


lamitech *metallic lam*

TECHNICAL DATA SHEET

to ill^aminate

The desire to inspire

 **Lamitech**®
High Pressure Decorative Laminates.

product description

▶ product composition

Lamitech Metallic Lam is manufactured with aluminum sheets and Kraft paper with phenolic resin; as support for the laminate. These materials combination is subjected to a high specific pressure (100 kg/cm²) and temperature 275°F (135°C). Once the press cycle is finished, the laminate is trimmed following the established nominal dimensions and sanded to provide a greater adherence when the adhesive is applied over the wooden surface.



▶ recommended applications

Lamitech Metallic Lam is a real metal foil laminated to a phenolic core, which combines the fabrication efficiency of a high pressure decorative laminate with the pureness of real metal. Designed for dry interior vertical and light-duty horizontal interior applications such as retail facilities, restaurants, hotel and office lobbies, theaters, and where special accent is required.

▶ basic limitations

Lamitech Metallic Lam is designed for interior uses only, it is not ment to be structural material; it does not admit high humidity or high temperature, exceeding 158°F (70°C). *Lamitech Metallic Lam* should not be exposed to intense and continue sunlight. The *Metallic Lam* should not be post-formed; it should only be used in normal or straight applications. Due to the low surface resistance typical of a ductile material such as aluminum, *Lamitech Metallic Lam* tends to get scratched; therefore we recommend its use only for light duty applications. *Lamitech Metallic Lam* is always commercialized with a protecting film, that should only be removed once the application is finished to prevent the surface deterioration during its manipulation. Take a look at our collection for a better selection of the different colors and finishes as: *Brushed, Dots, Squares, Vertical Lines, Horizontal Lines* and *Waves*. Please contact our sales representatives for further assistance.

product identification

TYPE OF LAMINATE	LAMITECH® GRADE	NOMINAL THICKNESS	SIZES				FINISHES	
		mm (inch)	feet (ft)				Brush	Matte
			4 x 8	4 x 10	5 x 8	5 x 12		
			meters(mt)					
		1.22 x 2.44	1.22 x 3.06	1.53 x 2.44	1.53 x 3.66			
Horizontal Standard Metallic Lam	70	1.20 (0.048)	X	-	-	-	X	X
Horizontal Standard Metallic Lam	50	1.00 (0.039)	X	-	-	-	X	X
Vertical Standard Metallic Lam	30	0.70 (0.028)	X	-	-	-	X	X

► useful information

1. Conditioning and storing conditions of *Lamitech Metallic Lam* are very important, it should be stored horizontally, at a regular temperature (max. 86°F 30°C) and relative humidity (max. 60%), in a dry and drafty place.
2. For manual, low press applications of *Lamitech Metallic Lam*, use contact adhesive in a solvent/neoprene base. When it comes to industrial applications, we strongly recommend the use of PVA adhesive (Polyvinyl Acetate), it does not react with heat and also has a high humidity resistance. To get a good adherence, we suggest you to use 80-140 g/m² of adhesive and a 7-9 k/cm² pressure. In case of having any waste of adhesive in the laminate while finishing the application, remove it with a soft cloth and organic solvent or a mixture of 50:50 alcohol-organic solvents.
3. To avoid warping in the surface laminated a with *Lamitech High Pressure Lamitech Metallic Lam*, we recommend the use of backer laminate on the back side of the surface, in order to get the maximum humidity absorbed balance in the wooden substrate.
4. *Lamitech Metallic Lam* should be cut with circular saws at a 8-2 m/min. and 3.000-5.500 r.p.m. speed, the tooth of the saw must be done in plane trapezoidal diamond with

- alternating geometry. For routed jobs, a cylindrical miller of minimum 12,000 r.p.m. must be used.
5. To perforate *Lamitech Metallic Lam* use a tungsten-carbide drill bit with biangular end at 10.000 r.p.m.. The selected drill bit must be 0.002 in (0.05 mm.) bigger than the specific diameter of the hole to be made.
 6. For stain cleaning or maintenance of *Lamitech Metallic Lam*, use water, soft non-abrasive detergents and nylon brushes. Stubborn stains may require the use of hypochlorite bleach dissolved in water. Avoid the use of strong bleachers, organic detergents and abrasive brushes, these could discolor and scratch the surface. Grease stain should be cleaned with a soft cloth and organic solvent or a mixture of 50:50 alcohol-organic solvent, the laminate shall be free of stain without any deterioration of its colortone or its original design.
 7. *Lamitech Metallic Lam* offers a long lasting and an easy cleaning surface. For High Pressure applications we suggest you to ask for *Lamitech Metallic Lam* covered with protective film to prevent any scratch or stain on the surface of the laminate during transportation, handling and application - that can seriously affect the final properties on the surface of the laminate.

technical specifications					
* NEMA LD.3/ EN-438 TEST METHOD	PROPERTY	UNITS	LAMITECH® S Grade 30	NEMA LD3 VGS	EN-438 VGS
3.1/ 4.0	NOMINAL THICKNESS	In (mm.)	0.028 (0.70)	0.028 (0.70)	-
	THICKNESS TOLERANCE	In (mm.)	+/- 0.004 (+/- 0.10)	+/- 0.004 (+/- 0.10)	-
	APPEARANCE	defects	No A,B,C defects	No A,B,C defects	-
	CLEANABILITY	rating (max.)	5	20	-
3.4 / 26	STAIN RESISTANCE				
	Stain 1-10	effect	NE	NE	-
	Stain 11-15	effect	NE	M	-
	Group 1	grade	5	-	5
	Group 2	grade	5	-	5
	Group 3	grade	5	-	4
3.5	BOILING WATER RESISTANCE	effect	NE	NE	-
3.6 / 16	HIGH TEMPERATURE RESISTANCE	grade (min.)	NA	NA	NA
3.11 / 17	DIMENSIONAL CHANGE				
	Longitudinal	% máx.	0.50	0.70	0.75
	Transversal	% máx.	0.80	1.2	1.25

SL=Slight Effect=4, NE=No Effect=5, M=Moderate=3, NA=Not Applicable, S=Standard
* Nema LD.3 America and EN-438 Europe

► limited warranty

Lamitech S.A., warrants that its products are reasonably free of defects and when properly used will comply, with normal deviations, to related manufacturing specifications. This warranty will be extended only to the original buyers for a period of one (1) year from the purchase date. It excludes damage resulting from accidents, abuse or lack of care, improper use and/or any alteration.

Since Lamitech laminates have a wide range of applications, without the possibility of control over the manipulation of the end product, Lamitech does not assume obligations or liabilities arising from the furnishing, sale, installation or repair, use or subsequent sale of any product, to any person or entity.

The contents of this brief correspond to common knowledge of High Wear Lam High Pressure Laminates. Lamitech offers this information solely to provide suggestions for your application. Since it's impossible to anticipate every variation in actual end use conditions, no warranties or liabilities can be assumed by Lamitech in terms of the use of this information. Lamitech believed the information and recommendations provided herein to be accurate at the time of preparation or to have been obtained from sources perceived to be generally reliable. Lamitech reserves the right to modify this brief without prior notice.

