

SURFACES

All types of surfaces are strong and easy to clean. When choosing a surface please consider where it is going to be used. E.g. scratches can be seen clearly on a soft matt surface.

Soft matt (A)

An attractive surface for furniture solution.

Silk (LP)

An attractive surface that highlights the depth of the colours. Meanwhile the surface is particularly cleanable.

Matt (B)

Provides a surface similar to linoleum.

Grained (W)

Provides the laminate with a pore structure that resembles the natural markings.

SHINE VALUES for Etronit-M surface types according to ISO 2813:

Surface	Reflection in % by 60 gr.
A	10,00
LP	18,00
B	6,00
W	11,00

TRANSPORTATION AND STORAGE

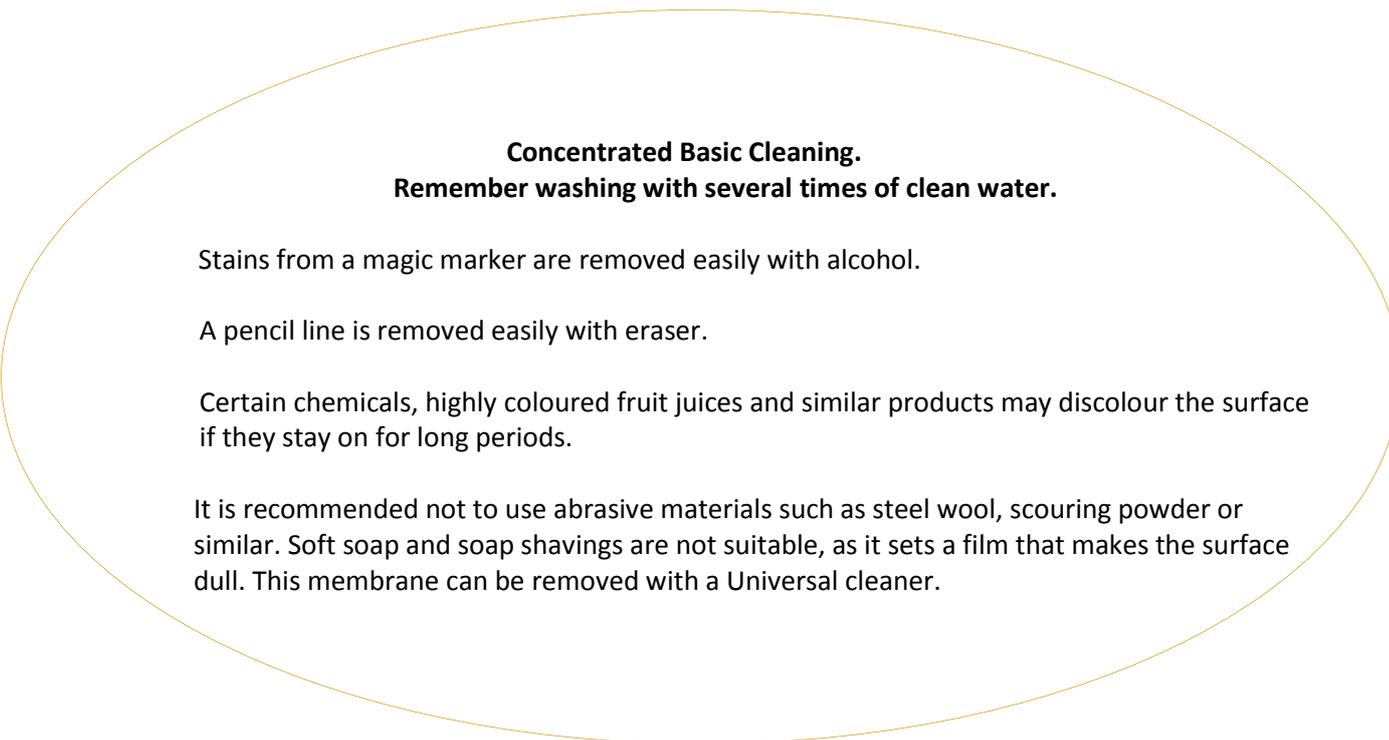
Keep Etronit-M dry until needed – best kept in the original packaging. In addition the laminate must lie flat with good support – also during transport. The decorative surfaces/covers should preferably face each other. Laminate sheets should never be placed vertically without support.

MAINTENANCE AND CLEANING

Etronit-M usually requires no special maintenance. The laminate is cleaned at normal use with a Universal cleaner dissolved in hot water. For difficult stains applied concentrated cleaner or dishwashing liquid, then wipe with a damp cloth and probably several times with clean water.

If using aggressive cleaning agents then test on an inconspicuous place as these may cause discolouration. After cleaning please wash with clean water several times.

We have good experience using Universal and Basic Cleaning from Elite Environmental A/S Products, Horsens, Phone +45 70 15 48 00.



Concentrated Basic Cleaning. Remember washing with several times of clean water.

Stains from a magic marker are removed easily with alcohol.

A pencil line is removed easily with eraser.

Certain chemicals, highly coloured fruit juices and similar products may discolour the surface if they stay on for long periods.

It is recommended not to use abrasive materials such as steel wool, scouring powder or similar. Soft soap and soap shavings are not suitable, as it sets a film that makes the surface dull. This membrane can be removed with a Universal cleaner.

Common to all Etronit-M laminates is that their resistance to a variety of chemicals have been tested. Detailed test list can be obtained.

MACHINING

Etronit-M can easily be processed with equipment designed for woodworking. For the best results it is recommended to use only tools with carbide inserts.

Sawing the Etronit-M

Manuel sawing with a circular saw produces the best results, if the laminate is sawed from the decorative side. Use a fine-toothed blade with carbide inserts. The cutting angle should be as small as possible. Peripheral speed of about 30-50 m/s.

Mechanical sawing is performed best with a blade by approx. 1 tooth per 8-9 mm and min. 2 mm thickness to avoid vibrations. Turn the decorative side up and cut with a feed speed of 6-15 m/min. Peripheral speed of about 50-100 m/s.

Jigsaw can also be used. Choose a saw blade for plastic and cut with the decorative side down. Grind the edge after the machining.

Drilling the Etronit-M

We recommend using a HSS drills with a point angle of 60-80 gr. and large increase, so cuttings are rapidly removed from the hole

When drilling through use a backstop on the back to avoid the laminate to shatter. When drilling holes for subsequent threading they must be predrilled by tables for thread-cutting steel. Through holes for mounting should be 1-2 mm larger than the nail or screw diameter, to avoid creating tension in the material.

Milling the Etronit-M

When milling we recommend using an end mill with 2 or more inserts of carbide, which runs at 10-14000 rpm / min., otherwise low feed rate.

Safety and Environment

Dust of any kind can cause discomfort in the airways.
There must be good ventilation during machining.
Not aligned edges are very sharp.

So beware!

BONDING

Bonding to other carrier materials is not a problem if the following basic rules are observed:

The laminate should be acclimated to the substrate.

A backing must be used by gluing.

The backing may be a similar high-pressure laminate or a counter plate.

When hot bonding is used please avoid rapid cooling, because it may cause curved plates.

Front and rear must be uniform oriented, i.e. with grinding tracks in the same direction for the sake of material nature.

Bonding should be done in a press that covers the entire bonded area at one time.

When bonding on hard surfaces there are often used PVA glue that can be used for both cold and hot pressing.

When bonding to porous and absorbent substrates it is preferred to use foaming glue-type polyurethane.

Bonding laminate on a metal surface, or other non-absorbent surface remember to use an epoxy- or 2-component polyurethane adhesive.

Glue

Press force, curing times and temperatures are individual for each type of glue.

Follow the glue suppliers technical and safety data sheets.