

ABET LAMINATI

TECHNICAL DATA 1.2 MM COLORPACT

1.0mm Full Colour

(color through)

Manufacturer

ABET Corp.
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Product Description

Basic Uses: Colorpact/Full Colour ABET LAMINATI is a high pressure decorative laminate (HPDL) used as a laminate sanded for layup applications. Colorpact is created with melamine resins. When bonded to a core, the 1.2 mm product can be used for vertical and light horizontal applications.

Composition: Colorpact/Colorpact by ABET LAMINATI high pressure decorative laminate is manufactured by pressing melamine impregnated surface print and solid color surface sheets over a melamine impregnated transparent paper core at pressures over 1000 psi and temperatures of approximately 300 degrees F (149 degrees C). The 1.2 mm and 1.0mm product has a phenolic impregnated sheet on the back side that is sanded to facilitate bonding to a substrate.

Limitations: Because the specific composition of Colorpact/Full Colour high pressure decorative laminates and its particular applications and uses are different from regular high pressure laminates, customers must be aware of the following limitations:

- Colorpact/Full Colour expand and contract up to 1/8" per 3 ft longitudinally and 1/4" per 3 ft in the width direction with changes in relative humidity. See conditioning requirements.
- Colorpact/Full Colour are not recommended for exterior applications or for bonding to gypsum wallboard, plaster, concrete, or plywood.
- Do not use these products in high humidity conditions or temperatures higher than 130 degrees F (54 degrees C) for extended periods of time.
- Avoid using these products close to lamps or sources of heat that can raise the temperature of the material in a limited area.
- This product is not to be exposed to continuous, direct sunlight.
- Contact adhesives are not recommended for bonding the 1.2 mm Colorpact to a core.

Sheet Size: 51" (130 cm) x 120" (305 cm)

Thickness: Colorpact 1.2 +/- 0.1 mm

FABRICATION AND ASSEMBLY

Bonding:

1.2 Colorpact and 1.0 Full Colour by ABET LAMINATI should be bonded to suitable substrates such as particleboard and medium density fiberboard (MDF) with suitable semi-rigid (PVA), or rigid (urea, phenolic, or resorcinol) adhesives. The choice of adhesives is based upon the service for which the assembly is intended and upon bonding facilities available. **The use of contact adhesives is not recommended.** In all cases, the adhesive manufacturer's instructions for use should be followed closely. Substrates thinner than 1/4" are not recommended. Thicker substrates give greater stability in the finished panel. Pressures in excess of 45 psi should not be used since this could cause a starved glue line or telegraphing of the core. It is advisable to use the same materials on both sides of the panel. Colorpact backer sheets are available from ABET. Before using other materials to balance Colorpact

laminates, preliminary warpage tests must be performed with this balancing material.

Inspection:

All laminates are to be inspected prior to lamination to ensure they are sound, clean, and free of surface defects. Protective peel coat should be removed prior to inspection.

Conditioning:

Materials must be properly conditioned before they are used. High pressure decorative laminates and substrates should be allowed to acclimate for at least 48 hours at the same ambient conditions. Because of the expansion and shrinkage of Colorpact laminates with relative humidity and temperature, it is advisable to condition the material at approximately 23 degrees C (73 degrees F) and a relative humidity of 45% to 55% for at least 48 hours before cutting and fabrication.

Sawing:

It is important to cut the sheets using routers or table saws adjusting the blade height precisely to prevent chip out on the back side. Best results are achieved with a second groove blade. To avoid chipping it is important that the saw blade teeth cut into the decorative surface. Carbide tipped cutters and blades are recommended. The use of a jigsaw or bandsaw to cut the edges is not recommended.

Cutouts:

To avoid stress cracking, do not use square-cut inside corners. All cutouts should be routed or filed to ensure smooth edges. A radius of 6.35 mm (1/4") or larger in the corners is recommended to minimize stress cracking for an inner side of 10" or less. This radius must gradually be increased for openings with a longer inner side.

Drilling:

Drill oversize holes (at least 0.05 mm or 0.002" larger diameter) for screws and bolts. Holes must be cut cleanly to prevent cracks commencing from any rough ID edges that may occur as temperature and relative humidity changes.

Industry Practices:

Material, equipment, and workmanship should conform to industry standard practices, conditions, procedures and recommendations as specified by ANSI/NEMA LD-3-2005, Standard for High-Pressure Decorative Laminates, Annex A, Application, Fabrication, and Installation; or Architectural Woodworking Institute (AWI) "Architectural Woodwork Quality Standards, Guide Specifications and Quality Certification Program".

TECHNICAL DATA

Colorpact by ABET LAMINATI has been tested according to ANSI/NEMA Standard LD-3-2005 Standard for High-Pressure Decorative Laminates, ISO 4586, High Pressure Decorative Laminates, and EN-438.

PHYSICAL PROPERTIES OF 1.2 MM DIAFOS AND COLORPACT LAMINATES

NEMA TEST		TYPICAL ABET
		1.2 mm Colorpact
		LAMINATE
Thickness		0.048" +- 0.004" (1.2 mm +- 0.1 mm)
Light Resistance		Moderate effect
Cleanability (cycle)		11
Stain Resistance		
Reagents 1 – 10		No effect
Reagents 11 – 15		No effect
Boiling Water Resistance		No effect
High Temperature Resistance		No effect
Linear Glass Scratch Resistance		<200 grams
Ball Impact Resistance		1100 mm
Dart Impact Resistance		600 mm
Radiant Heat Resistance		148 seconds
Dimensional Change	MD	0.53%
	CD	0.71%
Room Temperature	MD	0.17%
	CD	0.33%
Dimensional Stability		
Wear Resistance		5600 cycles
Formability		N/A
Blister Resistance		63 seconds

DIAFOS COLLECTION TECHNICAL INFORMATION

Property	Test Method	Unit of Measurement	
			Facing Colorpact 1.2 MM Sanded
Thickness	EN 438/2.4	mm	1.2 ± 0.1
Density	DIN 53 479	Kg/m ³	1.500
Abrasion resistance	EN 438/2.6	revs	> 400
Dimensional Stability at 20° C	EN 438/2.10	% long. % transv.	<0.3 <0.6
Scratch resistance	EN 438/2.14	N	> 2.5
Stain resistance	EN 438/2.15	degree degree	Groups 1-2=5 Groups 3-4 > 4
Solidity of colours in xenon light	EN 438/2.16	blue wool scale	≥ 6
Resistance to cigarette burns	EN 438/2.18	degree	≥ 3
Rockwell hardness	ASTM D 785	HRE	-
Diffuse transmission factor	-	%	-
Fire resistance	CSE RF2/75/A RF3/77	-	Class 1 Interior Min. homologstion No. CN 267B11CD100010

TRANSPORTATION AND STORAGE

Colorpact sheets must be stored in a horizontal position, supported for their whole length and not positioned on edge, even after cutting.

TECHNICAL SERVICE

For samples, literature and technical assistance, call our toll-free line 800-228-2238 from 8:30AM to 5 PM, Monday thru Friday, or visit our web site ca.abetlaminati.com.



SCHEDA INFORMATIVA PRODOTTO
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(BTS)

Laminato uniformemente colorato sulla superficie e nello spessore, composto da strati di carta colorata e impregnata di resine termoindurenti; il tutto è sottoposto all'azione combinata di calore e alta pressione (9 MPa).
Material uniformly coloured on the surface and in the whole thickness, consisting of paper layers all coloured through and impregnated with thermosetting resins, bonded together by means of heat and high pressure (9 MPa).

CARATTERISTICA PROPERTY	METODO DI PROVA TEST METHOD (pr EN 438: 2005)	CRITERIO DI VALUTAZIONE PROPERTY or ATTRIBUTE	UNITA' DI MISURA UNIT	VALORE VALUE
Spessore Thickness	EN 438-2.5	spessore <i>thickness</i>	mm	1,2 ± 0,18
Tolleranza di planarità Flatness	EN 438-2.9	deformazione massima <i>maximum deviation</i> *	mm/m	≤ 100
Resistenza all'abrasione Resistance to surface wear	EN 438-2.10	res. all'abrasione <i>wear resistance</i>	giri <i>revs</i>	IP 2: 150 A 2: 350
Res. all'immersione in acqua bollente Resistance to immersion in boiling water	EN 438-2.12	aspetto fin. lucida <i>appearance gloss fin.</i> aspetto altre finiture <i>appearance other fin.</i>	grado <i>rating</i>	≥ 3 ≥ 4
Resistenza al vapore d'acqua Resistance to water vapour	EN 438-2.14	aspetto fin. lucida <i>appearance gloss fin.</i> aspetto altre finiture <i>appearance other fin.</i>	grado <i>rating</i>	≥ 3 ≥ 4
Resistenza al calore secco (180°C) Resistance to dry heat	EN 438-2.16	aspetto fin. lucida <i>appearance gloss fin.</i> aspetto altre finiture <i>appearance other fin.</i>	grado <i>rating</i>	≥ 3 ≥ 4
Stabilità dimensionale alle temperature elevate Stability at elevated temperature	EN 438-2.17	variazione dimensionale cumulativa <i>cumulative dimensional change</i>	% long. % long. % trasv. % transv.	≤ 0,8 ≤ 1,4
Resistenza al graffio Resistance to scratching	EN 438-2.25	aspetto fin. lucida <i>appearance gloss fin.</i> aspetto altre finiture <i>appearance other fin.</i>	grado <i>rating</i>	≥ 2 ≥ 3
Resistenza alle macchie Resistance to staining	EN 438-2.26	aspetto gruppi 1-2: <i>appearance groups 1-2</i> aspetto gruppo 3 <i>appearance group 3</i>	grado <i>rating</i>	5 ≥ 4
Solidità dei colori alla luce Lightfastness	EN 438-2.27	contrasto <i>contrast</i>	grado scala grigi <i>grey scale rating</i>	superficie <i>surface</i> : ≥ 4 ^a anima <i>core</i> : ≥ 3 ^a

Resistenza alle bruciature di sigaretta <i>Resistance to cigarette burns</i>	EN 438-2.30	aspetto <i>appearance</i>	grado <i>rating</i>	> 3
Densità <i>Density</i>	ISO 1183	densità <i>density</i>	gr/cm ³	≥ 1,40

* a condizione che siano rispettate le modalità e le condizioni di stoccaggio del laminato descritte sulla brochure "Servizio Informazione Tecnica" / *provided that the laminate is stored in the manner and conditions recommended in the brochure "Technical Information"* .

^a anomalo scurimento e/o fotocromia sono dovuti all'effetto shock dell'esposizione accelerata ma non sono caratteristici dell'esposizione naturale.
^a*extraneous darkening and/or photocromism are due to the shock effect of accelerated exposure and are not characteristics of natural exposure.*

NOTA: Attenzione! I colori utilizzati quale base per la realizzazione del prodotto e appartenenti alla collezione Colours, potrebbero subire variazioni di tono dovute alla particolare lavorazione necessaria alla realizzazione del Colorpact.

La lieve differenza di tono (coprenza) non è tuttavia da considerarsi difetto, perché è dovuta alla differenza di colore dell'anima del laminato (kraft).

NOTE: Attention! Background decors on the up-side belonging to the "Colours" swatch, may show variations in tone due to the particular composition, which is necessary for the manufacturing of Colorpact. The slight difference in tone (covering) must not be considered as a defect because it is due to

CONSIGLI PER LA LAVORAZIONE E LA MESSA IN OPERA

Per la lavorazione e la messa in opera del Colorpact sono necessarie alcune raccomandazioni specifiche qui indicate; per le indicazioni generali rimane valido il nostro documento "Servizio Informazione Tecnica".

Trasporto e Immagazzinaggio Sia nel formato standard che nei formati a misura, i pannelli di Colorpact devono essere tenuti in posizione orizzontale, appoggiati su tutta la superficie e non posizionati "a coltello".

Taglio È opportuno limitare il taglio dei pannelli alle seghe circolari fisse effettuando una regolazione accurata dell'altezza della lama onde evitare scheggiature sulla parte inferiore. Risultati ottimali si ottengono utilizzando un incisore insieme alla lama di taglio. Il pannello deve essere sempre tagliato in modo che il senso longitudinale rappresenti il lato lungo del pezzo. Sono sconsigliate seghe portatili e seghe a nastro.

Foratura Si raccomandano fori con un diametro circa 1,0 mm più largo di quello delle viti. Occorre curare scrupolosamente grandezza e qualità dei fori al fine di evitare la propagazione di eventuali fessurazioni, originatesi dal foro stesso. La propagazione della fessurazione può verificarsi in seguito alle lievi variazioni dimensionali del pannello che naturalmente avvengono per i cambiamenti di temperatura e umidità dell'ambiente.

Traforatura Si richiede la massima cautela nel taglio degli angoli arrotondati (raggio di almeno 5 mm) in modo che non ci sia alcuna scheggiatura su entrambe le facce. Una traforatura o un taglio interno male eseguiti portano inevitabilmente alla fessurazione del materiale.

Applicazione In funzione delle condizioni di temperatura e umidità, il Colorpact si contrae e si dilata sino a 3 mm/m in senso longitudinale e 6 mm/m in senso trasversale. Si raccomanda perciò di condizionare sempre il materiale in un locale con temperatura di ca. 20°C e 50% di U.R. prima dell'applicazione. È opportuno evitare l'uso del Colorpact ove ci sia presenza ravvicinata di lampade o sorgenti di calore che creino accumuli di calore in certi punti del pannello.

Occorre garantire sempre una buona circolazione d'aria su entrambi i lati in caso di doppio decorativo.

Equilibratura Il Colorpact ha caratteristiche fisiche che lo differenziano dal Print HPL; pertanto, in particolari applicazioni come per antine, si consiglia di utilizzare sulle due facce del composito lo stesso materiale. Se si vogliono utilizzare come bilanciatori altri materiali, compreso il Print HPL, è necessario effettuare prove preliminari.

Incollaggio L'incollaggio del Colorpact è possibile su supporti a base legnosa, come MDF e truciolare, mentre si sconsiglia l'uso di supporti minerali e plywood. Per quanto riguarda gli adesivi, si consiglia l'uso di collanti a pressione e in particolare colle viniliche e colle urea-formaldeide con tecnologia preferibilmente a freddo. Si sconsiglia l'uso di colle al neoprene ogni qualvolta si debbano effettuare traforature, tagli interni e forature, in quanto si potrebbero verificare fessurazioni.

ADVICE FOR MACHINING AND APPLICATION

Specific recommendations required for the machining and installation of Colorpact are given below. For general instructions, please consult our "Technical Information Service" document.

Transport and Storage *For both standard and made-to-measure sizes, Colorpact panels must be laid flat and stacked in neat piles with no overlapping.*

Cutting *The cutting of panels should only be carried out with fixed circular saws, accurately adjusting the blade height to avoid chipping the bottom edge of the panel. For optimal results, use a scoring blade together with the cutting blade. The panel should always be cut so that the longest edge follows the direction of the patterned surface. Portable saws and belt saws are not recommended for this operation.*

Drilling *It is recommended that holes be drilled with a diameter approx. 1,0 mm larger than that of the screws. It is very important to ensure that the holes be drilled accurately in terms of both size and quality, so as to avoid the spread of cracks resulting from the holes themselves. There is always a risk that such cracks may arise from a slight dimensional variation of the panels, which can occur following normal changes in ambient temperature and humidity.* **Fretworking** *It is vital to cut rounded edges with great care (minimum 5 mm radius) so as to avoid chipping on both sides of the panel. Bad fretwork or bad internal cuts will inevitably lead to cracking of the material.*

Application *Colorpact can shrink or expand by up to 3mm/m in the longitudinal direction and up to 6mm/m across the panel, in accordance with varying temperature and humidity conditions. We therefore recommend that the material should always be left to condition in a room at approx. 20° C temperature and 50 % relative humidity before applying it. It is advisable to avoid using Colorpact near lights or any other source of heat which could cause a build up of heat in certain parts of the panel. In cases where a panel has a decor on both sides, it is necessary to provide good air circulation on each side of the panel.*

Balancing *Colorpact has different physical characteristics from Print HPL. For certain applications, such as cabinet doors, we therefore recommend using the same material on both sides of the composite structure. If using other materials as balancers, including Print HPL, it will be necessary to carry out preliminary tests.*

Gluing *Colorpact can be glued to wood-based cores, such as MDF and chipboard, but it is not recommended for application to mineral based cores or plywood. With regard to glues, we recommend the use of pressure glues and, in particular, vinyl and urea-formaldehyde glues, preferably applied cold. We never recommend the use of neoprene glues when it is necessary to make holes, internal cuts or fretwork, to avoid the possibility of cracks on the panels.*

Materiale colorato in superficie e in tutto lo spessore con colori predefiniti, composto di fogli di carta impregnati di resina termoindurente e sottoposti all'azione combinata di calore e alta pressione (9 Mpa).
Material uniformly coloured on the surface and in the core, consisting of paper layers impregnated with thermosetting resins, bonded together by means of heat and high pressure (9 MPa).

CARATTERISTICA PROPERTY	METODO DI PROVA TEST METHOD EN 438: 2005	PROPRIETÀ O ATTRIBUTO PROPERTY or ATTRIBUTE	UNITA' DI MISURA UNIT (max o min) (max or min)	QUALITÀ DEL LAMINATO LAMINATE GRADE		
				BCS (1 dec)	BCS (2 dec)	BTS (1 dec)
Spessore <i>Thickness</i>	EN 438-2.5	spessore (t) <i>thickness (t)</i>	mm	t = 2,0 ± 0,25 t = 3,0 ± 0,40	2,0 ≤ t < 3,0 ± 0,25 3,0 ≤ t < 5,0 ± 0,40 5,0 ≤ t < 8,0 ± 0,50 8,0 ≤ t < 12,0 ± 0,70 12,0 ≤ t < 16,0 ± 0,80	t = 1,0 ± 0,15 1,0 < t < 2,0 ± 0,18
Planarità <i>Flatness</i>	EN 438-2.9	scostamento massimo * <i>maximum deviation *</i>	mm/m	2,0 ≤ t ≤ 3,0 100	2,0 ≤ t < 6,0 12,0 6,0 ≤ t < 10,0 8,0 10,0 ≤ t 5,0	1,0 ≤ t < 2,0 100
Lunghezza e larghezza <i>Length and width</i>	EN 438-2.6	Lunghezza e larghezza <i>Length and width</i>	mm	+ 10 / 0		
Linearità dei bordi <i>Straightness of edges</i>	EN 438-2.7	Linearità dei bordi <i>Straightness of edges</i>	mm/m	≤ 1,5		
Ortogonalità <i>Squareness</i>	EN 438-2.8	Ortogonalità <i>Squareness</i>	mm/m	≤ 1,5		
Resistenza all'usura della superficie <i>Resistance to surface wear</i>	EN 438-2.10	res. all'usura <i>wear resistance</i>	giri (min) <i>revolutions</i> Punto iniziale <i>Initial point</i> Valore di usura <i>Wear value</i>	150 350	150 350	
Resistenza all'immersione in acqua bollente <i>Resistance to immersion in boiling water</i>	EN 438-2.12	aumento della massa <i>mass increase</i>	% (max) 2 mm s; t < 5 mm t ≥ 5 mm	5 3	—	
		aumento dello spessore <i>thickness increase</i>	% (max) 2 mm s; t < 5 mm t ≥ 5 mm	6 4	—	
		aspetto <i>appearance</i>	classificazione (min) <i>rating (min)</i> finitura brillante <i>gloss finish</i> altre finiture <i>other finishes</i>	3 4	3 4	
Resistenza al vapore acqueo <i>Resistance to water vapour</i>	EN 438-2.14	aspetto <i>appearance</i>	classificazione (min) <i>rating (min)</i> finitura brillante <i>gloss finish</i> altre finiture <i>other finishes</i>	3 4	3 4	

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Resistenza al calore secco (180 °C) <i>Resistance to dry heat (180 °C)</i>	EN 438-2.16	aspetto <i>appearance</i>	classificazione (min) <i>rating (min)</i> finitura brillante <i>gloss finish</i> altre finiture <i>other finishes</i>	3 4	3 4
Stabilità dimensionale a temperatura elevata <i>Stability at elevated temperature</i>	EN 438-2.17	variazione dimensionale cumulativa <i>cumulative dimensional change</i>	% (max.) L t < 2 mm T	— —	0,80 1,40
			2 mm ≤ t < 5 mm L T	0,60 1,00	— —
			t ≥ 5 mm L T	0,50 0,80	— —
Resistenza alle fessurazioni (laminati compatti) <i>Resistance to crazing (thick laminates)</i>	EN 438-2.24	aspetto <i>appearance</i>	classificazione (min) <i>rating (min)</i>	superficie <i>surface</i> 4 strato interno <i>core</i> 3 ^b	—
Resistenza alla scalfittura <i>Resistance to scratching</i>	EN 438-2.25	aspetto <i>appearance</i>	classificazione (min) <i>rating (min)</i> finitura brillante <i>gloss finish</i> altre finiture <i>other finishes</i>	2 3	2 3
Resistenza alle macchie <i>Resistance to staining</i>	EN 438-2.26	aspetto <i>appearance</i>	Classificazione (min) <i>rating (min)</i> Gruppi 1 e 2 <i>Groups 1 and 2</i> Gruppo <i>Group</i> 3	5 4	5 4
Solidità alla luce (arco allo xeno) <i>Light fastness (xenon arc)</i>	EN 438-2.27	contrasto <i>contrast</i>	classificazione scala grigi (min) <i>grey scale rating (min)</i>	superficie <i>surface</i> 4 ^a strato interno <i>core</i> 3 ^a	superficie <i>surface</i> 4 ^a strato interno <i>core</i> 3 ^a
Resistenza alle bruciature di sigaretta <i>Resistance to cigarette burns</i>	EN 438-2.30	aspetto <i>appearance</i>	classificazione (min) <i>rating (min)</i>	3	3
Resistenza a trazione <i>Tensile strength</i>	EN ISO 527-2	forza <i>stress</i>	sollecitazione MPa (min) <i>stress MPa (min)</i>	60	—
Resistenza a flessione <i>Flexural strength</i>	EN ISO 178	forza <i>stress</i>	sollecitazione MPa (min) <i>stress MPa (min)</i>	80	—
Modulo elastico a flessione (E) <i>Flexural modulus (E)</i>	EN ISO 178	forza <i>stress</i>	sollecitazione MPa (min) <i>stress MPa (min)</i>	9000	—

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Densità
Density

ISO 1183-1

densità
 density

gr/cm³ (min)

1,4

* a condizione che siano rispettate le modalità e le condizioni di stoccaggio del laminato consigliate dal produttore
 * *provided that the laminate is stored in the manner and conditions recommended by the manufacturer*

^a anomalo scurimento e/o il fotocromismo sono dovuti all'effetto d'urto dell'esposizione accelerata e non sono caratteristici dell'esposizione naturale.
^a *extraneous darkening and/or photocromism are due to the shock effect of accelerated exposure and are not characteristics of natural exposure.*

^b Le fessure moderate corrono lungo tutto il bordo del campione.
^b *The moderate cracks lines run along all the edge of the specimen.*

NOTA: Attenzione! I colori utilizzati quale base per la realizzazione del prodotto e appartenenti anche ad altre collezioni, potrebbero subire variazioni di tono dovute alla particolare lavorazione necessaria alla realizzazione del Full-Colour. La lieve differenza di tono (coprenza) non è tuttavia da considerarsi difetto, perché è dovuta alla differenza di colore dell'anima del laminato (kraft).

NOTE: Attention! Background decors on the up-side belonging also to further swatches, may show variations in tone due to the particular composition, which is necessary for the manufacturing of Full-Colour. The slight difference in tone (covering)

NB il prodotto è disponibile con decorativi di superficie appartenenti a varie collezioni/finiture.
 Per quanto riguarda le caratteristiche di seguito elencate, si prega di fare riferimento alla scheda informativa prodotto corrispondente alla tipologia di laminato superficiale:

- resistenza all'usura della superficie
- resistenza al vapore acqueo
- resistenza al calore secco
- resistenza alla scalfittura
- resistenza alle macchie
- solidità alla luce
- resistenza alle bruciature di sigaretta

La tipologia di prodotto nella versione VERTICAL è idonea solo per applicazioni verticali e non orizzontali.

Note: the product is available in decors belonging to various swatches / finishes.

As far as the below characteristics are concerned, please refer to the informative technical sheet corresponding to the type of surface decor:

- *resistance to surface wear*
- *resistance to water vapour*
- *resistance to dry heat*
- *resistance to scratching*
- *resistance to staining*
- *light fastness*
- *resistance to cigarette burns*

The product typology in VERTICAL grade is suitable only for vertical and not horizontal applications.

INFORMAZIONI E RACCOMANDAZIONI GENERALI**Versione a 2 decorativi**

Trasporto e Immagazzinaggio: I pannelli devono essere tenuti in posizione orizzontale, appoggiati su tutta la superficie e non posizionati "a coltello".

Taglio: E' opportuno limitare il taglio dei pannelli alle seghe circolari fisse effettuando una regolazione accurata dell'altezza della lama onde evitare scheggiature sulla parte inferiore. Risultati ottimali si ottengono utilizzando un incisore insieme alla lama di taglio.

Sono sconsigliate seghe portatili e seghe a nastro. Il pannello deve essere sempre tagliato in modo che il senso longitudinale rappresenti il lato lungo del pezzo.

Foratura: Si raccomandano fori con un diametro circa 2,0 mm più largo di quello delle viti. Occorre curare scrupolosamente grandezza e qualità dei fori al fine di evitare fenomeni di fessurazione. Ciò è necessario in considerazione delle lievi variazioni dimensionali del pannello che naturalmente avvengono per i cambiamenti di temperatura e umidità dell'ambiente.

Traforatura: Si raccomanda la massima cautela nel taglio degli angoli arrotondati in modo che non ci sia alcuna scheggiatura su entrambe le facce.

Per ulteriori informazioni consultare la brochure "Stratificato".

Versione a 1 decorativo

Fare riferimento alla brochure "Servizio informazioni tecniche", con particolare attenzione all'incollaggio.

Incollaggio: E' tassativo evitare colle a contatto. Si consigliano colle viniliche con spalmatura > 200 gr/mq. Evitare forature, tagli a 90°.

Postformabilità: A causa della speciale composizione del prodotto, la postformatura non è consigliata.

INFORMATION AND GENERAL ADVICE**2-decor-version**

Transport and storage: Panels must be laid flat and stacked in neat piles with no overlapping.

Cutting: The cutting of panels should only be carried out with fixed circular saws, accurately adjusting the blade height to avoid chipping the bottom edge of the panel. For optimal results, use a scoring blade together with the cutting blade.

Portable saws and belt are not recommended for this operation. The panel must be cut so that the longitudinal sense represents the long side of the piece.

Drilling: It is recommended that holes be drilled with a diameter approx. 2,0 mm larger than that of the screws. It is important to ensure that the holes be drilled accurately in terms of both side and quality, so as to avoid the spread of cracks resulting from the holes themselves. This is necessary considering the slight dimensional variations of the panels, which can occur following normal changes in ambient temperature and humidity.

Fretworking: It is vital to cut round edges with great care so as to avoid chipping on both sides of

the panel. For further information please refer to "Stratificato" brochure.

1 decor-version

Please refer to the "Technical information" brochure, with particular attention to gluing.

Gluing: please avoid the use of contact glues. It is recommended to use PVAC glues > 200 gr / sqm. Drilling and 90° cut-outs should be avoided.

Colorpact and Full Colour by ABET LAMINATI

Colorpact/Full Colour are decorative high pressure laminate surfaces. Colorpact/Full Colour is a color through laminate.

Colorpact/Full Colour is a high pressure laminate with color through the entire thickness of the sheet. Colorpact/Full Colour is created with melamine resins.

Colorpact/Full Colour is 130cm x 305cm (approx. 51" x 120").

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Colorpact TECHNICAL INFORMATION

PROPERTY	TEST METHOD	UNIT OF MEASURE- MENT	Results
			Colorpact
THICKNESS	EN 4382.4	MM	1.2 +/- 0.1
DENSITY	DIN 53 479	Kg / m ³	1.500
ABRASION RESISTANCE	EN 438 / 2.6	REVOLUTIONS	>400
DIMENSIONAL STABILITY AT 20 ⁰ C	EN 438 / 2.10	% longitudinal % transverse	≤ 0.3 ≤0.6
SCRATCH RESISTANCE	EN 438 / 2.14	N	>2.5
STAIN RESISTANCE	EN 438 / 2.15	DEGREE	GROUPS 1-2=5 GROUPS 3-4≥4
SOLIDITY OF COLORS IN XENON LIGHT	EN 438 / 2.18	BLUE WOOL SCALE	≥6
RESISTANCE: CIGARETTE BURNS	EN 438 / 2.18	DEGREE	≥3
ROCKWELL HARDNESS	ASTM D 785	HRE	-
DIFFUSE TRANSMISSION FACTOR	-	%	-
FIRE RESISTANCE	CSE RF 2/75/A RF 3/77	-	CLASS 1

Limitations: Because the specific composition of Colorpact high pressure decorative laminates and its particular applications and uses are different from regular high pressure laminates, customers must be aware of the following limitations:

- Colorpact/Full Colour expand and contract up to 1/8"/3 ft longitudinally and 1/4"/3 ft in the width direction with changes in relative humidity. See conditioning requirements.
- Colorpact/Full Colour are not recommended for exterior applications or for bonding to gypsum wallboard, plaster, concrete, or plywood.
- Do not use these products in high humidity conditions or temperatures higher than 130 degrees F (54 degrees C) for extended periods of time.
- Avoid using these products close to lamps or sources of heat that can raise the temperature of the material in a limited area.
- This product is not to be exposed to continuous, direct sunlight.
- Contact adhesives are not recommended for bonding the 1.2 mm Colorpact or 1.0mm Full Colour to a core

INSTRUCTION FOR MACHINING AND APPLICATION

1.2mm Colorpact 1.0mm Full Colour

TRANSPORT AND STORAGE:

Even after cutting, Sheets must be kept in a horizontal position, supported for their whole length and not positioned on edge.

CUTTING:

It is important to cut the sheets only using table saws adjusting the blade height precisely to prevent chip out on the backside. Best results are achieved with a second groove blade.

BORING:

Attention must be given to hole diameter and ID edge. Bore must be cut cleanly to prevent cracks commencing from rough ID edges. These occur as temperature and ambient humidity changes.

When drilling to create fastening points always create a sleeve between the bolt / screw and the DIAFOS. Sometimes a rubber grommet can fill this role. The specific application will govern the type of sleeve needed. Failure to buffer the fastener and DIAFOS will almost certainly result in cracking of the sheet.

JIG SAWING:

The use of a jigsaw to cut edges is discouraged. The resultant jagged edges become the beginnings of cracks. Router edging offers best results.

APPLICATION TIPS:

- Colorpact/Full Colour contracts and dilates up to 3mm/meter longitudinally and 6mm/meter transverse with temperature or humidity change.

It is advisable to condition the material in a room with a a_0 temperature of about 68 °F. and relative humidity of 50% before application.

- It is important to avoid using this material close to lamps or sources of heat that can raise the temperature of the material in a limited area. It is important to guarantee good air circulation on both sides.
- The sheet must always be cut so that the longitudinal direction is the long side of the piece. The maximum distances between fixed points are:
Longitudinal = 35 inches
Transverse = 12 inches

BALANCING:

It is advisable to use the same materials on both surfaces. Colorpact/Full Colour backer is available from ABET LAMINATI. Before using other materials to balance Colorpact/Full Colour, preliminary tests must be performed.

BONDING:

Rigid glue lines are strongly recommended. This is particularly true where drilled holes, internal cuts or inside radii are needed. PVA, aliphatic and urea-formaldehyde adhesives work well. Contact adhesives do not.

SUBSTRATES:

Recommended –

- MDF
- Particleboard

Not Recommended –

- Drywall
- Plywood

For other substrates not listed above, please contact your local ABET LAMINATI representative.

When creating panels avoid any substrate less than ¼" thick.

Substrates vary in moisture absorption, warp stress, and general dimensional stability. Most applications will require a balance sheet. Overall, the thicker the substrate is the greater the stability of the finished panel.

INTERNAL CUTOUTS:

All internal cutouts must have a radius not less than ¼" for an inner side of 10". This radius must gradually be increased for openings with bigger inner sides.

CARE AND MAINTENANCE

Colorpact/Full Colour

ABET LAMINATI High Pressure Laminate can be cleaned with a clean damp cloth or sponge using a mild soap or detergent. General-purpose cleaners are also very effective. Ammonia or vinegar based glass cleaners are best for cleaning surfaces soiled by grease.

Abrasive cleaners and metal (or abrasive coated) scouring pads should not be used on laminate since they can permanently scratch and dull the surface and make it more susceptible to staining.

Water spots can be removed by using any non-bleach bathroom cleaner. If unsure, contact your local ABET LAMINATI representative.

CAUTION: We do not recommend the use of any cleaners with bleach or anti-bacterial formulas as they may damage the finish. Aggressive rubbing in one area can cause a burnish to appear, causing that spot to appear shinier than the rest of the surface.

ATTENTION: ABET LAMINATI

offers this information solely to provide suggestions for your application, since it is impossible to anticipate all variations in actual end use conditions. ABET LAMINATI cannot assume liabilities in connection with the use of this information.