

**TECHNICAL DATA: Liquilay® HS (handscraped)**

Effective date: 01/08/2008

Application:	Hardwearing and abrasion resistant lamination of wood based materials, specially for handscraped structures.
Characteristics:	High abrasion resistant duroplastic impregnated films on the basis of alpha cellulose papers and melamine resins with a single assymetric coating of abrasion proof additives.
Product features:	<p>After the lamination the Liquilay®-products form a transparent, very hardwearing and abrasion resistant surface, which brilliantly displays and protects the decorative surface below. The surface feel of the end product is influenced by the manufacturing process so that the structure as well as the gloss grade of the surface can be selected by the manufacturer.</p> <p>This product was developed for processing using deep structure plates. These prevent, i.e. reduce foaming spots without pressure during the lamination process.</p>
Application examples:	<p>Usually the end products are used in the laminate flooring industry, due to their hardwearing and abrasion resistant surfaces. Depending on the Laminate Norm (EN 13329) these conform to abrasion classes AC 1 up to AC 6.</p> <p>Classic applications here are handscraped or tile optics.</p>
Appearance:	Transparent film.
Base paper weight:	20–40 g/m ²
Processing:	<p>Lamination of wood based materials by means of heat and pressure usually on short cycle presses. The processing normally takes place within a temperature range of 150 to 220 °C using press pads and hard-chromed or steel plates with pressing times of between 8 and 50 seconds and a pressure of 180 up to 600 N/cm².</p> <p>In order to obtain decorative surfaces, specially impregnated printed decor films are placed under the Liquilay® before the lamination. With very dark colour shades a slight transparency loss may occur. The films can be processed without difficulty as our qualified technicians can adjust these to the individual processing requirements of a particular press.</p>
Delivery form/Measurements:	<p>Cut sheet material – packed horizontally on pallets – in lengths of up to 6000 mm.</p> <p>Film widths of up to 2630 mm.</p>
Packaging:	<p>Roll and sheet material are packed in PE foil to protect these against moisture.</p> <p>Other and/or additional packaging methods are possible on request.</p>
Storage stability:	Liquilay®-films normally have a shelf life of 8 weeks when stored in carefully sealed packing at a temperature of 25 °C. Later on faults in form of transparency defects, increased porosity and adhesion problems could occur. High static pressures, e.g. pallet stacks, could cause the sheets to stick together.
Comments:	These specifications are based on our present knowledge and experience. This does not exempt the processer 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.