

**Product Data Sheet**

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Version 11/ZT15E

**dekoleather**

## Product Description

The product name **dekoleather** refers to **decorative high pressure laminates (HPL)** with a top layer of genuine leather. The **dekoleather** collection is available in six colours. **Dekoleather** is a natural product, which is why colour variations caused by production are possible.

Not only does it look like leather, but it also smells and feels like leather.

The **dekoleather** top layer is made from 100% recycled cow leather fibres. Using a special, patented procedure, **dekoleather** is pressed to a decorative high pressure laminate with a core layer of impregnated phenolic and/or melamine resin papers. Besides, the usual phenolic and/or melamine resin papers can be replaced by core layers from the "ECO-HPL" product series.

**Possible backing sheet for dekoleather: RS 16 GLA 008**

**This backing sheet is a white, plain melamine laminate with smooth surface without special quality requirements.**

## Form of Delivery and Quality

All **dekoleather** boards are manufactured and delivered in the dimensions 2440 x 1220 mm.

The tolerance for the nominal length and width dimensions complies with the requirements of DIN EN 438 and meets the specifications:

10 mm / -0 mm

The board thickness of **dekoleather** boards can be manufactured from 1.0 mm to 1.5 mm. The standard thickness of this product is 1.0 mm (weight: 1.0 kg/m<sup>2</sup>).

The requirements of DIN EN 438 apply to the thickness deviations.

Nominal thickness	Limit deviations
0.5 – 1.0 mm	± 0.15 mm
> 1.0 – 2.0 mm	± 0.18 mm

All **dekoleather boards** are manufactured in standard quality.

## Applications and Processing Instructions

The use of **dekoleather** is particularly suitable for vertical decorative surfaces in interior construction and the furniture sector. The surface can be cleaned easily. Typical application examples include: wall coverings, ceiling coverings, desks, home furnishing, hotel and restaurant furniture.

**Dekoleather HPL laminates can be sawn, milled and drilled with carbide tipped tools. When sawing the board, make sure that the dekoleather laminates are cut with a pulling motion to prevent damage to the fibres of the top layer.**

### Adhesive types suitable for gluing:

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

Gluing with dispersion and urea resin adhesives is done with a glue application of approx. 100 – 150 g/m<sup>2</sup> and a pressing power of approx. 2 – 5 bar. The pressing temperature should not exceed 60°C.

The processing instructions of the manufacturer must be observed when using contact adhesives, reaction adhesives and hot-melt adhesives.

In the case of composite elements, attention must be paid to a symmetrical structure, i.e. the back is glued to a corresponding backing sheet. Good flatness is achieved when using the same board quality on the rear of the element with a 1B board or with the RS 16 HGL 008 backing sheet.

## Bonding HPL-sheets surfaced with pure metal foils

The bonding of HPL sheets surfaced with pure metal sheets using

- contact glues (containing a solvent)
- condensation glues (resins based on phenol and/or resorcinol)

requires special precautions and close adherence to the manufacturer's instructions. Special attention must be paid to a uniform, but not too higher gluespred, sufficient airing (insufficient airing can lead to later-on blistering between the metalfoil and the core of the laminat and/or lead to the seperation of the metalfoil to the laminat. Here contact with the manufacturer is essential) and sufficient pressure in the press. The surfaces to be bonded should be kept as small as possible. At least one edge should not exceed 800 mm.

### General rules for bonding HPL, surfaced with pure metal, to wooden substrates

(particle board V 20, particle board V 100, plywood, hardboard or solid wood)

	Condensation glues		
Glues employed	Urea resin with approx. 10% filter	Urea-Melamine resin	Phenol Resorcinol resins
For use as in DIN 204	D 3	D 3	D 3 / D 4
Resistance in Temperature	between - 20°C + 150°C		between - 20°C + 150°C
	~ Gluespred: 90-150 g/m <sup>2</sup> on HPL or substrate ~ Open time: 2-20 min ~ Press pressure approx. 3-5 bar ~ Press temperature/Press time: 20 °C / 15-180 min 40 °C / 5-30 min 60 °C / 1-12 min ~ Open and press times are dependant on the amount hardener used.		100-180 g/m <sup>2</sup>  2-15 min  3-5 bar  20°C approx. 9 hours 80°C approx. 10 min 110°C approx. 5 min

  

	Contact glues		
Glues employed	without hardener	with hardener	with built-in hardener
For use as in EN 204	not classified under EN 204		
Resistance to Temperature	between - 20 °C + 70 °C	between - 20 °C + 100 °C	Contact the manufacturer
	~ Gluespred: 150-200 g/m <sup>2</sup> on both HPL and substrate ~ Open times: dependant on ambient temperature and on the type of glue used (Fingertest) ~ Presspressure: at least 5 bar ~ Press temperature: 20 /40 / 60 °C ~ Pressing times: short A roller press is recommended		These are special glues and therefor no values can be given.  Contact with the manufacturer is essential.

## Cleaning and Care

The **dekoleather** surface is cleaned using a clean cloth, a soft, damp sponge, soapy water or a commercially available leather care product.

**Abrasive detergents should not be used.**

## Storage

**Dekoleather** high pressure laminates must be stored in a closed room at 18-25°C and relative humidity of 50-60%. They must be stored horizontally and completely supported leaving 200 mm space between the floor and the supports.

The board stacks

- must be protected against moisture
- must not be exposed to direct sunlight
- must not be placed in a warm air flow.

If horizontal storage should not be possible, we recommend storing the boards at an angle of 80° with full surface contact and a counter weight at the bottom.

## Disposal

**Dekoleather** waste can be **burned** in officially authorised industrial incineration facilities.

**Dekoleather** waste can be **deposited** in landfills in compliance with the local waste legislation.

According to Germany's "TA – Abfall" (Technical Instruction on Waste), version as of 28 March 1991, Category I, No. 571, HPL residues are classified as "other hardened plastic waste". Category I means that a material is similar to household waste.

**Please do not hesitate to contact our service department if you have any questions. You may also contact us if you have open questions about special details concerning DIN EN 438.**

**Do you need any samples? You may request these from Dekodur® in the form of sample chains/samples in DIN A5 or DIN A4 by calling us on +49 (0) 6272 689-0 or sending an e-mail.**