Nevamar® ThruColor™ High Pressure Laminate (HPL) may be used in any application where a solid color edge is desired. ThruColor™ HPL is intended for use in applications where the edge of the laminate contributes to the aesthetics of the final product. The manufacturing process provides a second generation color-through laminate that is more flexible and much less likely to chip than other color-through laminate.

Due to its unique composition, ThruColor™ HPL will vary in color from corresponding colors of standard Nevamar® HPL. Sample evaluation is recommended.

**Product Composition**

ThruColor™ HPL is manufactured in a flat press by combining decorative papers saturated in melamine resin with multiple layers of pigmented core paper impregnated in a flexible thermoset resin at pressures exceeding 1000 psi (6.9 MPa) and temperatures approaching 300°F (150°C). The panels are trimmed to size and the backs are sanded to facilitate bonding. The thickness of the laminate is determined by the number of pigmented core layers used. The laminating process combines the durability of melamine resins with the aesthetics of decorative papers creating a more flexible color-through surfacing material than has been previously possible.

**Product Description**

**Standard Nominal Sizes**

<table>
<thead>
<tr>
<th>Type</th>
<th>Thickness*</th>
<th>Width**</th>
<th>Length</th>
<th>Colors***</th>
</tr>
</thead>
<tbody>
<tr>
<td>M01/M02 (in) (mm)</td>
<td>0.028 / 0.711</td>
<td>36, 48, 60 / 914, 1219, 1524</td>
<td>96, 120, 144 / 2438, 3048, 3658</td>
<td>Most Solids, Patterns and Woodgrains</td>
</tr>
<tr>
<td>M55/M56 (in) (mm)</td>
<td>0.050 / 1.3</td>
<td>36, 48, 60</td>
<td>96, 120, 144</td>
<td>Most Solids, Patterns Woodgrains</td>
</tr>
</tbody>
</table>

*Other thicknesses up to 1” (25 mm) are available.
**Other widths are available upon request.
***Due to its unique composition ThruColor™ HPL will vary in color from corresponding colors of standard Nevamar. Sample evaluation is recommended.

**Finish Options**

Please refer to HPL Finishes Chart on the web site to confirm available finishes for this product.

**Example of Fabricated ThruColor™ HPL Edges**

- Beveled Edge
- Wood Edge
- Smoothed Edge
- Pinstriped Edge
**Typical Uses**

ThruColor™ HPL is used in high-end furniture and casework applications where a solid color edge can be incorporated into the total design concept.

Solid color ThruColor™ HPL is ideal for high-wear applications since gouges and cuts will not readily show.

**Fabrication Tips**

When working with ThruColor™ HPL, these techniques will produce a quality application:

1. Proper conditioning of the laminate, substrate, and backing sheet minimizes possible warping, shrinking, or expansion of assembled panels. Ideally, all components should be conditioned at 70°F to 75°F (21°C to 25°C) and 45 to 50 percent relative humidity for 48-hours prior to assembly.

2. Always bond laminate to a suitable substrate such as medium to high density fiberboard, particleboard, or metals. It should not be glued directly to plaster walls, gypsum wallboard, or concrete.

3. For virtually invisible seams with ThruColor™ HPL, use a clear drying adhesive such as white glue (PVA) or clear epoxy.

4. The use of a backing sheet is recommended to minimize warpage. The thickness of the backing sheet should be relatively equal to the thickness of the decorative laminate on the face of the assembly.

5. All saw blades and router bits used for cutting should be carbide tipped. Feed rate should be slow and tool speed should be high.

6. Inside corners of cutouts for electrical outlets, sinks, etc., should have a minimum radius of 1/8" (3 mm) and be filed smooth. This reduces the likelihood of stress cracks.

7. All edges of laminate should be filed smooth with file direction towards substrate to help prevent stress cracks and to minimize chipping.

8. When fasteners are required, it is advisable to first drill an oversized hole through the laminate. This reduces the likelihood of stress cracks.

9. Two-inch edging strips can be wrapped around a 6" radius without heat. A radius of 3" can be achieved by heating the edging strip to 325°F (165°C).

10. All laminate is intended for interior use only, and should not be exposed to extreme humidity, continuous sunlight, or temperatures above 275°F (135°C) for extended periods of time.

11. Although ThruColor™ HPL is more flexible than other color-through laminates offered in the market, it is not as flexible as standard decorative laminate. Care should be used when rolling or flexing ThruColor™ laminate.

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**Technical Information**

**Physical Properties**

<table>
<thead>
<tr>
<th></th>
<th>NEMA LD 3-2005 TEST METHOD</th>
<th>TYPICAL THRU COLOR VALUES M55/M56</th>
<th>NEMA STD. HGS</th>
</tr>
</thead>
<tbody>
<tr>
<td>Thickness (in.)</td>
<td>0.050 ± 0.005</td>
<td>0.048 ± 0.005</td>
<td></td>
</tr>
<tr>
<td>Thickness (mm)</td>
<td>1.27 ± 0.08</td>
<td>1.2 ± 0.12</td>
<td></td>
</tr>
<tr>
<td>Appearance</td>
<td></td>
<td>Complies</td>
<td></td>
</tr>
<tr>
<td>Light Resistance</td>
<td>3.3</td>
<td>Slight effect</td>
<td>Slight effect</td>
</tr>
<tr>
<td>Cleanability</td>
<td>3.4</td>
<td>10</td>
<td>20 (max)</td>
</tr>
<tr>
<td></td>
<td></td>
<td>No effect</td>
<td>No effect</td>
</tr>
<tr>
<td></td>
<td></td>
<td>No effect</td>
<td>Moderate effect</td>
</tr>
<tr>
<td>Boiling Water Resistance</td>
<td></td>
<td>No effect</td>
<td>No effect</td>
</tr>
<tr>
<td>High Temperature Resistance</td>
<td></td>
<td>No effect</td>
<td>Slight effect</td>
</tr>
<tr>
<td>Ball Impact Resistance (in.)</td>
<td>3.8</td>
<td>55</td>
<td>50 (min.)</td>
</tr>
<tr>
<td></td>
<td>(mm)</td>
<td>1397</td>
<td>1250 (min.)</td>
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<tr>
<td>Radiant Heat Resistance (sec)</td>
<td>3.10</td>
<td>200</td>
<td>125 (min.)</td>
</tr>
<tr>
<td>Dimensional Change</td>
<td>3.11</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Machine Direction (%)</td>
<td>0.25</td>
<td>0.5 (max.)</td>
<td></td>
</tr>
<tr>
<td>Cross Direction (%)</td>
<td>0.70</td>
<td>0.9 (max.)</td>
<td></td>
</tr>
<tr>
<td>Wear Resistance (cycles)</td>
<td>3.13</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Solids</td>
<td>3500</td>
<td>400 (min.)</td>
<td></td>
</tr>
<tr>
<td>Patterns and Woodgrains</td>
<td>700</td>
<td>400 (min.)</td>
<td></td>
</tr>
</tbody>
</table>

*ThruColor™ HPL is not covered by ANSI/NEMA LD3 specifications; however, the physical properties are similar to the HGS grade.*
Codes and Certifications

1. The City of New York, Department of Building, Materials, and Equipment Acceptance Division Approval MEA 204-93-M for M55/M56.
2. ThruColor™ HPL can only be used for Class III or C fire rated applications.

Care and Maintenance

Nevamar® decorative laminate provides a durable surface that is easy to maintain using ordinary care.

To maintain the laminate’s lasting beauty, cleaning with a solution of warm water and liquid dishwashing detergent is all that should be required in most cases.

Stains may be removed with most non-abrasive household cleaners such as FORMULA 409®, GLASS PLUS®, or WINDEX® WITH AMMONIA D®. Light scrubbing with a soft bristled brush may be necessary to remove stains from the depth of the structure on some textured surfaces.

If the stain persists, use a paste of baking soda and water and apply with a soft bristled brush. Light scrubbing for 10-20 strokes should remove most stains. Although baking soda is a low abrasive, excessive scrubbing or exerting too much force may damage the decorative surface, especially if it has a gloss finish.

Stubborn stains that resist any of the above cleaning methods may require the use of undiluted household bleach. Apply the bleach to the stain and let stand no longer than 1 1/2 minutes. Rinse thoroughly with warm water and wipe dry. This step may be repeated if the stain appears to be going away and the color of the laminate has not been affected. WARNING: Prolonged exposure of the laminate surface to bleach will cause discoloration.

Many commercially available products contain substances that may damage or discolor a laminate surface. ABRASIVE CLEANERS SHOULD NOT BE USED. Particular care should be used with any products labeled CAUTION or WARNING. Any questions or concerns should be referred to the product’s manufacturer or call 1-877-726-6526. Do not allow harsh materials to remain in contact with the laminate surface. Examples of these are as follows:

- Toilet bowl cleaners
- Chlorine bleach
- Hydrogen Peroxide
- Coffee pot cleaners
- Oven cleaners
- Hard water stain removers
- Drain cleaners
- Fruit and berry juice
- Metal cleaners and polishes
- Tub and tile cleaners

Limited Warranty

Subject to the limitations set forth below, Panolam Industries International Inc. (Panolam) expressly warrants that our products are reasonably free of defects in material and workmanship, and when properly handled and fabricated will conform, within accepted tolerances, to applicable manufacturing specifications as set forth in our technical brochure. This warranty shall extend to the original buyer for a period of twelve (12) months from the date of shipment of this product by Panolam, and shall not be assignable by the original buyer. This warranty does not cover damage resulting from accident, misuse, alteration, abuse or lack of reasonable care.

Due to the variety of uses and applications to which this product may be put, and because the manufacturer has no control over the end products fabricated, the warranty set forth above is exclusive and in lieu of all warranties, expressed or implied, in fact or by operation of law or otherwise, or arising by course of dealing or performance, custom or usage in the trade, including, without limitation, the implied warranties of fitness for a particular purpose and merchantability, and Panolam shall have no obligation or liability to any person or entity in connection with or arising from the furnishing, sale, installation or repair, use or subsequent sale of any product supplied by it.

Formula 409 is a registered trademark for The Clorox Company of Oakland, CA 94612; Glass Plus is a registered trademark for The Dow Chemical Company of Indianapolis, IN 46268-0511; Windex is a registered trademark for S.C. Johnson & Sons INC. of Racine, WI 53403-501
Our maximum liability arising out of the sale of the products or their use, whether based upon warranty, contract, tort or otherwise, shall not exceed the actual payments received by us in connection therewith.

In no event shall we be liable for special, incidental or consequential damages, including, but not limited to, arising hereunder or from the loss of profits, or loss of use damages, sales of the products.

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