

**TECHNICAL DATA: Melamine Film – SDW HS (handscraped)**

Effective date: 01/08/2008

Application:	Decorative carrier for lamination using Liquilay®-film types or Overlays specially impregnated for handscraped application.
Characteristics:	Duroplastic laminated impregnated films on the basis of melamine resins.
Product features:	Our SDW films demonstrate the complete range of the present typographic possibilities. There are virtually no limits to the wood reproductions, stone decors or other fantasy designs. In combination with our Liquilay®-HS products or our Overlays, these form hardwearing and abrasion resistant surfaces. This product was developed for processing using deep structure press plates. It prevents, i.e. reduces, the 'milky affect'.
Application examples:	In combination with our Liquilay®-HS products the end products with their hardwearing and abrasion resistant surfaces are used in the laminate flooring industry. The classical uses are for hand-scraped or tile optics.
Appearance:	Film material on a decorative paper basis (uni, wood reproductions, fantasy designs, etc.).
Base paper weight:	60–100 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 8 and 50 seconds and forming pressures of between 180 and 600 N/cm².</p> <p>In order to protect the decorative surfaces against mechanical effects, the film is covered by a high abrasion resistant Overlay, for e.g. Liquilay® before the lamination takes place. Depending on the Overlay type used, different abrasion classes for the laminate flooring norm (EN 13329) or the furniture surface norm (DIN 68861-2) can be achieved. 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 suit the individual requirements of a particular press.</p>
Delivery form/Measurements:	<p>Roll material – packed vertically or horizontally – in lengths of up to 2500 linear meters.</p> <p>Cut sheet material – packed horizontally on pallets – or sheet 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 these against moisture.</p> <p>Other and/or additional packaging methods are possible on request.</p>
Storage stability:	SDW film material normally has a shelf life of 6 months when stored in carefully sealed packing at a temperature of 25 °C. 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. They do 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.