



## Formica® High Pressure Decorative Laminates Technical Data Sheet

Formica® High Pressure Decorative Laminate is a material produced by simultaneous application of heat and pressure, in order to obtain a homogeneous non-porous high density product. The core structure and outer surface are composed of paper, impregnated with thermosetting resin.

Technical Specification-Grade HPL			Post Forming Grade		General Purpose Grade		
Test Method NEMA LD3:2005	Characteristic	Unit	Criterion values	Typical Value 0.7 mm	Criterion values	Typical Value 0.8 mm	
	Thickness	mm	±0.10	0.7±0.06	±0.10	0.8±0.08	
Clause 3.1	Appearance		No ABC Defect	No ABC Defect	No ABC Defect	No ABC Defect	
Clause 3.3	Light Resistance	Rating, Min	Slight Effect	No Effect	Slight Effect	No Effect	
Clause 3.4	Cleanability (Reagents 1-10) (Reagents 11-15)	Rating, Max Appearance Appearance	20 No Effect Moderate	20 No Effect Moderate	20 No Effect Moderate	20 No Effect Moderate	
Clause 3.5	Boiling Water Resistance	Rating, Min	Slight Effect	No Effect	No Effect	No Effect	
Clause 3.6	High Temperature Resistance	Rating, Min	Slight Effect	No Effect	Slight Effect	No Effect	
Clause 3.7	Resistance to scratching	Rating, Min	3	≥3	3	≥3	
Clause 3.8	Ball Impact Resistance (Drop Height)	mm, Min	500	≥500	500	≥500	
Clause 3.9	Dart Impact Resistance	mm, Min	200	≥200	200	≥200	
Clause 3.10	Radiant Heat Resistance (coil method)	Sec, Min	80	≥80	80	≥80	
Clause 3.11	Dimensional Change	Machine direction	%, Max	1.1	≤1.1	0.7	≤0.7
		Cross direction	%, Max	1.4	≤1.4	1.2	≤1.2
Clause 3.12	Dimensional stability	Machine direction	%, Max	1.0	≤1.0	0.6	≤0.6
		Cross direction	%, Max	1.3	≤1.3	1.1	≤1.1
Clause 3.13	Wear Resistance	Revolutions, Min	400	≥400	400	≥400	
Clause 3.14	Formability	Radius mm, Min	13	≤13	/	/	

-Inspection items mentioned above, results of resistance to scratching are expressed as rating 1 – rating 5, the best is rating 5

**Note to Formica HPL thin laminate:**

- Pearlescent items are excluded from this wear resistance and resistance to scratching, must be verified separately.
- HPL post forming grade: Formability is depending on decorative paper basic weight and texture effect, must be verified.

**Disclaimer:**

The material Technical Data Sheets provide all the technical information relevant to the performance of the product as tested by certified testing body. Any information contained within this document must be verified and tested for suitability by the user for his or her particular purpose or specific application. Consideration needs to be given to local or specific circumstances. The content of this document reflects our knowledge and experience at the time of publication.