

Flawless™ High Pressure Laminate



Flawless Laminate is designed for vertical and horizontal applications where high impact and a durable, decorative surface is required.

Product Description

High pressure laminate is manufactured in a flat press by combining decorative papers saturated in melamine resin with phenolic-impregnated kraft layers 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 kraft layers used. The laminating process combines the durability of melamine resins with the aesthetics of decorative papers creating a surfacing material that has been the standard for many years.

Product Description

Standard Nominal Size

Type	Thickness	Width	Length
PK37 (in.)	0.030	48	96, 120,
(mm)	0.762	1219	2438, 3048

Finish Options

Flawless Laminate is offered as Flawless (ST) finish type. Please refer to HPL Finishes Chart on the web site.

Typical Uses

Flawless Laminate is suitable on countertops, desktops, vanities, interior doors, cabinets, contract furniture, retail store fixture, and hospitality. Flawless Laminate is a non-postformable HPL.

Fabrication Tips

When working with Flawless Laminate, 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. Recommended adhesives include solvent or water-based contact cement, white glue (PVA), epoxy, and hot melt glue. Consult your adhesive supplier for specific application requirements.
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. All edges of laminate should be filed smooth with file direction towards substrate to help prevent stress cracks and to minimize chipping.
7. 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.
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. 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.

Technical Information

Physical Properties

TEST		NEMA LD 3-2005 TEST METHOD	TYPICAL FLAWLESS VALUES PK37	NEMA STD. VGF
Appearance		3.1	Complies	
Light Resistance		3.3	Slight Effect	Slight Effect
Cleanability		3.4	13	20 (max.)
Stain 1 - 10			No Effect	No Effect
Stain 11 - 15			Slight Effect	Moderate Effect
Boiling Water Resistance		3.5	No Effect	No Effect
Hight Temperature Resistance		3.6	No Effect	Slight Effect
Ball Impact Resistance	(in.)	3.8	36	20 (min.)
	(mm)		914	900 (min.)
Radiant Heat Resistance	(sec.)	3.10	94	TBD
Dimensional Change		3.11		
Machine Direction	(%)		0.10	0.60 (max.)
Cross Direction	(%)		0.50	1.0 (max.)
Room Temperature		3.12		
Dimensional Stability				
Machine Direction	(%)		0.09	0.6 (max.)
Cross Direction	(%)		0.14	1.0 (max.)
Wear Resistance	(cycles)	3.13	600	400 (min.)

Fire Test Data

High pressure laminate is frequently used in installations governed by local fire codes. Listed below are typical flame spread index and smoke developed values for Flawless Laminate.

ASTM E-84/UL723

“Standard Test Method for Surface Burning Characteristics of Building Materials”

Type	Sample Configuration	Flame Spread Index	Smoke Developed Value
PK37	Unbonded	45	15

Codes and Certifications

1. Meets SEFA 8-PL testing requirements.
2. Greenguard certified.

Care and Maintenance

Flawless 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.

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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