

# SWISS KRONO HPL FLEX

## 1. Product description

SWISS KRONO HPL FLEX is a thin decorative material with very good properties for postforming and covering elements such as door frames, door fronts, mouldings, etc. HPL FLEX is made of layers of paper impregnated with thermosetting resins, combined at high temperature and pressure.

HPL FLEX comes in a wide variety of wood-like, whimsical, unicolour and stone colours, available in the collections of all SWISS KRONO POLSKA furniture products.

## 2. Use

Material type: P (Postforming) based on the EN 438-3 standard.

SWISS KRONO HPL FLEX laminate is used as a decorative material for finishing door elements (e.g. door frames), and other elements (e.g. mouldings and finishing profiles) that require high postforming and covering properties.



**Figure 1. Door frame**

## 3. Technical data

### 3.a. Build up

The covering/exterior layer is the decorative part, inspired by wood, unicolour or whimsical patterns. It is a printed paper, impregnated with melamine resin. The core, which is the underside, consists of the backing paper.

### 3.b. Parameters

Based on the EN 438-3 standard, SWISS KRONO HPL FLEX can be classified as type P (Postforming) laminate.

**Tab. 1. Technical and performance properties of laminates SWISS KRONO HPL FLEX.**

Property	Unit of measurement	Requirement	Test method
Thickness tolerance	mm	0,2 mm $\pm$ 0,05	EN 438-2.5
Length tolerance	mm	+10 / -0	EN 438-2.6
Width tolerance	mm	+10 / -0	EN 438-2.6
Scratch resistance	N	$\geq 2$	EN 438-2.25
Abrasion resistance	rotation	IP $\geq 15$ , IP + FP/2 $\geq 60$	EN 438-2.10
Resistance to wet heat (100°C)	degree	$\geq 3$	EN 438-2.18
Resistance to hot pot base (160°C)	degree	$\geq 3$	EN 438-2.16
Stain resistance	degree	group 1 and 2 = 5 group 3 $\geq 4$	EN 438-2.26
Light resistance (xenon lamp)	Gray scale	$\geq 4$	EN 438-2.27
Steam resistance	degree	glossy surface $\geq 3$ other surfaces $\geq 4$	EN 438-2.14
Formability	mm L <sup>a</sup>	$\geq 3$	EN 438-2.31
Formaldehyde emissions		Class E1	EN 717 -1

## 3.c. Maintenance

SWISS KRONO HPL FLEX should be cleaned with a damp, soft cloth or sponge, with commercially available cleaning agents, such as a solution of dishwashing liquid. After washing with ordinary cleaning products, the laminate should be washed with clean water and wiped dry to obtain a smooth surface without streaks. Before using any cleaner, read the attached description to make sure it is suitable for this type of surface. Do not use cleaners that contain aggressive or corrosive substances or agents that contain abrasive or glossy additives, as they may permanently damage the surface of the laminate. Larger dirt, such as from a marker, nicotine, nail polish or shoe polish, should be removed with spirit or an organic solvent (such as acetone), and then the laminate surface should be washed with clean water and wiped dry.

## 4. Packaging, storage and transportation

### 4.a. Packaging

Packaging material:

- information label (running metres, roll identification number, material designation, format/decor/structure, customer number, roll production designation),
- polyester tape,
- pallet (narrow format 1400x1000, wide format 2100x1000mm)
- packaging film
- cover board

Maximum roll diameter mm	Core diameter mm	Width mm	Thickness mm	Minimum order quantity
400	150	1300*	0,2	400 lm
400	150	2060*	0,2	400 lm

\* possible other width in agreement with the customer

## 4.b. SWISS KRONO HPL FLEX storage in rolls

- SWISS KRONO HPL FLEX should be laid out and stored on a flat, rigid and stable surface.
- The rolls should be placed on a pallet, with a maximum of 6 pieces in pyramid form (narrow format), or in pyramid with 3 pieces (wide format).
- The whole should be fastened together with banding tape to prevent the material from moving in transit.
- In the stack, between the rolls, there should be no dirt or grit that can scratch the surface of the laminates.
- HPL IMO should be stored indoors and covered, in a place protected from moisture.
- Care should be taken to avoid damage when handling and transporting laminates.
- There should be an information label on each roll, containing, in addition to product identification data, the steering wheel mark with the number of the notified body and the year in which the mark was applied.

SWISS KRONO HPL FLEX laminates should always be stored in a closed, dry warehouse, at a temperature of not less than 18 °C and not more than 25 °C, humidity of 50-60%, for a maximum period of 6 months.

## 4.c. Transportation

Width mm	Thickness mm	Number of rolls on a pallet	Number of pallets on a truck
1300*	0,2	6	8
2060*	0,2	3	8

\* other widths possible in agreement with the customer

## 5. Waste disposal

### 5.a. Energy recovery

SWISS KRONO HPL IMO laminates can be thermally recycled. When HPL laminates burn completely at 700 °C, water, carbon dioxide and nitrogen oxides are produced. Well-controlled combustion processes are achieved in modern, officially approved industrial incinerators. Ashes from this process can be delivered to controlled waste disposal sites.

### 5.b. Landfills

Unusable residues of SWISS KRONO HPL laminates should be delivered to controlled waste disposal sites in accordance with current national and/or regional regulations.

## 6. Certificates and licenses

- Hygienic certificate - confirms class E1
- Certified for antibacterial properties