


# *lamitech chalk board lam*

## TECHNICAL DATA SHEET

to ill<sup>a</sup>minate

The desire to inspire

 **Lamitech**®  
High Pressure Decorative Laminates.

# product description

## ▶ product composition



*Lamitech Chalk Board Lam* is manufactured with special decorative papers saturated with melamine resin, pressed with special texturized finishes which determines the special surface needed to be used with chalk. Kraft papers impregnated with phenolic resin constitutes the core of the laminate. All these materials are subjected to a high specific pressure (100 kg/cm<sup>2</sup>) and temperature 275°F (135°C). Once the press cycle is over, 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 Chalk Board Lam* is provided for the special needs of standard vertical applications requiring a durable, green or black matte decorative surface that ensures easy erasure of chalk. *Lamitech Chalk Board Lam* is ideal for applications where chalk bar is to be used including schools, universities and presentation areas.

## ▶ basic limitations

*Lamitech Chalk Board Lam* is designed for interior uses only, it is not meant to be structural material; it does not admit high humidity or high temperature, exceeding 275°F (135°C). *Lamitech Chalk Board Lam* should not be exposed to intense and continue sunlight. *Lamitech Chalk Board Lam* must be subjected to a monthly maintenance. It must be cleaned with a water moisted cloth to remove any chalk residual material that can derive in permanent stain. *Lamitech Chalk Board Lam* is only use for standard applications. Please contact our sales representatives for further assistance.

product identification							
TYPE OF LAMINATE	LAMITECH® GRADE	NOMINAL THICKNESS	SIZES				FINISHES
		mm (in)	feet (ft)				
			4 x 8	4 x 10	5 x 8	5 x 12	
			meters (m)				
		1.22 x 2.44	1.22 x 3.06	1.53 x 2.44	1.53 x 3.66	Matte	
Horizontal Standard Chalk Board Lam	70	1.20 (0.048)	X	X	X	X	X
Horizontal Standard Chalk Board Lam	50	1.00 (0.039)	X	X	X	X	X
Vertical Standard Chalk Board Lam	30	0.70 (0.028)	X	X	X	X	X

## ▶ useful information

1. Conditioning and storing conditions of *Lamitech Chalk Board 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 Chalk Board 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/m<sup>2</sup> of adhesive and a 7-9 k/cm<sup>2</sup> 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 with *Lamitech Chalk Board 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 Chalk Board Lam* should be cut with circular saws at 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 the *Lamitech Chalk Board 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 Chalk Board 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.

## technical specifications

* NEMA LD.3/ EN-438 TEST METHOD	PROPERTY	UNITS	LAMITECH® S Grade 30	NEMA LD3 VGS	EN-438 VGS
	NOMINAL THICKNESS	In (mm.)	0.028 (0.70)	0.028 (0.70)	-
	THICKNESS TOLERANCE	In (mm.)	+/- 0.004 (+/- 0.10)	+/- 0.004 (+/- 0.10)	-
3.1 / 4.0	APPEARANCE	defects	No A,B,C defects	No A,B,C defects	-
3.3 / 27	LIGHT RESISTANCE	effect/gray scale	5	SL	4- 5
	CLEANABILITY	rating (max.)	12	20	-
	STAIN RESISTANCE				
	Stain 1-10	rating (min.)	NE	NE	-
3.4 / 26	Stain 11-15	rating (min.)	SL	M	-
	Group 1	grade	5	-	5
	Group 2	grade	5	-	5
	Group 3	grade	4	-	4
3.5	BOILING WATER RESISTANCE	effect	NE	NE	-
3.6 / 16	HIGH TEMPERATURE RESISTANCE	grade (min.)	4	4	4
3.7 / 25	SCRATCH RESISTANCE	grade (min.)	2	2	2
3.8 / 21	BALL IMPACT RESISTANCE	In (mm.) min.	39 (1,000)	20 (500)	24 (600)
	DIMENSIONAL CHANGE				
3.11 / 17	Direction Machine	% máx.	0.50	0.70	0.75
	Cross Machine	% máx.	0.80	1.20	1.25
3.13 / 10	WEAR RESISTANCE	Cycles (min.)	600	400	350

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 manufacturing 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 Pressure Laminates. Lamitech offers this information solely to provide suggestions for your application. Since it's impossible to anticipate all variations in actual end use conditions, no warranties or liabilities can be assumed by Lamitech in connection to the use of this information. Lamitech believed the information and recommendations provided herein to be accurate at the time of preparation or obtained from sources believed to be generally reliable. Lamitech can modify it without prior notice.

