



TECHNICAL DATA

PRODUCT DESCRIPTION

Compact™ grades are decorative laminates with a thickness of at least 1/8" and generally have a decorative surface on both sides. Being of homogeneous construction, they offer excellent dimensional stability and mechanical strength. Since Compact™ 1/4" thick or below usually requires some measure of support (e.g. a metal frame), thicker laminates can be regarded as self-supporting. Compact™ laminate over 1/4" thick are suitable for horizontal applications with the minimum of support. Not only do they meet all the requirements of EN 438:2005, ISO 4586, NEMA LD3 they also possess high impact and moisture resistant properties. Compact™ laminates are available in both standard and flame-retardant grades.

STORAGE

Compact™ sheets should be stored in enclosed warehouses where normal interior conditions (65-75°F and 50-60% relative humidity) are maintained. Compact™ laminates will remain flat if stored horizontally in packs on a flat base board, with their edges flush with one another. The base board must be dry and ideally it should be covered with a material impervious to water, to act as a moisture barrier.

The top sheet of each stack should also be covered with a moisture barrier/cover board, with sufficient weight to remain flat and in contact with the whole surface area of the top sheet of Compact™ laminate. This procedure should be maintained throughout their storage (whether in a warehouse or on the fabrication shop floor) and reinstated whenever a sheet is removed from the stack.

If Compact™ sheets are not stored flat for any length of time, deformation can result which will be almost impossible to rectify, particularly with thicker boards. Protective films must be removed from both sides simultaneously.

RECOMMENDED APPLICATION

Compact™ by Formica Group is suitable for interior horizontal or vertical surfaces where high strength, impact, water, and humidity resistance are required. Because of its inherent high strength, Compact™ sheets may be used as a structural material. Compact™ sheets can be drilled, routed, tapped, sanded, shaped and cut with standard carbide-tipped tooling. Compact™ sheets are available in two-sided decorative face; thicknesses ranging from 1/8" (3.18mm) to 1" (25.4mm) with black core. Fire retardant, Class I (A) grades are also available.

FABRICATION AND ASSEMBLY

All the general recommendations for the fabrication of thin laminates also apply to Compact™ laminate and they should be treated in the same manner as double sided composite boards. The following additional recommendations should also be observed.

GENERAL

The increased thickness of Compact™ laminates imposes greater demands on cutting tools and causes greater wear. Slower feed-speeds than those generally used for cutting HPL-faced composite boards are required. The degree of feed speed reduction will

depend on the thickness of the laminate and the quality of finish required. Tool manufacturers should be consulted as to the type and quality of tungsten carbide tipping to provide the best performance. Where long production runs are contemplated and where a high quality finish is required, it is worth considering PCD (Polycrystalline Diamond) tooling. In all machine processes, localized heating caused by poorly maintained saws and cutters must be avoided. For optimum flatness the longest dimension of the panel should always be cut to coincide with the longest dimension of the Compact™ sheet.

SAWING

Saw blades normally used for cutting double sided composites are generally suitable for cutting Compact™ laminate grades. Saws of less than 2 mm in thickness are not recommended. Breakout on the underside and poor cutting of Compact™ sheets can be reduced by various methods.

1. By the use of a pre-scoring blade on the underside.
2. Using a base-board of plywood or hardboard beneath the Compact™ sheet.
3. Altering the exit angle of the saw blade by adjusting the height setting.
4. Triple chip designs have shown to provide good cut quality. Hook - +15°.
5. Rate of advance of the cutter ("chip load") should be .001"-.002".

NOTE: The higher the saw blade the better the top cut and the worse the bottom cut and vice versa. The feed speed essentially governs the quality of the saw cut when sawing Compact™ laminates having two decorative faces

PROFILE CUTTING AND EDGE FINISHING

It is not necessary to apply edging strips or edge sealants to Compact™ panels and for many applications clean sawn edges are sufficient.

A hand router may be used to achieve a superior finish or a profiled edge. Rough cut panels to approximately 1/16" before finish routing. Two-flute carbide straight cutting bits work well for trimming double-sided panels. Although it is not possible to achieve complete freedom from cutter marks, they can be minimized by feeding the work at a constant controlled speed. Care should be taken to avoid pausing during cutting and profiling, as burn marks may result which are difficult to remove.

A CNC router cutting sequence is determined by the type of machining required. A good starting point for machining is:

- Spindle Speed — 16,000-18,000 rpms
- Feed Rate — 200-900 in/min

Where it is desirable for edges to be completely free from cutter marks, a further sanding and scraping operation is necessary. Edges may be further enhanced by buffing with steel wool and applying silicone-free oil. A use of an orbital sander in multi-step finishing sequence like Solid Surface can be achieved.



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MATTE FINISH	SATIN FINISH	SEMI-GLOSS FINISH
100µ	100µ	100µ
80µ	80µ	80µ
60µ	60µ	60
1000 Abralon		
1000 Abralon	1000 Abralon	2000 Abralon

Chamfering or profiling the edges of Compact™ panels will reduce the risk of edge impact damage.

DRILLING

The most suitable drills for use on Compact™ laminates are those designed for plastic sheet materials. These drills have a point angle of 60°- 80° instead of the normal 120° for drilling metal.

To avoid breakout on the reverse side, the feed speed of the drilling head and the pressure applied should be gradually reduced approaching the point of breakthrough. Working on a firm underlay, such as plywood or chipboard, will also reduce the risk of breakout.

For blind boring into the face, the depth of the hole should be such that at least 1/8" of material remains between the bottom of the hole and the other side of the sheet. TCT lip and spur drills will produce clean flat bottomed blind holes, with less risk of point penetration on the reverse side. This will allow maximum depth of material to be used for fixings. Compact™ sheets less than 3/8" thick are not considered suitable for blind fixing. When drilling parallel to the surface (edge drilling) at least 1/8" of material must remain on either side of the hole. Threaded holes can be produced using engineers screw cutting taps. Self-tapping screws or threaded brass inserts may also be used.

INSTALLATION

In the planning of any installation, it is essential to take into account the dimensional movement that can occur with Compact™ laminates and allowances must be made in the design, fabrication and installation processes. Movement in the length direction of the sheet is about half of that in the width direction.

Typical dimensional movement values resulting from extreme change in relative humidity are as follows:

- Transverse direction of the sheet: 0.3" per 10'
- Longitudinal direction of the sheet: 0.1" per 10'

Compact™ panels used for wall cladding may be fixed by screwing directly through the face, or by hanging on a rigid supporting timber or metal framework with 'Z' clips. Thinner grades,

1/4" or less, may be bonded to a wood-based framework with heavy duty building adhesives. Scuffing the back of the Compact™ panel with 220 grit sand paper is advised. The chosen method of attachment will depend on the installation, board thickness and visual design criteria. In all applications the panels must be fixed to a rigid, secure system of horizontal supports at not more than 2' centers, with vertical support members at the joints appropriate to the detailing. Fixing clips should also be at maximum 2' centers. It is recommended that panels of less than full board width are used, both for ease of handling and reducing dimensional movement.

Compact™ panels should not be fixed to freshly constructed block work (CMU) or brickwork until adequate drying has taken place, nor should they be fixed to damp walls without the protection of a damp-proof membrane.

NOTE: When cladding damp walls Formica Corporation recommends metal furring strips or channel. Do not use particleboard or MDF as lacks structural integrity.

Adequate ventilation/air circulation must be provided behind the panels either by notching the support members or packing them off the wall. Typical minimum ventilation access at the top and bottom of the panels should be 3in²/10ft² of panel area.

Panels should have minimum of 1/8" gap between them to allow for air circulation and panel movement.

DIRECT FACEFIXING

Thru fixing holes should be at least 1.5 times the outside diameter of the screw being used and should be a minimum of 3/4" from the edge of the panel. Soft plastic bushes should be used to ensure correct centering of the screw in the hole, thus still allowing for movement. Countersunk screws should not be used.

ATTACHING FIXING DEVICES

'Z' clips and other secret fixing devices may be attached to the back of panels with 'Taptite' self-tapping screws or threaded brass expansion inserts. Screws and bolts with slow threads provide better resistance to working loose than those with fast threads. In all cases a blind pilot hole of the correct size must first be bored in the back of the panel. The depth of the hole should be at least 1/32" greater than the penetrating depth of the screw, and should leave at least 1/4" of material between the bottom of the hole and the face of the panel.

Rigid items, such as 'Z' clips and fixing angles, fixed to Compact™ laminate panels, should have oversize holes to accommodate differential movement. A slip foil between the two components is also recommended. Expansion fasteners should not be used in edge-drilled holes (i.e. parallel to the surface).

EDGE TO EDGE JOINTING

Edge-to-edge joints may be either tongued and grooved, or simply grooved and a loose spline inserted. Whichever method is chosen, the wall thickness of the groove should be greater than the width of the groove. The depth of the groove should be no greater than the thickness of the board and the length of the tongue/spline should be such as to accommodate the maximum anticipated movement. Compact™ laminates less than 3/8" thick are not suitable for edge grooving.

EDGE RETAINING PROFILES

Edge retaining profiles of steel or aluminum should be used in situations where some movement of adjoining panels is anticipated, such as in vehicle construction.

ATTACHING LAMINATE TO COMPACT™

Solvent-based contact adhesive can be used to bond laminate sheets to Compact™ sheets. Do not use water-based contacts for this application. Scuff up surface of Compact™ with 220 grit sandpaper.



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THERMOFORMING

Compact™ S2 at 1/8" thickness can be thermoformed.

Product is heated to 325°F using a convection or radiant oven. Depending on oven type, trials needs to be performed to determine time to heat the sheet thru its core. Temperatures in excess of 375°F may cause blistering. After heating, clamp the mold and let cool to room temperature. Sheets will form to a 6" mold radius but there will be some spring back to a larger radius after cooling depending on sheet size and grain direction.

APPLICATION

In common with all high-pressure decorative laminates Compact™ laminates undergo a certain amount of dimensional movement when subjected to changes in humidity. In order to minimize the risk of bow occurring as a result of this movement, the following points should be observed:

1. In new buildings, or where excessive moisture conditions are present, it is recommended that, prior to fixing Compact™ laminates, a process of pre-conditioning be carried out to ensure the sheets reach an equilibrium within the site conditions.

This can usually be achieved by laying the Compact™ sheets on a pallet, neatly and flat, face to face and back to back, using care-fully aligned spacer sticks (1" by 1") between the sheets at 12' centers across the full area of the wallboards, in the area where they are to be used, (or in another area having identical conditions), for 7 to 10 days prior to installation.

2. Panels should be cut with the long edge parallel to the length of the sheet. Dimensional movement across the width of the sheet is twice as great as it is along the length, so cutting panels with the long dimension running across the width of the sheet will greatly increase the risk of bowing.
3. As far as possible, the ambient conditions should be the same on each side of the panel, as it is important that both sides gain or lose moisture at roughly the same rate. Where panels are mounted on a wall or enclose a vanity unit or Integrated Plumbing System (IPS), adequate ventilation must be provided to ensure that temperature and humidity conditions at the backs of the panels are essentially the same as those at the front.
4. Fixing centers should be sufficiently close to prevent excessive freedom of movement. Shower cubicle doors greater than 60" high should have three hinges.

LIMITATIONS

Compact™ sheets are suitable for interior horizontal or vertical surfaces. Compact™ sheets, 1/4" (6.4mm) or less, are not recommended for adherence directly to plaster, gypsum board, or concrete. They can be attached to particleboard, MDF or hardwood faced particleboard. Compact™ greater than 1/4" should be attached using mechanical fixing systems (see above). Do not use in areas exposed to temperatures exceeding 275°F (135°C). Compact™ sheets should not be used in wet wall applications where one side is exposed to a higher humidity than the other. Areas in bathrooms such as toilet, urinal and shower room partitions are fine since both sides are exposed to equal moisture. They should not be used in

shower stalls. Compact™ sheets are not recommended for exterior applications.

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Performance compliance of Compact™ by Formica Group:

ANSI/NEMA STANDARDS PUBLICATION - LD3-2005

PHYSICAL PROPERTIES	LD3 TEST	COMPACT™
Appearance	3.1	No ABC Defects
Light Resistance	3.3	Slight Effect
Cleanability	3.4	20 (maximum)
Stain Resistance Reagents 1 – 10 Reagents 11 – 15	3.4	No Effect Moderate Effect
Boiling Water Resistance	3.5	Slight Effect
High Temperature Resistance	3.6	Slight Effect
Ball Impact Resistance (in.) – in – mm	3.8	75 (minimum) 1905 (minimum)
Radiant Heat Resistance (sec.)	3.10	250 (minimum)
Dimensional Change Machine Direction – % Cross Direction – %	3.11	0.30 (maximum) 0.70 (maximum)
Wear Resistance – cycles	3.13	400 (minimum)

ASTM MECHANICAL PERFORMANCE PROPERTIES

MECHANICAL PROPERTIES*	ASTM TEST	COMPACT™
Flexural Strength Ultimate Modulus	D790-84a	2.12 x 10 ⁴ psi 1.91 x 10 ⁶ psi
Tensile Strength Ultimate Modulus	D638-84	1.97 x 10 ⁴ psi 2.07 x 10 ⁶ psi
Bond Strength	D952-8	1.460 x 10 ⁴ psi
Bearing Strength	D953-84a	1.650 x 10 ⁴ psi

STANDARD COMPACT™ FIRE TEST DATA - ASTM E-84

GRADE/FORMICA® BRAND PRODUCTS (FACED MATERIAL)	ADHESIVES	FLAME	SMOKE	CLASS
S6/Compact (1/2" Thick Phenolic)	Unbonded	30	110	B
S7/Compact (3/4" Thick Phenolic)	Unbonded	30	110	B

FIRE RATED COMPACT™ FIRE TEST DATA - ASTM E-84 UL CLASSIFIED BUILDING PRODUCTS - FILE R22111 TESTED IN ACCORDANCE WITH UL723/ASTM E-84

THICKNESS	FLAME	SMOKE	CLASS
1/4" to 1" (6.35 mm to 25.4 mm)	10	165	A



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SIZES

STANDARD COMPACT™

Sheet Sizes:	48" (121.9cm) x 96" (243.8cm)
	60" (152.4cm) x 96" (243.8cm)
	60" (152.4cm) x 120" (403.8cm)
	60" (152.4cm) x 144" (365.8cm)

FIRE-RATED COMPACT™

Sheet Widths:	48" (121.9cm), 60" (152.4cm)
Sheet Lengths:	96" (243.8cm), 120" (403.8 cm), 144" (365.8cm)

TYPICAL THICKNESSES

S2	0.125" (3.18mm)
P7/FM	0.250" (6.4mm)
P9/FL	0.313" (7.9mm)
S8/FK	0.375" (9.5mm)
S6/F1	0.500" (12.7mm)
C6	0.500" (12.7mm)
P8	0.625" (15.9mm)
S7/F5	0.750" (19.0mm)
C7	0.750" (19.0mm)
R3/F8	1.000" (25.4mm)

WEIGHT

Compact™ sheet weighs approximately 90 lbs/ft³ (1442 kg/m³).

COLORS, PATTERNS, AND FINISH

Compact™ laminate sheets are available in a broad selection of designs and colors in matte and crystal finish as factory orders.

Compact™ samples are available from Formica Corporation specification representatives or directly from Formica Corporation. Call 1-800-FORMICA™.

HOW TO SPECIFY

Panels shall be Compact™ by Formica Group, Cincinnati, Ohio.

COLOR NUMBER

COLOR NAME

THICKNESS

FINISH

USE AND CARE GUIDELINES

Formica® Laminate, Compact and ColorCore®2 Surfacing are designed for beauty and durability. Like any surfacing materials they can be damaged by abuse and carelessness. When used as recommended with proper use and care, the end result is years of satisfaction.

SCRATCH AND IMPACT PROTECTION

Formica® Laminate, Compact and ColorCore®2 surfacing material are resistant to scratches and impacts under normal use conditions.

USE CUTTING BOARDS, CHOPPING BLOCKS, OR OTHER PROTECTIVE SURFACES.

- Do not chop, slice, pound, or hammer on any laminate surface.
- Knives or other sharp utensils may slice or scratch the surface.
- Heavy blows from a hammer or meat tenderizer may crack or gouge the surface.

USE PLACE MATS, DOILIES, AND TRIVETS ON LAMINATE SURFACES WHEN NECESSARY.

- Ceramics and abrasive objects can cause scratching and premature wear – do not slide these items across surface.

FOLLOW RECOMMENDATIONS FOR CLEANING – DO NOT USE ABRASIVE CLEANERS, STEEL WOOL, SANDPAPER, OR SCOTCH-BRITE® SCOURING PADS (SEE CLEANING SECTION INSIDE).

HOT OBJECTS

Cookware still hot from the stove, oven or microwave, as well as electric skillets, waffle irons, curling irons and hot rollers, should not be placed directly on laminate surfaces. Use a trivet, insulated hot pad or other protective device beneath all hot cookware, heat generating appliances, or other heated objects.

- Formica® Laminate, Compact and ColorCore®2 surfacing material can withstand heat up to 275°F (135°C) for short periods of time.

AVOID IRONING OR PLACING A HOT IRON ON LAMINATE SURFACES. DO NOT PLACE LIGHTED CIGARETTES DIRECTLY ON LAMINATE SURFACES.

ORDINARY CLEANING

Formica® Laminate, Compact and ColorCore®2 surfacing material are very easy to clean.

- In most cases, you only need to use a clean, damp, non-abrasive cotton cloth and a mild liquid detergent or household cleaner.
- Rinse with clean water, using a clean, non-abrasive cotton cloth.
- Dry the surface with a soft, clean, non-abrasive cotton cloth.

For specific types of surfaces, use the following care guidelines.



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MATTE AND CRYSTAL FINISH LAMINATES

Especially hard-to-clean areas may require special attention. Use a nylon bristled hand or vegetable brush, along with a mild liquid detergent-and-water solution or household cleaner. Clean the soiled area using a rotating motion. Rinse and dry the surface as indicated above.

ABRASIVES

Abrasive pads, scouring powders or cleaners may permanently dull and scratch the laminate surface making it susceptible to staining.

Ceramics, including unglazed materials and other abrasive objects, can cause scratching and premature wear – do not slide these items across surface.

CHEMICAL DAMAGE

Never use cleaners containing acid, alkali, or sodium hypochlorite. These cleaners will mar, etch, corrode, and permanently discolor the laminate surface. Also, make sure that bottles, rags, and other materials contaminated with these cleaners never contact the laminate surface. Accidental spills or splatters from these compounds should be wiped off immediately, and the area rinsed thoroughly with water.

EXAMPLES OF CLEANERS CONTAINING ACID, ALKALI, OR SODIUM HYPOCHLORITE INCLUDE, BUT ARE NOT LIMITED TO:

ceramic cooktop cleaners	oven cleaners
chlorine bleach	rust removers
coffeepot cleaners	some countertop cleaners
drain cleaners	some disinfectants
lime scale removers	toilet bowl cleaners
metal cleaners	tub and tile cleaners

SPECIAL CLEANING RECOMMENDATIONS

PAINT AND VARNISH

Remove most oil-base paints, varnishes and lacquers from decorative laminate surfaces with a suitable solvent. Read and follow all warnings and instructions on the labels of all solvent products, and remember that most solvents are extremely flammable. Use solvent sparingly, as excessive amounts may delaminate edges. Remove most water-based paints with an ammoniated household cleaner. For stubborn paint spots, gently use a plastic, non-metallic, non-abrasive pad. Never use steel wool or other abrasive scouring pads.

STAINS

To remove or minimize stains, use full strength Fantastik® All Purpose Cleaner, Formula 409®, Pine-Sol® (original formulation) or other mild household cleaner on the affected area, and allow it to draw out the stain. Blot with a clean, damp, non-abrasive cotton cloth, and then rinse with clean water. When a recommended cleaner changes its formulation, the change may be harmful to the laminate surface. Formica Corporation cannot be held responsible for these changes. Solvents such as denatured alcohol can also be used. Follow all directions and warnings on the solvent label because many are extremely flammable.

STUBBORN OR “FUGITIVE” STAINS THAT MAY DISAPPEAR ON THEIR OWN, AFTER A SHORT TIME OR AFTER REPEATED CLEANINGS, INCLUDE:

coffee and tea stains	food stains
fingerprints	glass rings
food dyes	water marks

STAINS WHICH ARE STUBBORN OR EVEN PERMANENT, AND MAY NOT DISAPPEAR, INCLUDE:

cash register inks	lemon juice
food pricing ink	marking pen inks
indelible inks	newsprint
label inks	wood stains

SOME MATERIALS AND LIQUIDS, SUCH AS DYES AND PHARMACEUTICAL PRODUCTS, WILL PERMANENTLY STAIN LAMINATE. EXAMPLES INCLUDE:

dermatological	povidone-iodine
hair dyes and rinses	Red-2B dye
laundry bluing	silver nitrate
Mercurochrome®	tannic acid
peroxides	tar compounds

These stains may be reduced by applying a paste of baking soda and water on the area to pull out the stain. The paste will be slightly abrasive, so do not rub. wipe up the paste with a clean, damp, non-abrasive cotton cloth, and then rinse clean with water.

Periodic application of a self-cleaning wax can help minimize future staining.

SCOTCH-BRITE® IS A REGISTERED TRADEMARK OF 3M COMPANY. FANTASTIK® IS A REGISTERED TRADEMARK OF DOWBRANDS INC. FORMULA 409® AND PINE SOL® ARE REGISTERED TRADEMARKS OF THE CLOROX COMPANY. MERCUROCHROME® IS A LICENSED TRADEMARK OF BECKTON DICKSON.



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LIMITED WARRANTY

Formica Corporation expressly warrants that, for a period of one (1) year from the date of first sale, these products will be reasonably free of defects in materials and workmanship, and that when properly handled and fabricated, will conform, within accepted tolerance, to applicable manufacturing specifications. Colors subject to dye lot variations. This limited warranty only applies to Formica® Brand Laminate which is stored, handled, fabricated and installed in the manner recommended by Formica Corporation. Due to the variety of uses and applications to which Formica® Brand Laminate may be put, FORMICA CORPORATION CAN MAKE NO WARRANTY THAT THIS PRODUCT IS SUITABLE FOR ANY PARTICULAR PURPOSE AND CAN MAKE NO OTHER WARRANTIES, EXPRESS OR IMPLIED, OTHER THAN THOSE SET FORTH ABOVE.

DISCLAIMER OF WARRANTIES

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LIMITATION OF LIABILITY

No claim by buyer of any kind, including claims for indemnification, whether as to quality or amount of products delivered or for non-delivery of products, shall be greater in amount than the purchase price of the products in respect of which damages are claimed. IN NO EVENT SHALL FORMICA CORPORATION BE LIABLE TO BUYER FOR ANY SPECIAL, INDIRECT, INCIDENTAL, RELIANCE, EXEMPLARY, OR CONSEQUENTIAL DAMAGES OR COVER, OR LOSS OF PROFIT, REVENUE OR USE, IN CONNECTION WITH, ARISING OUT OF, OR AS A RESULT OF, THE SALE, DELIVERY, SERVICING, USE OR LOSS OF USE OF THE PRODUCTS SOLD HEREUNDER, OR FOR ANY LIABILITY OF BUYER TO ANY THIRD PARTY WITH RESPECT THERETO. BUYER SHALL INSPECT FOR NONCONFORMITY PROMPTLY UPON RECEIPT. Failure by buyer to give Formica Corporation written notice of claim within 30 days from date of delivery or, in the case of non-delivery from the date fixed for delivery, shall constitute a waiver by buyer of all claims in respect of such products.

This limited warranty gives purchaser of Formica® Brand Laminate specific legal rights. Other rights may be available and vary from state to state.

Any information or suggestion concerning application, specifications or compliances with codes and standards is provided solely for your convenient reference and without any representation as to accuracy or suitability. Formica Corporation disclaims any legal responsibility. The user must verify and test the suitability of any information or products for their own particular purpose of specific application.

MANUFACTURER

Formica® Brand Laminate sheets are manufactured by Formica Corporation.

TECHNICAL SERVICES

Technical assistance may be obtained through your local Formica® Brand Products Distributor or from Formica Corporation trained representatives in sales offices throughout the country. To assist these representatives, Formica Corporation maintains a sales and technical services staff in Cincinnati, Ohio. For technical assistance, contact your distributor or sales representative; write the company directly at Formica Corporation Technical Services Department, 10155 Reading Road, Cincinnati, OH, 45241; call (513) 786-3578 or 1-800-FORMICA™; or fax (513) 786-3195. In Canada, call 1-800-363-1405. In Mexico, call (525) 530-3135.

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