

SWISS KRONO LLC, Y.Mudroho St., 62,
80400 Kamianka-Buska, Lviv Region, Ukraine

Technical data

1 - Structure

HPL are produced in sheets or rolls. The upside of each sheet has a decorative layer – unicolour, imitating wood or stone, or a whimsical pattern.

The underneath is pre-polished and prepared for gluing or joining with a carrier board.

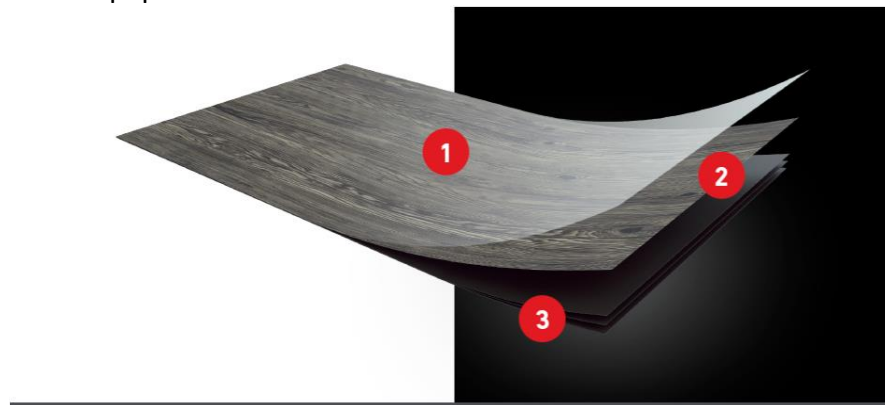
HPL contains several layers:

Each layer is made of a different kind of paper, prepared and produced in a different way.

1. Overlay protective layer - top, invisible layer, special impregnated paper containing corundum. Due to the content of corundum, HPL possesses the required resistance to wear and scratches.
2. Decorative layer – printed paper impregnated with melamine resin. The pattern may be wood-like, stone, whimsical or unicolour.
3. Core paper – paper of the highest degree of hardness, impregnated with phenol resin.

HPL (High pressure laminate)

1. Protective layer (overlay)
2. Decorative layer
3. Core paper



2 - Storing and transport

- **HPL SWISS KRONO** should be stacked and stored on a flat, firm, and stable surface.
 - Storage surface should be bigger than laminate sheet.

SWISS KRONO LLC
Y.Mudrogo St., 62, 80400 Kamianka-Buska,
Lviv Region, Ukraine
T +38 089 226 86 00

ua.sekretariat@swisskrono.com
swisskrono.com

Registered in Ukraine No. 31147999, VAT No. 311479913208
JSC «CREDIT AGRICOLE» IBAN – UA67 300614 0000026001500249700
JSC «RAIFFEISEN BANK AVAL» IBAN – UA53 380805 0000000026009528945
JSC «ALFA-BANK» IBAN – UA36 300346 0000026008015596501

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- Top, last sheet of the stack should be placed with the decorative layer on the bottom and covered with covering panel over the entire surface.
- Between sheets in the stack there should be no dirt that might scratch the laminate surface.
- Individual sheets may be rolled up, decorative side facing inwards.
- HPL should be stored in closed and roofed rooms, protected from humidity.
- Caution should be exercised during moving and transport of laminate sheets to avoid damaging them.

3 - Room conditions during HPL laminates processing

Room humidity and temperature have a crucial influence on **HPL** laminate linear dimension changes.

Optimum conditions:

Temperature: 18-22°C

Air humidity: 50-60 %.

Note: Storage and room conditions during processing have a direct influence on **HPL** SWISS KRONO laminates gluing and processing results.

4 - Processing

The top surface of **HPL** SWISS KRONO laminate is made of high-quality melamine resins, thanks to which it is relatively firm.

HPL SWISS KRONO laminate processing should be performed on a stable, flat, even surface.

Laminate should be placed with decorative side up. Do not let laminate vibrate or tremble. Sharpness and proper movement of tools are crucial.

Decorative side cracks, breaks, or bumps result from inappropriate processing or the wrong tools.

Use standard carpenter's tools for cutting, such as circular bench saws, buzz saws, and jigsaws. Remember to follow the saw manufacturer's instructions.

Good quality of the processed edge depends on:

- teeth shape

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- teeth number
- cutting speed
- feed speed

HPL laminates meet requirements of EN 438-3

HPL formats available from the warehouse:

3050 /4100 x 1300-1350 x 0,5 – 0,8 mm

Packaging:

Decorative plastic is packed in cardboard boxes, twisted into a roll

5 - Gluing HPL

Decorative **HPL** SWISS KRONO laminates may be used in a variety of ways by gluing them to carrier wood-derived materials..

When making combined elements out of **HPL** SWISS KRONO and carrier materials, it is crucial to use proper gluing systems matched to the place of use of the finished product.

Before gluing, clean both sides of the laminate and the carrier material thoroughly. All, even the smallest smudges and stains must be removed.

During gluing, follow all adhesive manufacturer recommendations on both adhesive layer application and proper stress.

The following kinds of adhesives are appropriate for wood-derived materials:

Dispersive adhesive

e.g. PVAC = white glue

Condensing adhesive

e.g. urea-formaldehyde/melamine, resorcinol, phenol resins

Contact adhesives

e.g. neoprene adhesives

Reactive adhesives

e.g. epoxy, unsaturated polyesters, polyurethane adhesives

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Hot-melt adhesives

e.g. polyurethane hot-melt adhesives

6 - Carrier materials

To create the perfect surface, laminate **HPL** Swiss Krono should be used (glued) on both sides of the carrier material.

It is recommended to use laminates of the same parameters, particularly the same thickness, on both sides.

Remember to glue opposite laminate sheets to the carrier material in the same direction.

Failure to follow above recommendations may result in material deformation.

Carrier materials

- Particle boards
- MDF
- HDF
- OSB
- Plywood
- Wooden boards

7 - Cleaning

HPL SWISS KRONO should be cleaned with a damp soft rug or sponge and regular cleaning agents available on the market, e.g. dish soap.

Cleaning agents commonly used in households perform well in contact with laminate if they have no wear properties and do not contain acids or strong alkaline substances.

After washing with standard cleaning agents, laminate should be washed with clean water and dried completely in order to obtain a smooth surface without smudges.

HPL SWISS KRONO is resistant to most stain-causing substances, e.g. milk, tea, coffee, wine, syrups.

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Despite the high parameters of HPL laminate, it is recommended to remove remains of all aforementioned products from the surface promptly.

Particular attention should be paid to products such as blueberry juice, beetroot juice, or tomato puree.

8 - EN 438-3 standard

HPL Swiss Krono laminates meet the requirements defined by the EN 438-3 standard.

EN 438-3 standard precisely defines the parameters and properties of all types of HPL laminates, including control procedures for unequivocal determining of declared material properties.

Properties of decorative paper-laminated plastic according to EN 438-3

No	Property	J.m.	Requirement
1	Deviation from nominal sizes: - Thickness - length and width	mm mm	$\pm 0,1$ $\pm 10,0$
2	Resistance to scratches	degree	$\geq 3^*$
3	Resistance to wear	rotations	Initial 50 / average 150
4	Edge straightness tolerance	mm/m	$< 1,5$
5	Edge perpendicularity tolerance	mm/m	$< 1,5$
6	Stain resistance	degree	$\geq 4^*$
7	Resistance to cigarette embers	degree	$\geq 3^*$
8	Resistance to hot pot base (180°C)	degree	shiny surfaces $\geq 3^*$ other surfaces ≥ 4
9	Steam resistance	degree	shiny surfaces $\geq 3^*$ other surfaces ≥ 4

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