

SIZES

- Width varies from 91,5mm to 1250mm, length 2100mm to 2800mm and thickness 8-18mm. Plates can be produced on different scales according to client requests.

STOCKING CONDITIONS

- LAMI GLOSS panels should be stocked as horizontal position on pallets. Bound moisture should be 50% and temperature should be at 25 Celsius degrees.
- LAMI GLOSS panels are manufactured for indoor use. Products shall not be used in gardens or similar open areas and shall not be exposed to direct sunlight, vapor and water for long time.

APPLICATION AND MAINTANENCE GUIDE

- Panels should be cut when their protective film is headed to the ground. It is recommended to be cut on circular sawing and panel sizing machines via scriber.
- Panels should be cut while its protective film is still on.
- During circular sawing machine cut, recently whetted 96 buttress gear should be used.
- It is advised to have sizing cut with whetted 72 buttress gear at maximum 25m/minute speed.
- In order to prevent micro fractions thereby buttress tray during cutting, panels should be cut via whetted scriber tray
- It is recommended scriber tray to mark 0,50mm on right and left sides of MDF and scriber tray should be penetrated at least 5mm.
- Please check square adjustments of the cutting machines (horizontal, sizing, CNC).
- **CNC:** In order to have a fine cutting and remove the necessity of milling cutter, it is recommended to have cutting on CNC Router with 18.000 d/d dia 10-12mm blade at 8-9 m/minutes speed.
- Before edge banding process, in order to prevent gaps between panel and edge band, it is recommended to frim the edges via banding router.
- It is not recommended to use protective film during press process in order not to harm glossy surface.
- To protect the glossy surface, please avoid frictions and impacts during edge banding, stow aging, shipment and assembly processes.
- It is recommended to remove protective film, after the assembly while not exposing high temperature and direct sun light. Cleaning should be done with moist duster.
- It is not recommended to use cleansers which have sub grain structure, acid based chemical, wire wool, harsh & dry cloths because of the damage to glossy surface
- Panels are produced for indoor use. Panels shouldn't be used in open areas, gardens, wet grounds and areas that are exposed to direct sunlight and vapor.

TECHNICAL SPECIFICATIONS

COMPANY DETAILS

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PRODUCT DESCRIPTION

- E1. m3/720 kg both faces of mid-density MDF panels are covered with water & fire proof melamine.
- Afterwards, on one side of MDF Lam and Chipboard Lam panels' acrylic based UV lacquer layers are cured with UV light in different levels. Consequently, one side of panels turn into high gloss.

TECHNICAL DATA

- Thanks to mirror effected 92 degrees surface gloss, LAMI GLOSS panel surface will protect its natural appearance and high colored pigment look with UV cured lacquered layers for long years.
- Acetone and thinners being in the first place, high resistant to all sorts of surface cleaners. Quick cleaning, hygienic, long lasting surface.
- UV layers which are cured on the panel surface are acrylic based. Panel is completely free from any solvents.
- LAMI GLOSS brings elegance with its mirror effected view to kitchens, bathrooms, offices, living rooms and bedrooms.

TEST METHODS	STANDARD	RESULTS
Chemical Resistance	DIN 68861-4:2013	Class 1B (5)
Cold Chemical Resistance		
Splice Strength	EN ISO 2409:2013	0 (OK)
Splice Strength at Panel Corner	EN 14323:2004	No breaking (5)
Surface Soundness (Insulation Test)	EN 311:2002	1.59 N/mm ²
Cold/Hot Test (40 Spins -> 1hr. 60 °C / 1hr. -20 °C, 15 minutes in room temperature)	-	No damage
Lightfastness Test	EN 14323:2004	> 6
Dry Heat Resistance	DIN 68861-4:2013	7 C (100 °C)
Wet Heat Resistance	DIN 68861-4:2013	8 A (100 °C)
Cigarette Burn Resistance	EN 438-2:2005	2
Scratch Resistance	EN 14323:2004	> 4 N
Water Vapor Resistance	EN 438-2:2005	4
Impact Resistance (Big Ball)	EN 14323:2004	1900 mm
Width-Length-Thickness Tolerance	EN 14323:2004	Thickness:±0.5mm Width/Lenght:0.4/0.6mm
Bending Resistance	EN 14323:2004	0.51
Solid Color Tolerance	CIE LabCH D65/10º	ΔE ≤ 0,70
Brightness Tolerance	EN 14323:2004	91.9 (+/- 5)
Resistance to Surface Abrasion (Taber S 42)	EN 14323:2004	Starting Point: > 350 Abrasion Value: > 400 Class 3A
Surface Defects	EN 14323:2004	No Surface Defects
70 C° Oven Test	EN 14323:2004	Category 3
Formaldehyde Ratio	EN 717-1:2005	Class E1
Plate Thickness Inflation (Water Test)	DIN EN 317:1993	1.0 %
Plate Breaking Point	DIN EN 310:1993	Glossy Up: 30.6 N/mm ² Glossy Down: 36.0 N/mm ²
Plate Elastic Limit (Pressure)	DIN EN 310:1993	Glossy Up: 3770 N/mm ² Glossy Down: 3770 N/mm ²
Micro Scratch	DIN CEN/TS 16611:2014 Method A (after 5 LB)	Average: 9.5 %