

Product data sheet

Langenthaler Str. 4
69434 Hirschhorn/Neckar
Germany
phone 00-49-6272-689-0
fax 00-49-6272-689-30

Version: 10ZT09E

dekofoil

Product Description

The product *dekofoil* stands for a continuously produced laminate (CPL) with an aluminium surface. This metal layer is applied to a core of modified phenol resin using pressure. Depending on the type or thickness this products is obtainable in the following range:

1. Sheathing foil
2. Edge banding material
3. Endless laminate

The sheathing foil has a thickness of 0.2 mm and is therefore applicable where very small radii are required or to surface cylindrical profiled objects.

The edge banding material is produced in standard thickness of 0.4 mm and is intended for sealing edges (with smooth surfaces i.e. MDF / HDF and an even, machine-applied glue-coating).

The endless laminate is produced in thickness of 0.4 mm and can be used for surfacing elements.

A special heat-curing lacquer on the basis of an Epoxide resin gives the aluminium surface a permanent protection against corrosion and oxidization.

The aluminium layers in the current production have a rushed surface structure.

A slight unevenness in the surface in *dekofoil* is one of the features of this product. The slight indentations in the aluminium layer are at the present stand of the technique and are unavoidable and normal. The same holds for the colours in the following lists of products. These slight colour variations occur during the production process and are not detrimental to the overall appearance.

Products Available

A 250	Pure aluminium	brushed and lacquered	(natural colour)
A 251	Pure aluminium	brushed and lacquered	(gold colour)
A 256	Pure aluminium	brushed and lacquered	(stainless steel colour)

If other surfaces are required direct contact with **Dekodur®** is advised.

Dimensions and Quality

1. Sheathing foils (thickness 0.2 mm):

This foil is available in widths from 20 mm to 260 mm in 2 mm steps.

If special widths (up to 1.300 mm) are required, please contact **Dekodur®**.

The foil can be coated on the reverse side with hot melt glue. For this material the maximum width is 160 mm. The standard length of the rolls coated or not, is 200 running meters.

Special lengths are available if required.

The spread of the hot melt glue is ca. 170 g/m².

The tolerance in thickness is ± 0.03 mm.

2. Edge banding material (thickness 0.4 mm):

This laminate is available in widths from 20 mm to 260 mm in 2 mm steps.

If special widths are required direct contact with **Dekodur®** is advisable.

The foil can be coated on the reverse side with hot melt glue. For this material the maximum width is 160 mm. The standard length of the rolls coated or not, is 200 running meters.

Special lengths are available is required.

The spread of the hot melt glue is ca. 170 g/m².

The tolerance in thickness is ± 0.05 mm.

3. Endless laminate (thickness 0.4 mm):

The width of this product is 1.300 mm, with a tolerance of $- 0$ mm / $+ 0.05$ mm.

The tolerance in thickness is ± 0.05 mm.

Endless laminates can be supplied either on rolls or formatted in lengths of 1200 mm to 5400 mm.

A thicker endless laminate and also a thicker edge banding material is possible. Direct contact with **Dekodur®** is advisable.

Behaviour in case of fire – the standard quality is classified as B2 – B1 when tested according to DIN 4102. This quality is certified by Lloyd's Register and fulfils the requirements of IMO FTC.

A protective foil is absolutely necessary. This foil must be removed after 6 month at the latest, as by later removal the aluminium surface could be damaged.

The *dekofoil* range of products are produced in post forming quality.

The post forming of *dekofoil* can be carried out using stationary or continuously forming machines. Bonding o *dekofoil* to the substrate is carried out using dispersion glues (PVAc) or heat sensitive glues. The sheathing foil is bonded mainly with PU glues using profile sheathing machines.

Here radii of 2 mm can be obtained.

Application and Processing

Dekofoil is intended for use as decorative vertical surfaces, which are exposed only to light wear, in interior application. *Dekofoil* can also be used fro horizontal surfaces which are not exposed to heavy wear.

Typical applications are: wall cladding, ceiling cladding, fronts of drawers, signs for shops and firms, shelve cladding.

Typical applications for the sheathing foils are profiled objects for kitchens also as edging material.

The *dekofoil* laminates can be sawed, routed and drilled using carbide tipped tools.

Caution to be taken when bonding *dekofoil* in surface presses:

Maximum temperature 60°C
Press pressure 0.15 – 0.20 N/mm² (1.5 – 2.0 bar)
Soft cushioning between laminate surface and press plates.

All standard commercial glues which can be used for bonding standard high pressure laminates can be used.

Glue types: dispersion glues (PVAc)
 condensation resin glues (Urea resin)
 contact glues
 2 component glues
 hot melt glues

When PU glues are used great care mist be taken that glue residues are completely removed from the surface before they harden.

With elements, a symmetric construction is necessary. This is obtained by the use of a suitable balancing sheet which must be bonded to the reverse side. A flat element can be obtained by using a foil of the same type in 2nd quality.

Cleaning and Maintenance

Cleaning the surface of the *dekofoil* sheet is best carried out using a clean cloth, or soft sponge using soap and plenty of water or a glass cleaner.

Abrasive cleaners, acids or alkalise should never be used.

Storage

Dekofoil should be stored in a closed room with a temperature of 18-25°C and 50-60% relative humidity. Furthermore, they have to be stored within a distance of 200 mm to the ground.

Dekofoil

- is to be protected from moisture
- should not be exposed to direct sunlight
- should not be stored in a warm-air-stream

Formatted endless laminate should be stored horizontally and full-laminar with a distance the ground measuring a minimum of 200 mm.

Waste Disposal

Dekofoil waste can be **burnt** in officially accepted incinerators.

Dekofoil waste can also be disposed of in landfills in accordance with the local regulations.

The German authorities classify high pressure laminate waste as “other hardened plastic waste material”, which means that it is similar to household waste.

Should you have any further questions, please do not hesitate to contact our service department.

If you need samples, please contact Dekodur®.