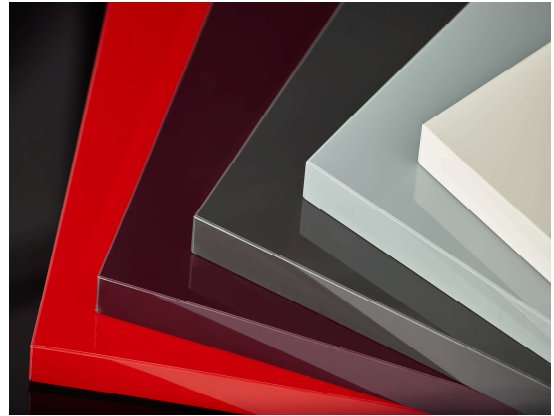


High gloss boards Acrylux II - HIPs

A high gloss coextruded ABS / PMMA sheet is laminated onto a coated wood-based panel. The extremely acrylic layer is a key feature of this product. The maximum coating width is 1300 mm and the maximum panel length 2800 mm. A protective film is applied to the coating material to protect it against scratches. In addition to supplying panel goods for customer processing, we also offer finished items with edging in matching and contrasting colors.



Standard dimensions:

Dimensions	
Dimensions:	2800x1300mm
Thickness:	17,95 - 19,25 mm Coated on one side
Weight:	13,5 kg/m ² Tolerance 10%
Thickness of acryl:	0,5 – 0,8 mm (depending of the colour) + protective film

Other dimensions on request!

Properties:

Mechanical properties	Testing standard	Unit	Class / value
Chemical stress	DIN EN 68861 T1	Level	1B
Resistance for micro scratches	IHD-W-466	Methode A	Class 1 Gloss loss <20%
Steel wool test	QPA-25-LT	Pressure: 1kg Revolutions: 20 Steel wool: 00	Class 1 No visible changes nor scratches
Dry heat	DIN EN 68861 T7	Level [°C]	7D, 75°C
Moist heat	DIN EN 68861 T8	Level [°C]	8B, 70°C
Light fastness	EN ISO 4892-2 Total color change after 200h Xenon Test		DE* <1,7
Gloss level	DIN 67530 at 60°	GLE	>85 Gloss - gloss <5 Gloss - mat

Balancing laminate HIPs properties:

Charakteristics		Value	Unit	Test method
PHYSICAL PROPERTIES				
Density	23 C	1,05	g/cm ³	ISO 1183-1
MECHANICAL PROPERTIES				
Tensile E-Modulus	23 C	2540	Mpa	ISO 527
Yield stress	23 C	28	Mpa	ISO 527
Elongation at break	23 C	74	%	ISO 527
THERMAL PROPERTIES				
Vicat B/50	50N / 50K/h	88	C	ISO 306
HDT-A	1,82 Mpa	74	C	ISO 75
OPTICAL PROPERTIES				
Top surface gloss	(60 gloss master)	2,3	GLE	DIN 67530
	(85 gloss master)	3,1	GLE	DIN 67530
BURNING BEHAVIOUR				
Flammability classification		HB		UL 94
		HB		ISO 1210
MISCELLANEOUS PROPERTIES				
Moulding shrinkage		0,5	%	DIVERSE TEST METHOD
Thermoforming temperature range		≥ 120 ≤ 165	C	DIVERSE TEST METHOD

Tolerances	Panels		
Substrate	< 15 mm	15 - 20 mm	> 20 mm
Thickness	± 0.5 mm		
Length and width	± 5.0 mm		
Distortion length/width	Concave: 1.5 mm/m convex : 1.5 mm/m		
	Carriers <16 mm may have higher levels of distortion		
Edge defects	≤ 10 mm		

Thickness tolerance = nominal size + 0.2 mm (film + adhesive) ± tolerance

Warranty and Liability:

The claims will be honored only if reason to it are faulty gluing of acrylic sheet to substrate board, air bubbles or foreign objects between sheet and board (which cause uneven spots which exceeds the norms). Claims which are results of faulty substrate material (acrylic and MDF boards) will be honored only after positive recognition by a manufacturer.

According to international norms the board surface is allowed to have small flaws which are not exceeding 2mm² per each m² of board. Flaws in such number are not reason to claim.

Production process in our facility are almost fully automatic with focus on clean production environment and quality control. It is not possible for board with visible mechanical damage to leave production line and be packed on a pallet. The claims for mechanical damages of boards inside of originally packed pallets will not be honored.

Boards are secured with protective foam. Foam must stay on the board during all handling and transport operations.

Acrylic boards might be scratched if handled carelessly or used in improper way. The damages and flaws which are made by normal usage of material over time or improper use of material are not reason to a claim.

Warranty claims shall become statute-barred, including in the case of hidden defects, within one year from delivery. If a consumer makes justified warranty claims within the statutory period applicable to him and our customer then takes recourse against us as a link in the supply chain, we shall be liable for the warranty claims as provided by law.

Surface property	Panels
Scratches	The named properties are assessed in accordance with DIN EN 14322 and DIN EN 438-1
Contrasting points	
blisters, indentations, filings under the film	
Pressure points	Tiny scratch marks that can be seen in sunlight and under halogen light are due to the high gloss effect, and are not a surface defect.
Blisters	
Distance of observation and light source as per DIN EN 14323 in the current version! The current versions of the relevant standards of guidelines for the particular materials will apply where alternative criteria are not further specified!	
Shade	Minor variations in line with standard commercial tolerances may occur as the result of irregularities in the coating papers and the type of carrier used Permitted variations: White and light colours: Delta E ≤ 0.5 Medium colours: Delta E ≤ 0.8 Dark colours: Delta E ≤ 1.5
Larger variations are permitted on pearlescent and metallic decors	
Due to the differing shape and size of the metallic pigments used, colour effects ranging from light to dark and iridescent may occur depending on the angle of light and the angle of observation. This is part of the charm of metallic decors, and does not constitute grounds for complaint.	

According to our terms and delivery conditions a 3% of boards with more exposed defects then stated above need to be accepted. With that we comply to the European norm of chipboard and MDF manufacturers.

Cleaning recommendations:

To clean the surfaces, all you need is a soft cloth and warm water with a few drops of detergent. It is important to wipe the item dry with a soft cloth.

Stains, particularly those caused by strongly dyed substances and liquids, as well as splashes of fat etc., must be removed with plenty of water, if necessary adding a quantity of ordinary, non-abrasive household cleaner. After cleaning, remove any soap residue with lukewarm water and rub dry with a soft cloth. Stains should not be allowed to dry. It may no longer be possible to remove dried-on substances or substances that have been allowed to penetrate over a prolonged period of time.

Treating an Acrylux surface with solvent-based cleaning products may result in stress that could, over the long term, cause minor, almost invisible cracks and tears. These fronts should only be cleaned with soap-and-water and a soft cloth. Tiny scratches can be polished out with "ULTRA GLOSS Superpolish".

For this reason, do not apply any abrasives, furniture polish, floor wax, cellulose and synthetic-resin thinners, acetone or similar cleaning products. Do not use steel wool or sponge scourers either!

Packing and postage:

Compound elements are usually supplied with foam sheets between the layers. Items are delivered on disposable pallets. The finished stacks are wrapped in stretch film to protect them against dirt and moisture.

Other packaging may be agreed on enquiry!

Over / under deliveries

Over / under deliveries of 10% per item for technical reasons are permitted.

General information:

Compound materials are used in decorative interior design and furniture construction. Panels are to be used in dry areas.

Careful checks of incoming goods are part of our excellent order processing sequence. They comply with the Terms and Conditions of Niemann-Möbelteile. Compound panels must be transported and stored carefully. If necessary, storage may be on a level, horizontal, dry base. In order to prevent the edges from swelling and the panels from distorting in moisture, they should be stored in a closed building. The panels should not be stored at temperatures under 15°C for long periods of time. This may result in irreversible damage (distortion) to the compound. Relative humidity should be between 45 and 65%

This information is based on current knowledge and does not provide any assurance of product qualities.

It is merely intended for guidance and provides no assurance of specific product qualities or suitability for a particular use. The user must always make sure that the products we manufacture are suitable for the purpose they are to be used for. This applies when sampling a product for the first time as well as in the event of changes in ongoing production. As we have no influence on our suppliers' materials and processing conditions, this information cannot give rise to any liability on our part. The recipient of our product is responsible for observing the laws and regulations in force. Subject to technical change without notice.

Our general terms of sale and delivery apply.