

## Technical data

### Duropal HPL Compact Individual, black core

Compact high-pressure laminate of standard quality with individual digital printed motifs based on EN 438-4:CGS. With uniform black-coloured core and white reverse.



Specification							Unit	Standard
<b>Nominal thickness</b>	<b>2</b>	<b>3</b>	<b>4</b>	<b>5</b>	<b>6</b>	<b>7</b>	<b>mm</b>	
Tolerance on thickness	± 0.2	± 0.3	± 0.3	± 0.4	± 0.4	± 0.4	mm	EN 438-2:2016
Tolerance on length				+ 10			mm	EN 438-2:2016
Tolerance on width				+ 10			mm	EN 438-2:2016
Surface defects				max. 1 <sup>1)</sup> max. 10 <sup>2)</sup>			mm <sup>2</sup> /m <sup>2</sup> mm <sup>2</sup> /m <sup>2</sup>	EN 438-4:2016
Edge defects				max. 3			mm	EN 438-4:2016
Straightness of edges				max. 1.5			mm/m	EN 438-2:2016
Squareness				max. 1.5			mm/m	EN 438-2:2016
Flatness	max. 8	max. 8	max. 8	max. 8	max. 5	max. 5	mm/m	EN 438-2:2016
Density				min. 1,350			kg/m <sup>3</sup>	EN ISO 1183-1
Bending strength				min. 80			MPa	EN ISO 178
Flexural modulus				min. 9,000			MPa	EN ISO 178
Resistance to crazing				min. 3			rating	EN 438-2:2016
Dimensional stability at elevated temperature (length)	max. 0.4	max. 0.4	max. 0.4	max. 0.3	max. 0.3	max. 0.3	%	EN 438-2:2016
Dimensional stability at elevated temperature (width)	max. 0.8	max. 0.8	max. 0.8	max. 0.6	max. 0.6	max. 0.6	%	EN 438-2:2016
Resistance to wet heat, 100 °C (smooth finishes)				min. 3			rating	EN 438-2:2016
Resistance to wet heat, 100 °C (textured finishes)				min. 3			rating	EN 438-2:2016
Resistance to dry heat, 160 °C (smooth finishes)				min. 3			rating	EN 438-2:2016
Resistance to dry heat, 160 °C (textured finishes)				min. 3			rating	EN 438-2:2016
Resistance to water vapour (smooth finishes)				min. 1			rating	EN 438-2:2016
Resistance to water vapour (textured finishes)				min. 1			rating	EN 438-2:2016
Resistance to immersion in boiling water (smooth finishes)				min. 1			rating	EN 438-2:2016
Resistance to immersion in boiling water (textured finishes)				min. 1			rating	EN 438-2:2016
Resistance to immersion in boiling water (edge)				min. 3			rating	EN 438-2:2016
Resistance to immersion in boiling water	max. 5 <sup>3)</sup> max. 6 <sup>4)</sup>	max. 5 <sup>3)</sup> max. 6 <sup>4)</sup>	max. 5 <sup>3)</sup> max. 6 <sup>4)</sup>	max. 2 <sup>3) 4)</sup>	max. 2 <sup>3) 4)</sup>	max. 2 <sup>3) 4)</sup>	%	EN 438-2:2016
Resistance to surface wear				min. 50			cycles	EN 438-2:2016
Resistance to scratching (smooth finishes)				min. 2			rating	EN 438-2:2016
Resistance to scratching (textured finishes)				min. 3			rating	EN 438-2:2016
Resistance to impact by large diameter ball – impression diameter				max. 10			mm	EN 438-2:2016

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Resistance to impact by large diameter ball - Fall height	min. 1,400	min. 1,400	min. 1,400	min. 1,400	min. 1,800	min. 1,800	mm	EN 438-2:2016
Stain resistance (groups 1 & 2)	min. 5						rating	EN 438-2:2016
Stain resistance (group 3)	min. 4						rating	EN 438-2:2016
Resistance to colour change (xenon arc light)	4 to 5 Grey Scale Grade							EN 438-2:2016
Reaction to fire	normally flammable							
Reaction to fire (Euroclass)	not classified	not classified	not classified	not classified	D-s2,d0	D-s2,d0		EN 13501-1, CWFT acc. to 2003/593/EG
Formaldehyde emission class	E1							EN 717-1

- 1) Dirt, spots and similar surface defects  
 2) Fibres, hairs and scratches  
 3) Mass increase  
 4) Thickness increase

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Specification							Unit	Standard
<b>Nominal thickness</b>	<b>8</b>	<b>9</b>	<b>10</b>	<b>12</b>	<b>13</b>	<b>15</b>	<b>mm</b>	
Tolerance on thickness	± 0.5	± 0.5	± 0.5	± 0.6	± 0.6	± 0.6	mm	EN 438-2:2016
Tolerance on length				+ 10			mm	EN 438-2:2016
Tolerance on width				+ 10			mm	EN 438-2:2016
Surface defects			max. 1 <sup>1)</sup> max. 10 <sup>2)</sup>				mm <sup>2</sup> /m <sup>2</sup> mm/m <sup>2</sup>	EN 438-4:2016
Edge defects			max. 3				mm	EN 438-4:2016
Straightness of edges			max. 1.5				mm/m	EN 438-2:2016
Squareness			max. 1.5				mm/m	EN 438-2:2016
Flatness	max. 5	max. 5	max. 3	max. 3	max. 3	max. 3	mm/m	EN 438-2:2016
Density			min. 1,350				kg/m <sup>3</sup>	EN ISO 1183-1
Bending strength			min. 80				MPa	EN ISO 178
Flexural modulus			min. 9,000				MPa	EN ISO 178
Resistance to crazing			min. 3				rating	EN 438-2:2016
Dimensional stability at elevated temperature (length)			max. 0.3				%	EN 438-2:2016
Dimensional stability at elevated temperature (width)			max. 0.6				%	EN 438-2:2016
Resistance to wet heat, 100 °C (smooth finishes)			min. 3				rating	EN 438-2:2016
Resistance to wet heat, 100 °C (textured finishes)			min. 3				rating	EN 438-2:2016
Resistance to dry heat, 160 °C (smooth finishes)			min. 3				rating	EN 438-2:2016
Resistance to dry heat, 160 °C (textured finishes)			min. 3				rating	EN 438-2:2016
Resistance to water vapour (smooth finishes)			min. 1				rating	EN 438-2:2016
Resistance to water vapour (textured finishes)			min. 1				rating	EN 438-2:2016
Resistance to immersion in boiling water (smooth finishes)			min. 1				rating	EN 438-2:2016
Resistance to immersion in boiling water (textured finishes)			min. 1				rating	EN 438-2:2016
Resistance to immersion in boiling water (edge)			min. 3				rating	EN 438-2:2016
Resistance to immersion in boiling water			max. 2 <sup>3) 4)</sup>				%	EN 438-2:2016
Resistance to surface wear			min. 50				cycles	EN 438-2:2016
Resistance to scratching (smooth finishes)			min. 2				rating	EN 438-2:2016
Resistance to scratching (textured finishes)			min. 3				rating	EN 438-2:2016
Resistance to impact by large diameter ball – impression diameter			max. 10				mm	EN 438-2:2016

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Resistance to impact by large diameter ball - Fall height	min. 1,800						mm	EN 438-2:2016
Stain resistance (groups 1 & 2)	min. 5						rating	EN 438-2:2016
Stain resistance (group 3)	min. 4						rating	EN 438-2:2016
Resistance to colour change (xenon arc light)	4 to 5 Grey Scale Grade							EN 438-2:2016
Reaction to fire	normally flammable							
Reaction to fire (Euroclass)	D-s2,d0							EN 13501-1, CWFT acc. to 2003/593/EG
Formaldehyde emission class	E1							EN 717-1

- 1) Dirt, spots and similar surface defects  
 2) Fibres, hairs and scratches  
 3) Mass increase  
 4) Thickness increase

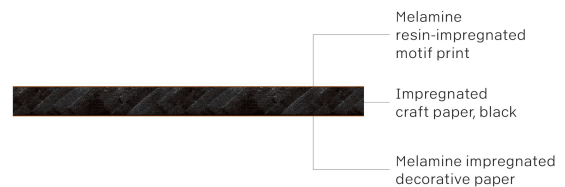
#### Additional information

Product standard	<ul style="list-style-type: none"> <li>produced acc. to EN 438-4</li> </ul>
Areas of application	<ul style="list-style-type: none"> <li>Individual furniture and interior design elements, particularly where high demands are made on the durability, ease of care and moisture resistance of the material. But also when low material cross-sections or open edge solutions are required. Such as in the restaurant sector, in shop fitting and in food sensitive areas, in doctors' surgeries and clinics, leisure and sanitary areas. The material is not suitable for use outdoors.</li> </ul>
Core material	<ul style="list-style-type: none"> <li>Compact laminate black</li> <li>Solid, black pigmented compact laminate core, impact resistant and moisture resistant for applications with high specification demands.</li> </ul>
Product safety	<ul style="list-style-type: none"> <li>The surface is physiologically safe, and approved for direct contact with food acc. to Regulation (EU) No. 10/2011.</li> <li>We manufacture the panels without the use of halogens, heavy metals, preservatives, wood protectors or organic solvents.</li> <li>This product follows the REACH regulation EC 1907/2006 an article. Following Article 7 it does not need to be registered.</li> </ul>

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#### Special

- Certificate Blue Angel - Ecolabel (RAL DE-UZ 76)
- FSC®-certification (license code: FSC-C011773) or PEFC-certification (license code: PEFC/04-32-0828) - available on request.
- Maximum motif format per board, incl. overprinting: 2,750 mm x 2,030 mm. Larger motifs can be tiled.
- Standard delivery without protective film.
- Cut to size is not available.
- Colour differences can occur in follow-up production lots.
- No guarantee of stability can be given for uneven constructions.
- Assignment of the motifs parallel with the edge of the coreboard is not possible for production reasons.
- Depending on the decor and surface texture, slightly different surface visual impressions can result between cut panels viewed from different angles. This is a result of the production methods and does not constitute a quality defect.
- Because for production technical reasons there can be slight colour variations of the coloured core.
- Please consider that digital printed laminates are, because of their material composition, slightly harder and more brittle than classical laminates.
- The decorative surface and the core consists of paper layers that are impregnated with thermosetting resins. The resins harden completely during the manufacturing process by heat and high pressure. They form a stable, resistant and non-reactive material.

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