mix one part of hypochlorite with 10 parts of water. Disinfection is obtained with 0.5% sodium hypochlorite in water.
- Ethyl alcohol (70% Ethanol), to disinfect the laminate surface use this solution and a clean cloth.
- Quaternary ammonium at 0.1% concentration, it is recommended to use products such as Durobacter TC - 31 which comes with a concentration of 10% of active component, for this mix one part of the product with 99 parts of water and clean with a cloth soft.
- Hydrogen peroxide, this product contains hydrogen peroxide in a concentration of less than 3%, the solution is applied to the laminate surface with a clean cloth.

After 5 minutes of carrying out the disinfection process, the cleaning process should proceed, long exposure times of sodium hypochlorite, hydrogen peroxide, quaternary ammonium and other disinfection products can generate deterioration in the high pressure laminate.

(2*) <https://www.epa.gov/pesticide-registration/list-n-disinfectants-use-against-sars-cov-2>

Cleaning And Disinfection Chart

Product name	Active ingredient	Purpose	Recommended concentration (%)	Max contact	Formulation type	Should it be cleaned after each use?
Clorox Bleach	Sodium hypochlorite	Routine cleaning	<0,1	N.A.	Dilute 1 part bleach in 50 parts water	No
Clorox Bleach	Sodium hypochlorite	Difficult stains cleaning	0,1	3	Dilute 1 part bleach in 50 parts water	Yes
Clorox Bleach	Sodium hypochlorite	Disinfection	0,5	5	Dilute 1 part bleach in 50 parts water	Yes
Ethyl alcohol	Ethanol	Disinfection	70	5	Use 70% commercial formulation	No
Peroxide	Hydrogen peroxide	Disinfection	<3	5	Use 3% commercial formulation	Yes
Durobacter TC-31	Quaternary ammonium	Disinfection	0,1	5	Dilute one part of the product in 99 parts of water	Yes

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Instructions For Removing Difficult Stains

Acetone or nail remover, alcohol, gasoline, turpentine, White spirit, trichloroethylene, perchloroethylene and trichloroethane are suitable to remove neoprene residues.

3M Graffiti Remover, paint diluent or Hauser Vandal are some commercial substances that can be used. Remember to always rinse by using enough water.

Note: Product Brand names are only suggestions and its effectivity is not guaranteed.

It is the responsibility of the distributor / installer to verify the updated technical documents updated on the respective website. Visit us at www.surfacematerials.com for more information.

VERSION JUN2022 This document supersedes all printed and electronic technical and installation guides previously distributed by LAMITECH.

TECHNICAL DATA SHEET

Test	Standard	Field	Unit	Lamitech
Density	ISO 1183	Mass	g/cm ²	≥ 1.35
Length and width	EN 438 2-6	Size	mm	+5/-0
Straightness of edges	EN 438 2-7	Plate	mm/m	≤ 1.5
	EN 438 2-8	Size	mm/m	≤ 1.5
Squareness	Lamitech	1220 x 2440 mm	mm	≤ 4.0
		1220 x 3060 mm		≤ 5.0
		1530 x 3660 mm		≤ 6.0
		1530 x 2440 mm		≤ 4.5
Resistance to surface wear	EN 438 2-10	Initial point	Cycles	50
Scratch resistance	EN 438 2-25	Force	Newtons (min)	1N
Surface quality	EN 438 2-4	Stains, dirt, similar defects on the surface	mm ² /m ²	≤ 1
		Fibers, hairs and stripes	mm/m ²	≤ 10
Thickness	EN 438 2-5	Size	mm	0.5 ± 0.10
Resistance to immersion in boiling water	EN 438 2- 12	Bright finished appearance	Grade	≥3
		Appearance other finishes	Grade	≥4
		Appearance of edges	Grade	≥3
High temperature dimensional stability	EN 438 2-17	Longitudinal	% e <2.0mm	≤0.50
		Transversal	% e <2.0mm	≤0.80
Resistance to impact by small diameter ball	EN 438 2-20	Spring force	Newton (min)	20
Resistance to light (Xenon arch lamp)	EN 438 2-27	Contrast (Grayscale)	Grade	≥4
Resistance to stains	EN 438 2-26	Appearance group 1-2	Grade	5
		Appearance group 3		≥4

* The total allowable length of contamination may be concentrated in one defect, or dispersed in an unlimited number of smaller defects.