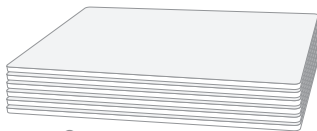
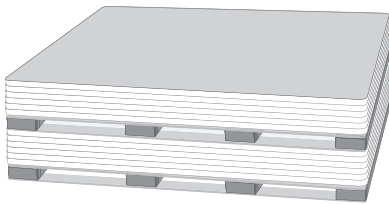
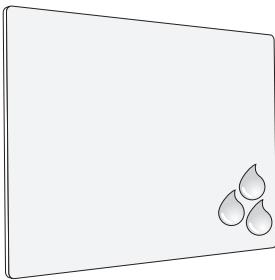




HPL White Core Monochrom B&W

High pressure laminate made from melamine impregnated white kraft paper and a melamine impregnated decorative surface.



Applications

Designed for all interior applications both horizontal and vertical (for high or moderate wear depending on the surface texture). Ideal for furniture, offering a homogenous finish with no visible edge.

- Worktops, vanity units, office furniture
- Carcassing, doors

Stocking conditions

• Transport and stock

- Transport the sheet on pallets of sufficient size and rigidity in order to protect the edges and corners from damages.
- Panels must be stored on a flat bed within a rack on a pallet with regular support.
- Stock away from direct heat sources and excessive humidity.
- Stock within a controlled environment, closed to the elements:
 - Between 15 °C and 25 °C
 - 55 / 65 % relative humidity
- **DO NOT ROLL**, must be stored flat.

• Conditioning

- Prior to fabrication, product must be conditioned for a period of 10 days in the following ambient conditions:

- Temperature 15 to 20°C.
- Relative humidity 50 to 65 %.

- Keep away from direct heat.

Please respect the stocking and utilisation of the product. Do not stock or use in an overly dry and hot environment.

Fabrication Guidelines

Fabrication of sheet

• Cutting

The resin used in the manufacture of the white monochrom reduces its flexibility in comparison to other Polyrey HPL. As a result, extra care is required to avoid chipping, cracking and crazing:

- Tools should be perfectly sharp.
- Diamond-tipped blades, or tungsten carbide with small teeth should be used.
- Sheets can be cut either individually or in batches. Sheets should be positioned on a base board for support and blade speed should be adapted accordingly.
- To avoid stress cracking, internal corners and notched incisions should be rounded with a minimum radius of 6mm.

• Bonding

- An aesthetic appearance is governed by the choice of glue. A translucent glue will maintain colour uniformity.

- Pre-mixed glues. PVA types.

- Gluing type:

• *Cold bonding:*

Single or multi-daylight presses. The HPL will not be subjected to any drying out.

• *Hot bonding:*

Avoid a temperature in excess of 60 °C and a press time of a 120 seconds to minimise the risk of cracking due to tension in the sheet caused by drying out.

- Press time and temperature:

20 °C × 8 - 60 min

40 °C × 4 - 12 min

60 °C × 45 - 120 s

- Maximum pressure: 2 Bars

Laying up of white Monochrom must be done using chipboard or MDF core boards entirely flat and free from dust. Do not bond to metal substrates.

• Balancing

To guarantee flatness and avoid potential bowing, it is imperative that panels less than 25mm thick are balanced with the same product at the same time.

In cases where a slight bowing is acceptable (subject to the tolerances laid out in EN438-9) or if the panels are mechanically fixed to a sub-frame, it is possible to use a Monochrom balancer.

• Cold Bending

A width of 60mm can be cold bent to a radius of 150mm. As the width increases so will the radius.

Fabrication Guidelines

• Cutting

A minimum radius of 6mm must be adhered to.

Square angles are not allowed, even non-visible ones, to minimise the risk of cracking. All cut and fabricated edges must be smoothed off. Any large chip in the product could lead to stress-cracking in a dry atmosphere.

Tools:

- Circular saw
- Jigsaw
- Router
- Drill
- CNC Router

• Care and Maintenance (AFNOR T54325)

Any light dirt is easily removed using a damp cloth and warm soapy water, or other non-abrasive or alkaline cleaning products. More stubborn strains can be removed with an appropriate organic solvent: alcohol, acetone, etc.

Do not use polish or any polish derivative. Vinyl based glue can be removed using hot water. Neoprene glue can be removed with the appropriate dissolving agent.