



Application example

dekorial starline

High Pressure Metal Laminates HPML

Product description

The product name dekorial-starline refers to real metal laminates (HPML) with an aluminium surface. This metal layer is applied on a phenolic resin core with high pressure. The resistant aluminium surface is produced by anodizing (for mirror quality) or by painting. Since anodizing is an integral part of the top layer, this provides permanent protection against external influences.

Special stove enamel on an epoxy resin basis or a PU-lacquer is also used to protect the metal surface, which is practiced in many designs. Depending on the requirements, the aluminium layer can be smooth, brushed, or embossed. The typical metallic character is created through compacting in the natural colour. A transparent colour, in combination with surface structures, is another additional possibility for decorative designs.

This product is characterized, inter alia, by a „slight surface unevenness“ and (in the structures of some aluminium laminate types) slight differences in the gloss level. Even small dents are unavoidable and normal with today's technology. The same applies to the colour for the products listed here. It can vary minimally due to the manufacturing process, but the overall impression is generally not disturbed.

✔ Suitable for:

- the implementation of high-quality concepts (e.g. store fitting, hotels, etc.)
- vertical application, as wall lining, etc.
- horizontal application, partly even in strongly frequented areas (A 480 and A 486)







✘ Not recommended for:

- Outdoor use, areas of splash water, very humid environments (wet and humid rooms)



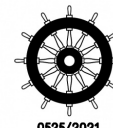
dekorial starline

Characteristics:

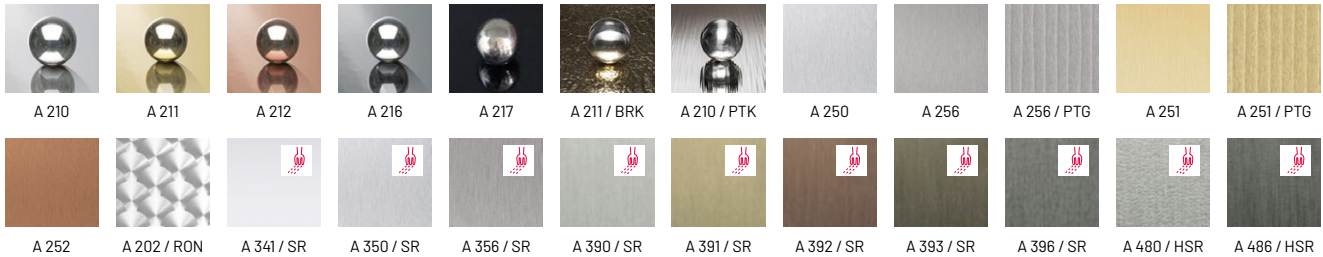
-  Lightfast
-  Resistant to chemicals
-  Food safe
-  Resistant to cleaning
-  Flame retardant
-  Scratch-resistant



European Standard
EN 438



Selection from the dekorial starline collection:



More decors of the dekorial-starline collection can be found at www.dekodur.de/de/metall/aluminium-hpl.html

Real aluminium surfaces are very often implemented as smooth surfaces. However, surface structures such as PTG, PTK, NTZ, AQA, DIA, RON, or lengthwise/crosswise grooves with different characteristics (603 - 610) will additionally emphasize the application's metal character. As the grooves differ in their appearance, a combination is not recommended.

Of course, an ideal mirror effect can only be achieved with a smooth metal surface. Structures such as grooved structures (see dekovario) offer additional possibilities with these mirror qualities.

A 210	Real aluminium	smooth & anodized	Silver color	Mirror quality
A 211	Real aluminium	smooth & anodized	Gold color	Mirror quality
A 212	Real aluminium	smooth & anodized	Copper color	Mirror quality
A 216	Real aluminium	smooth & anodized	Gunmetal color	Mirror quality
A 217	Real aluminium	smooth, matt, anodized	Night blue color	Mirror quality

 **More resistant to scratching**

Abrasion resistance: A 341, A350, A356, A390, A391, A392, A393 and A396

These products are coated with a special lacquer. The surface protection lacquer has a scratch hardness according to **DIN EN 438** of $\geq 1.2 \text{ N}$. A comparative test with a household steel sponge, loaded with weights, gives the following result when tested in a direction transverse to the running direction:

With a load of 1000g: no scratch marks/standard versions from 2000g: light and / from 5000g: clear scratch marks.

i-RESIST / high abrasion resistance: A480 and A486

The surface protection lacquer has a scratch hardness of $\geq 3 \text{ N}$ according to **DIN EN 438** = and can be used horizontally

Standard version	Scratch-resistant	High scratch-resistant
Scratch hardness 0.5 N	Scratch hardness $\geq 1,2 \text{ N}$	Scratch hardness $\geq 3 \text{ N}$



Backing for dekorial starline: A 209 real aluminium smooth and painted (natural colour) (aluminium quality without colour and quality requirements)

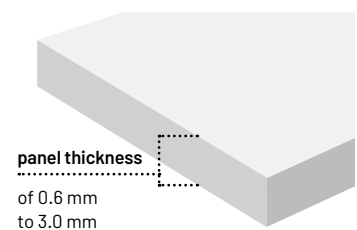
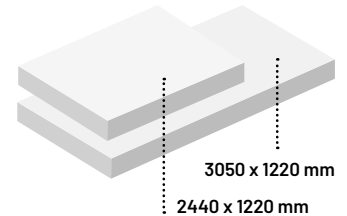
Delivery form and quality

All dekorial-starline boards with smooth finish are supplied in dimensions of **2440 x 1220 mm** and **3050 x 1220 mm**.

This does not apply to the (WAF) structure, which has a usable width of 1200 mm and a length of 2440 mm.

According to **DIN EN 438**, the nominal length and width tolerance must correspond to limit dimensions of **- 0 mm and + 10 mm**.


dekorial-starline boards can be produced in **thicknesses from 0.6 mm to 3.0 mm**. The standard thickness for painted versions is 0.8 mm (weight: 1.35 kg/m²), and 0.9 mm for mirror quality. (Weight: 1.45 kg/m²).



Nominal thickness	Limit deviations
0.6 - 1.0 mm	± 0.15 mm
> 1.0 - 2.0 mm	± 0.15 mm
> 2.0 - 2.5 mm	± 0.18 mm
> 2.5 - 3.0 mm	± 0.20 mm

Thicknesses of >3.0 mm available upon request

The fire behaviour of the dekorial-starline standard-quality product range corresponds to classification B2 according to DIN 4102 Part 1 and to class D-s2-d0 according to DIN EN 13501-1. Furthermore, laminates of the dekorial starline product range are **flame-retardant** according to FTP Code Annex 1, Part 5 and Annex 2 (IMO Res MSC307(88) - (2010 FTP Code) Annex 1, Part 5 and Annex 2.

The products carry the „Steering Wheel Symbol,”  as well as the US Coast Guard Approval - No. USCG EU MRA 1164.112/EC0038/yyyy for dekorial starline and are certified by Lloyds Register. Note: In addition to the general technical instructions, the behaviour of products in the event of fire is influenced not only by the laminate used but also by the bond with other materials, fasteners, and the processing technique. Adhesives used in Type B cutting surfaces and in connection with the insulation of cold systems in shipbuilding must also be flame-retardant according to FTP Code Annex 1, Part 3 No. 3.1. and Part 5 No. 3.4.

Lamination with a protective film is mandatory for dekorial-starline. The foil must be removed after 6 months at the latest. Otherwise, the aluminium surface might get damaged.



In addition to the standard quality, all painted aluminium versions (except A 480 and A 486) can be produced in post-forming quality („post formable“). In the article description, laminates in post-forming quality are marked with the abbreviation **NF.** Upon request, these boards will be laminated with a heat-resistant foil.

The processing of dekorial-starline boards in post-forming quality is influenced or determined by a multitude of material and processing parameters (thickness of the material, decor, structure, temperature, feed rate, rounding profile, rounding radius, etc.). The specific production parameters have to be adjusted not only to the material properties but also to the equipment and adhesive used.

A general specification for the laminate's forming temperature is a range of 140 - 160° C; a feed rate of 10 - 20 m/min is another guideline for the forming process. In general, the laminate allows for a maximum bending radius (in mm) of approx. 10 x the board thickness (e.g. 0.8 mm = 8 mm radius). Storage under normal climatic conditions (approx. 18 - 23° C and 50 - 65 % relative humidity) must be observed. When stored under these conditions, the post-forming properties will remain virtually unchanged for storage periods of up to one year.

Applications and processing methods

dekorial starline boards are intended for decorative vertical surfaces in interior design applications. Even lightly stressed, horizontal surfaces can be covered with starline.

Typical application examples include:

- Wall coverings
- Ceiling coverings
- Living room furniture
- Hotel and restaurant furniture
- Drawer fronts
- Company signs
- Shelf cladding
- Counters and displays in store fitting
- Door and frame cladding
- Shipbuilding
- Vehicle construction/Caravan construction
- and much more



When dekorial-starline is used on heavily used work surfaces, a glass plate or a similar cover is recommended to protect the surface. dekorial-starline laminates can be sawed, milled, and drilled with carbide-tipped tools.

When gluing starline in flat presses, the following must be observed:

- Maximum temperature of **60° C** (Recommendation: cold pressing)
- Contact pressure of **0.15 – 0.20 N/mm² (1.5 – 2.0 bar)**
- **Soft padding** between the laminate surface and pressing agent

All commercially available adhesives and glues, which are also used to bond classic high-pressure laminates, are suitable for gluing.

Adhesive types:

- Dispersion adhesives (PVAc)
- Condensation resin adhesives (urea resin)
- Contact adhesives
- Reaction adhesives
- Hot melt adhesives

PU adhesive residues must be fully removed from the surface immediately before curing.

When it comes to composite elements, attention must be paid to an asymmetrical structure, i.e. the rear side is glued to a corresponding backing plate. A good flatness is achieved when using the same board quality and thickness on the back of the element with a second-choice board or A 209 backing.

When used as a front, A-quality is expressly recommended on both sides!

Gluing of HPL with real metal foil

When gluing real metal HPL with

- contact adhesives (solvent-based)
- condensation adhesives (phenol-resorcinol resin base)

special care and compliance with the adhesive manufacturer's instructions are essential. Be particularly sure to apply an even adhesive layer that is not too thick, and ensure sufficient ventilation (insufficient ventilation can lead to the delayed formation of bubbles between the metal foil and the laminate core and/or to separation of the metal foil from the laminate core! – Before use, consultation with the manufacturers is necessary!)

If possible, the parts should be pressed over a small area. At least one edge length should be less than 800 mm.

Guide value table for the bonding of HPL with real metal surfaces on wood-based materials

(chipboard V 20, chipboard V 100, plywood, hard fibre, solid wood)

Adhesives	Condensation adhesives		
	Strength acc. to EN 204	Urea resin approx. 10 % filled	Urea melamine resin
Temperature resistance	D 3 -20 °C to +150 °C	D 3	D 3 / D 4 -20 °C to +150 °C
	- adhesive application: 90-150 g/m ² on HPL or carrier material - open waiting period: 2-20 min - bonding pressure: 3-5 bar - pressing temperature/pressing time: 20 °C / 15-180 min 40 °C / 5-30 min 60 °C / 1-12 min The open waiting and pressing times depend on the added curing agent		100-180 g/m ² 2-15 min 3-5 bar 20°C / approx. 9 h 80°C / approx. 10 min 110°C / approx. 5 min
Adhesives	Contact adhesives		
	without curing agent	with curing agent	with built-in resin hardener
Strength acc. to EN 204	no classification according to EN 204		
Temperature resistance	-20 °C to +70 °C	-20 °C to +100 °C	Consultation with the manufacturer
	- adhesive application: 150-200 g/m ² each on HPL and carrier material - open waiting time: depending on ambient temperature and adhesive type (finger test) - bonding pressure: min. 5 bar - pressing temperature: 20 / 40 / 60 °C - pressing time: short (preferably roller press)		These are special adhesive settings for which no guide values can be given. Consultation with the adhesive manufacturer is necessary.



Cleaning and care

dekorial-starline surfaces are cleaned with a clean cloth or a soft sponge using soap and plenty of water or a glass cleaner.

Abrasive cleaning agents, acids and alkalis, especially chlorine-containing products, should not be used.

Storage

dekorial-starline laminates must be stored in a closed room at temperatures between 18 and 25°C and a relative humidity of 50 - 60%. They must be stored flat and horizontally over the entire surface, with at least 200 mm distance to the floor. The board stacks

- are to be protected from moisture
- must not be exposed to direct sunlight
- must not be placed in a warm and/or cold air stream.



If horizontal storage is not possible, an **inclination of approx. 80°** with full-surface support and a lower counter bearing is recommended.

Waste disposal, environment, and hygiene

- dekorial-starline waste can be incinerated in officially approved industrial combustion plants.
- dekorial-starline waste can be deposited in landfills, taking into account the local waste regulations.
- According to TA-Abfall, version as of 28 March 91, Category I, No. 571, HPL residues are classified as „other hardened plastic waste.“ Category I refers to materials which are similar to household waste.

Formaldehyde / VOC

Dekodur laminates from the dekorial starline collection have been tested for formaldehyde emissions. They are well below the limit values specified in the German Chemicals Prohibition Ordinance (ChemVO) and the guideline value of the AgBB Scheme 2018, ISO 16000 Parts 3, 6, and 9, DIN 16516 (01/2018) for interior rooms.

FSC

All products of the dekorial starline collection are manufactured with FSC-CW certified raw materials from sustainable forestry. Upon request, these products are also available in FSC-mix quality.

Hygiene

Food safe material

Technical data at a glance

	Quality		
	Decoration / Surface		All
	Thicknesses		0,8 - 0,9 mm
Complies with EN 438-8	Standardized type		MTF
Feature	Standard	Unit	

Physical properties and dimensions of metal laminate panels *

Density	EN ISO 1183-1	g / cm ³	≤ 1,35
Strength tolerance	EN 438-2-5	mm	± 0,15
Length and width tolerance	EN 438-2-6	mm	- 0 / +10
Tolerance of edge straightness	EN 438-2-7	mm / m	≤ 1,5
Perpendicularity tolerance	EN 438-2-8	mm / m	≤ 1,5
Flatness tolerance	EN 438-2-9	mm / m	100
Dimensional stability at high temperature:	EN 438-2-17	%	
■ Longitudinal direction			≤ 0,75
■ Cross direction			≤ 1,25

Mechanical properties

Resistance to boiling water	EN 438-2-12		No delamination of core layers
Tear resistance	EN 438-2-23	Class ^(a)	4
Minimum bending radius (convex and concave direction)		cm	15

Surface properties

Resistance to water vapour	EN 438-2-14	Class ^(a)	3
Scratch resistance	EN 438-2-25	Degree ^(b)	1
Resistance to stains	EN 438-2-26	Class ^(a)	
■ Group 1 & 2			4
■ Group 3			4
Colour stability under artificial light	EN 438-2-27	Grey scales	4 to 5

Fire behaviour

Fire behaviour (upon request)	EN 13501-1	Class	D-s2-d0 / B-s1-d0 / A2-s1-d0
Gross calorific value	EN ISO 1716	MJ / Kg	18 - 20

Health and environmental qualities

Release of formaldehyde	EN 717-2	Class	E1 (< 0,1ppm)
Emissions of volatile substances	ISO 16000-9	Class	A

* Metal is subject to slight variations in colour and structure; some decors may show a mother-of-pearl lustre. These deviations are no reason for complaint.

MTF: fire-resistant metallic laminate surface. / Type P2: panels used in a dry environment for interior decoration.

(a) Class: 1 = damage to the surface. 2 = significant change in appearance. 3 = moderate change. 4 = minor change visible from certain angles. 5 = no change.

(b) Level: 2 = continuous scratches with 2N. 3 = continuous scratches with 4N.

Do you have any questions?

If so, please contact our service department. If you need samples, you can request them from Dekodur[®] in the form of sample chains or hand samples in DIN A5 or DIN A4.

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