

**TECHNICAL DATA: Melamine Film – Short cycle**

Effective date: 01/08/2008

Application:	Lamination of wood based materials for the furniture industry and for interior construction components.
Characteristics:	Duroplastic impregnated films on the basis of melamine and urea resins.
Product features:	Our short cycle films display the whole range of the present typographic possibilities. There are virtually no limits to the wood reproductions, stone decors or other fantasy designs. The finished surfaces are highly wear resistant. The surface feel of the end product is influenced by the manufacturing process so that the surface structure as well as the gloss grade can be selected by the manufacturer.
Application areas:	The end products are used in all areas of daily life but, due to their hard wearing surfaces, predominantly in the furniture industry and interior construction.
Appearance:	Impregnated films on a decorative paper basis (uni, wood reproduction, fantasy etc.).
Base paper weight:	50–150 g/m ²
Processing:	<p>Lamination of wood based materials using heat and pressure, usually by means of a short cycle press. The processing temperature normally lies between 150 and 220 °C using press pads and hard-chromed brass or steel plates with pressing times of between 10 and 50 seconds and forming pressures of between 180 and 600 N/cm².</p> <p>Modified forms are suitable for processing using Conti presses or for the processing as CPL laminates. The films can be processed without difficulty as our qualified technicians can adjust these to suit the individual processing requirements of a particular press.</p>
Delivery form/Measurements:	<p>Roll material – packed vertically or horizontally – in lengths of up to 2000 linear meters per roll.</p> <p>Cut sheet material – packed horizontally on pallets, with lengths of up to 6000 mm.</p> <p>Film widths of up to 2630 mm.</p>
Packaging:	<p>Roll and sheet material packed in PE foil to protect against moisture.</p> <p>Other and/or additional packaging methods are possible on request.</p>
Storage stability:	Short cycle film material normally has a shelf life of 6 months when stored in carefully sealed packing at a temperature of 25 °C. Special decorative films, i. e. special resin adjustments can differ from this rule. High static pressure, e. g. pallet stacks, can cause the films to stick together.
Comments:	These specifications are based on our present knowledge and experience. This does not exempt the processor from making their own tests. A binding legal assurance can not be assumed from the statements that we have given concerning certain characteristics or the suitability for a particular purpose. Possible trade property rights as well as current laws and regulations must be observed and are the responsibility of the user.