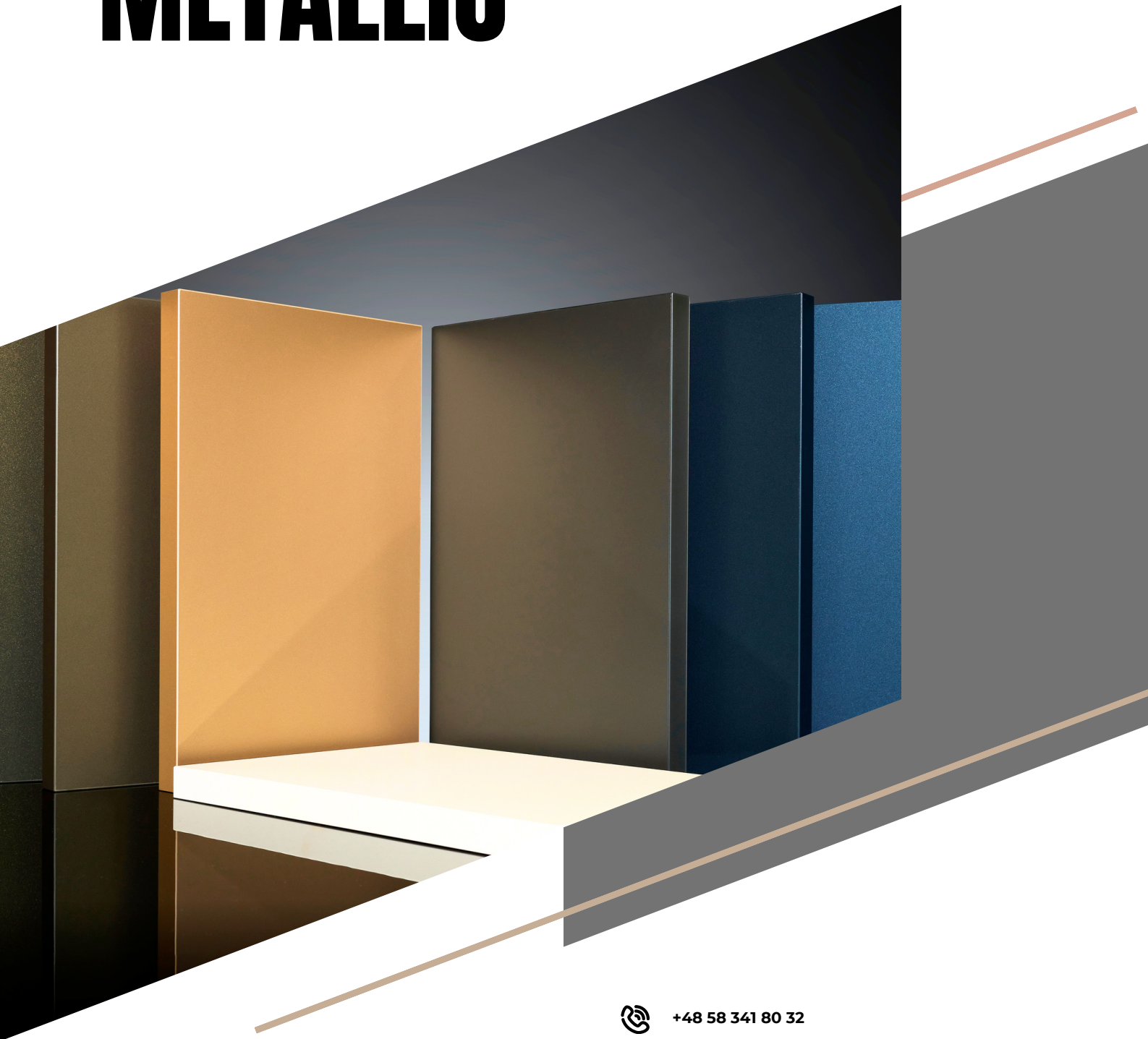


# PET MATTE METALLIC



## TECHNICAL SPECIFICATIONS



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## Technical Specifications PET Metallic Matte

Furniture panels with a Polyethylene terephthalate (PET) Metallic Matte surface.

Polyethylene terephthalate (PET) laminate, 0.3 mm thick, is applied to the board with (in accordance with customer choice) :

- (1) Raw MDF backside coated with white, 0.40 mm thick PP laminate
- (2) Raw MDF backside coated with white 0.2 mm thick PP laminate \*
- (3) Double-sided White melamine MDF (Premium variant)
- (4) White lacquered MDF single-sided (ECO variant)\*\*

\* other colors available by request

\*\* do not use in places with high humidity

The very high quality PET coating is key to this product. The maximum width of the board we can obtain is 1300 mm and the maximum length is 2800 mm. PET Metallic Matte laminate coating has much higher chemical, scratch and UV resistance. The boards are additionally covered with a protective film, which significantly reduces the likelihood of damage during production and assembly of furniture elements.

### Standard Dimensions:

	Dimensions			
	(1)	(2)	(3)	(4)
<b>Panel Variant</b>	MDF + PP (0,4 mm)	MDF+ PP(0,2 mm)	melamine MDF	Lacquer MDF
<b>Dimensions</b>	2800 x 1300 mm*	2800x1300 mm*	2800x1300 mm*	2800x1300 / 2800x1250 mm*
<b>Substrate Thickness</b>	17 / 18 mm	17 / 18 mm	18 mm	16 / 18 mm
<b>PET Base Film</b>	0,3 mm + protective foil thickness			

Other dimensions available by request.

### PET Laminate Properties :

Property	Examination acc. To.	Requirement: nit	Class/ Value
<b>Chemical Resistance</b>	DIN 68861/1	DIN 68930	1C
<b>Resistance</b>	DIN 68861/4	DIN 68931	4E
<b>Temperature Resistance (Dry Test)</b>	DIN 68861-7	DIN 68931	100°C, 7C
<b>Cross cutting test</b>	DIN EN ISO 2409	Classification acc.to DIN EN ISO 2409	Characteristic value 0
<b>Color Fastness</b>	White		ΔE 0,5
	Achromatic colors (e.g. black, grey tones)		ΔE 0,8
	Intense colors (e.g. red, blue, yellow)		ΔE 1,0
<b>Gloss Level</b>	Surface dependent between 2 and 11 GU		



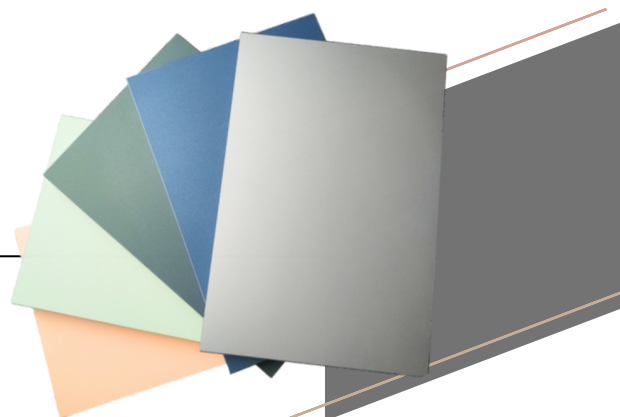
## PP 0,4 Balancing Laminate Properties:

Property	Norm	Unit	Specification
Thickness	PN-ISO 4593	μm	160-400 +/-7%
Width	PN-ISO 4592	mm	50 - 1400 +/- 2
Color		ΔE	≤1,0
Shearing Resistance	PN-ISO 6383	N/mm	w: >30 p:>90
Stretch Resistance	PN-EN ISO 527	Mpa	w:>16 p:>12
Elongation at break	PN-EN ISO 527	%	>300
Total phthalates content: DEHP, DINP, DNOP, DIDP, DBP, BBP, DIBP		%	No substance found (<0,1%)
The content of organic tin compounds:DOT, DBT, TBT,TPhT			No substance found (<0,1%)
Heavy metal content: PB,Cd		%	No substance found (<0,1%)
Bisphenol A content		(mg/kg)	No substance found (<0,1%)
Formaldehyde content		(mg/kg)	No substance found (<0,1%)

## PP 0,2 Laminate Properties:

Property	Norm	Unit	Specification
Thickness	PN-ISO 4593	mm	215 +/-7%
Width	PN-ISO 4592	mm	50 - 1400 +/- 2
Color		ΔE	≤1,0
Shearing Resistance	PN-ISO 6383	N/mm	w: >30 p:>90
Stretch Resistance	PN-EN ISO 527	Mpa	w:>16 p:>12
Elongation at break	PN-EN ISO 527	%	>300

\*Results apply to laminates without deep embossed mottle patterns (04). In the case of such a pattern, the strength parameters are determined individually. Laminates produced by the Cast method - from single colored polypropylene. The laminate is designed for indoor use, any deviation from the recommended applications should be supported by additional tests of resistance against the conditions in which the product would be used.

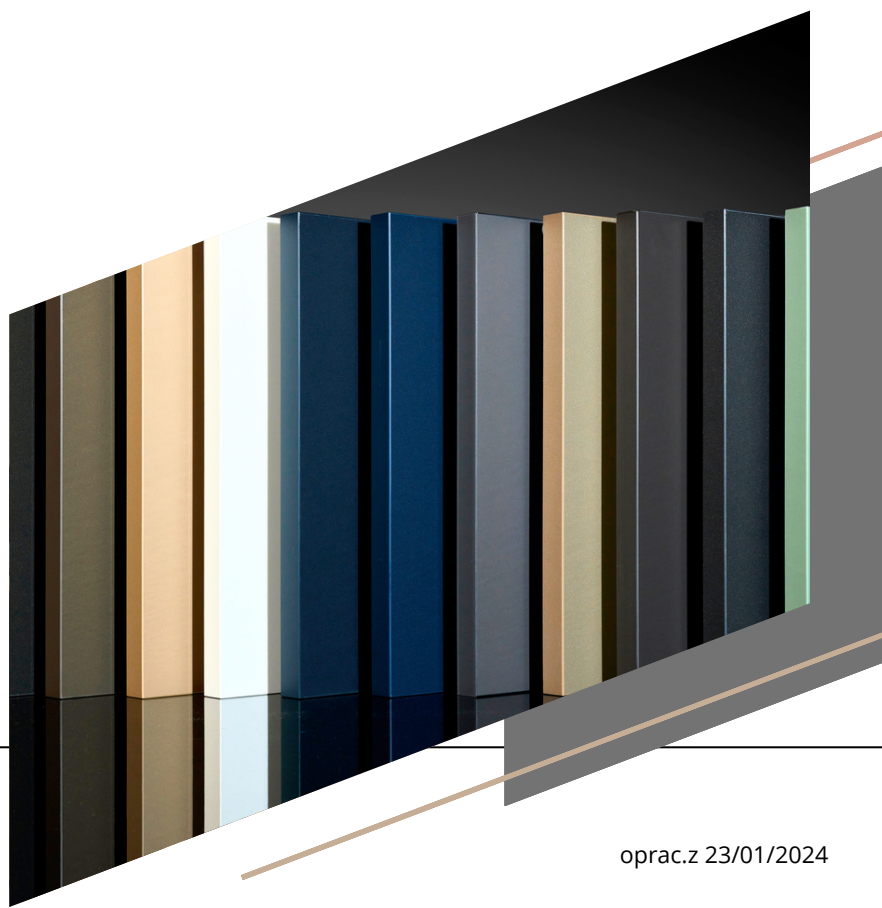


## Board Tolerances:

	Panels		
Substrate Board Dimension	< 15 mm	15 - 20 mm	> 20 mm
Thickness Tolerance	± 0.5 mm		
Length and Width Tolerance	± 5.0 mm		
Length- and Width-wise deformation	inward bending (concavity): 1.5mm/m, outward bending (bulging): 1.5mm/m, panels <16mm thick may have higher deformation values		
Edge Defects	≤ 10 mm From Panel Edge		
Final Product Thickness Tolerance	Nominal dimension + 0.2mm (foil + adhesive) ±Tolerance		

## Surface Properties:

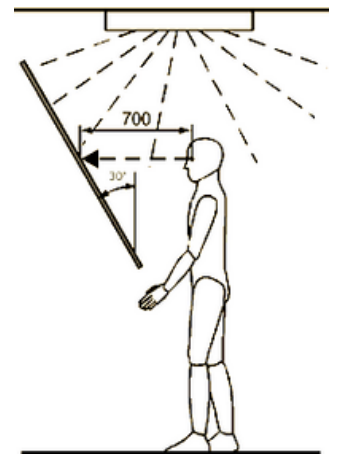
	Panels
Scratches	Listed surface properties are evaluated in accordance with PN EN 14322 and PN EN 438-1 norms
Contrasting Points	
Bubbles, Indentations, particles under f	
Pressure Marks	
Bubbles	Micro scratches, which may be visible in daylight or under halogen lighting, are a result of the high gloss effect and are not considered a defect
<b>Observation distance and light characteristics for quality control in accordance with the current PN EN 14323 standard*</b>	
Color Shade	Slight deviations (within the manufacturer's standard tolerance) may occur as a result of irregularities on the decor paper and the type of substrate used.
	<b>Color Tolerance:</b>
	White and Light Colors: Delta E ≤ 0.5
	Medium Intensity Colors: Delta E ≤ 0.8
	Dark Colors: Delta E ≤ 1.5
<b>Larger Deviations are Permissible with Reflective and Metallic Decors</b>	
Due to the different shape and size of the metallic pigment particles used in the production of the panels, the aperant color can vary from light to dark to iridescent depending on the angle of light and the angle of observation. This is an intentional element of metallic decors and is not grounds for complaint.	
When evaluating colors, the samples should first be subjected to 48h of daylight, due to the photochemical process taking place. This should always be done under the same conditions (same lighting, exposure time, etc.). The tested samples must not be exposed to direct sunlight.	





## Procedure for Product Evaluation:

- Panel position: static, vertical
- Light: fluorescent lamp at 6.500°K (Diffuse light or D65)
- Observation at an angle of 30° at a distance of 0,7 m
- Observation time: max 20 s



Panel evaluation should take place under a diffuse and fixed light source that illuminates the surface uniformly. This can be sunlight or adequate artificial lighting (between 2000-5000 lux). The approximate distance between the assessed surface and light source should be 1,5m. Surface defects will only be acknowledged if they are larger than 0,8mm<sup>2</sup> and visible from a distance of 0,7m at a viewing angle of approximately 45°.

It is within tolerance for 3% of a given shipment to have defects exceeding the standards given above, and does not constitute grounds for a claim. This tolerance is in accordance with the European standards for chipboard and MDF manufacturers. For technical reasons, deliveries have a permitted quantity tolerance of +/- 10%

General Information: The product is intended for use as a decorative material in interior design and furniture making. It should only be used in dry places. The boards must be transported and stored with the proper precautions. If necessary, they can be stored on top of each other on a level and horizontal surface in a dry place. The boards should be stored indoors to protect them from swelling and deformation caused by moisture. The boards should not be stored at temperatures below 15°C for long periods of time, as this may cause irreparable damage. The relative humidity of storage should be between 45% and 65%. Before processing, boards should be acclimated by storage for a period of min. 48h and under suitable conditions (temperature of 18-22 C and humidity of 30%-65%). Processing should also take place at room temperature. It should be noted that, especially in the colder periods of the year, it is necessary to acclimatize all boards. If, due to the number of boards in a stack, there is a risk of insufficient acclimatization of boards in the middle of the stack, the acclimatization period should be extended accordingly.