

**Product Data Sheet**

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**dekowood**

**veneer**

## Product Description

The product name **dekowood veneer** is applied to **decorative high-pressure laminates (HPL)** with a face made from genuine wood veneers. **dekowood veneer** is composed from one type of wood or available with a striped pattern made from different types of wood.

We process sliced and rotary cut veneers. These veneers are joined and combined into a harmonious overall and visually pleasing decor. Hardly any other natural product is as versatile and valuable as wood. Its use as veneer is especially ecological.

### **dekowood veneer**

The veneer is pressed in a special process with the core layer of impregnated phenol and/or aminoplastic paper for a decorative high-pressure laminate. Furthermore, the commonly used phenol and/or aminoplastic paper core layers can be replaced with core layers of the "ECO-HPL" product line.

Matte surfaces of **dekowood veneers** are produced and protected either by acrylic varnishing or by a melamine layer. High gloss surface by pressing with a melamine layer.

Depending on tree and type of wood, colors vary from rich beige to dark brown. Each **dekowood veneer** panel is unique, yielding a harmonious overall look when combined with other panels. The beauty and charm of the veneer panel can be mixed and matched with many other materials for interesting and visually appealing results.

**Possible backing sheet for dekowood veneer: RS 16 GLA 010**

**This backing sheet is a melamine laminate in a solid white color and with a smooth surface without special quality demands.**

## Forms of Delivery and Quality

All **dekowood veneer** panels are delivered in the dimensions 2440 x 1220 mm.

The tolerance for the length and width dimension corresponds with the requirements as outlined by DIN EN 438-8 and meets the limit deviations with values of

10 mm / -0 mm.

**dekowood veneer** panels are available in thicknesses from 1 mm to 1.5 mm. The standard thickness of this product is 1 mm (weight: 1.0 kg/m<sup>2</sup>).

The limits defined by DIN EN 438-8 also apply to the thickness deviations.

Nominal Thickness	Limit Deviation
0.5 – 1.0 mm	± 0.15 mm
> 1.0 – 2.0 mm	± 0.18 mm

All **dekowood** panels are produced in standard quality.

## Applications and Processing Notes

**dekowood veneer** is designed for interior vertical decorative surfaces and furniture applications. The surface is easy to clean.

The following are typical application examples: Wall paneling, ceiling panels, home furniture, and hotel and restaurant furniture.

**dekowood veneer laminates can be sawed, cut, milled, and drilled with carbide-tipped tools.**

**When sawing the panel, make sure the dekowood veneer laminate is processed with a transverse cut to prevent damaging the fibers of the face.**

### Suitable Glue Types:

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

In case of dispersion adhesives and condensation resin adhesives, the bond is established with a glue application of approx. 100 – 150 g/m<sup>2</sup> and a laminating pressure of approx. 2 – 5 bar.

The laminating temperature should not exceed 60°C.

## Gluing HPL Panels with Genuine Wood Surface

Gluing dekowood veneers using

- contact adhesives (containing solvents)
- condensation adhesives (phenol/resorcinol resin basis)

requires special care and compliance with the specifications and instructions of the adhesive manufacturers.

In particular, the following must be observed:

Even, not too thick application of the glue, sufficient flash off (insufficient flash off may lead to bubbling between veneer and laminate core and/or debonding of the veneer from the laminate core! Consult with manufacturer if necessary!)

### Reference value table for gluing HPL with genuine wood surfaces to wood materials (chipboard V 20, chipboard V 100, plywood, hard fiber, solid wood)

Adhesives	Condensation Adhesives		
	Urea resin filled approx. 10%	Urea melamine resin	Phenol resorcinol resin
Durability acc. to EN 204	D 3	D 3	D 3 / D 4
Temperature resistance	- 20°C to + 90°C		- 20°C to + 90°C
	~ Adhesive application: 90-150 g/m <sup>2</sup> on HPL or backing material ~ Open waiting time 2-20 min ~ Laminating pressure 3-5 bar ~ Laminating temperature/press time: 20°C / 15-180 min 40°C / 5-30 min 60°C / 1-12 min ~ Open waiting time and press time dependent on hardener addition		100-180 g/m <sup>2</sup>  2-15 min  3-5 bar  20°C / approx. 9 hours 80°C / approx. 10 min 90°C / approx. 5 min

Adhesives	Contact Adhesives		
	Without hardener	With hardener	With integrated resin hardener
Durability acc. to EN 204	No classification acc. to EN 204		
Temperature resistance	- 20°C to + 70°C	- 20°C to + 90°C	Inquire at manufacturer
	~ Adhesive application: 150-200 g/m <sup>2</sup> each on HPL and backing material ~ Open waiting time Dependent on ambient temperature and Adhesive type (finger test) ~ Laminating pressure: min. 5 bar ~ Laminating temperature: 20 / 40 / 60°C ~ press time: short (preferably roller press)		These are special adhesives settings for which no reference values can be indicated.  Inquiries with adhesive manufacturer required.

Comply with the manufacturer usage instructions in case of contact, reaction, and hot melt adhesives.

Composite elements must be arranged symmetrically, i.e. the rear side is glued with a corresponding backing panel. Using the same panel quality on the back of the element with a 1B panel or the backing sheet RS 16 HGL 010 yields a good layout and optimal flatness.

## Cleaning and Care

**dekowood veneers** with a melamine surface are cleaned with a clean cloth, soft moist sponge, or a soft brush.

Cleaning agent: Glass cleaner, water with small amount of detergent.

The varnished surfaces are cleaned with a clean cloth or a soft brush.

Cleaning agent: Moist cloth or similar with small amount of detergent. Remove excess moisture at once.

**Do not use abrasive cleaners.**

## Storage

**dekowood veneer** laminates are stored flat and horizontally in a closed room at 18-25°C and 50-60% relative humidity at a distance to the floor of 200 mm.

The panel stacks

- must be protected from moisture.
- may not be exposed to direct sunlight.
- may not be exposed to warm air flows.

If horizontal storage is not possible, a slanted position of approx. 80° with a support across the entire panel surface and a back support is recommended.

## Disposal

**dekowood veneer** waste can be **incinerated** in officially authorized industrial incineration plants.

**dekowood veneer** waste can be **deposited** in landfills in compliance with local waste and debris rules and regulations.

According to the TA Refuse, version dated 28 March 1991, Category I, No. 571, HPL residues and refuse are classified as "other hardened plastic waste." Category I means that a material resembles household waste.

**Please contact our service department if you have any questions. This also applies to any questions you may have concerning DIN EN 438.**

**Samples in the form of pattern strings or hand sheets (DIN A5 or DIN A4 format) can be requested from Dekodur®.**