

Product data sheet

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dekorial

rustikal

Product Description

The name *dekorial-rustikal* stands for a high pressure laminate with a pure aluminium surface which has the **appearance of tin**. This surface is applied to a core of phenolic resin using high pressure.

All our products are coated with an UV – lacquer based on acryl. The lacquer has scratch hardness in EN 438 of

> 1, 5 N.

The surface is unaffected by common household agents / solvents. Alcohol has no effect. Slight variations of the silky shine / gloss coming from raw aluminium material are unavoidable.

A slight unevenness in the surface as well as a slightly uneven density of the black colour in some of the aluminium surfaced laminates is one of the features of this product. The slight indentations are at the present stand of technique and are unavoidable and normal. Slight colour variations occur during the production process and are not detrimental to the overall appearance.

The pure metal surface with the appearance of aluminium combined with rustic surface structures give further openings for a decorative effect in individual decoration. The various products can be embossed in a number of structures.

Backing sheets for *rustikal*:

A 209 Pure Aluminum smooth (Natural aluminum colour)

Aluminum quality without colour and quality requirements.

Dimensions and Quality

Rustikal sheets are delivered in the standard dimensions 2440 mm x 1220 mm. The tolerance limits for the dimensions along and across the sheets as required in EN 438 are:

- 0 mm and + 10 mm

The *rustikal* sheets can be produced in thickness from 1.2 mm to 3.0 mm. The standard thickness in the lacquered product is 1.2 mm, giving a density of 2.1 kg/m².

The limits for variations in thickness are governed by EN 438.

Nominal thickness	Maximum tolerances
0.6 – 1.0 mm	± 0.10 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

If thicker sheets of *rustikal* are required, direct contact with **Dekodur®** is advisable.

Behaviour in case of fire - the standard quality is classified as B2 when tested according to DIN 4102.

For *rustikal* sheets in the quality “flame retardant” a direct contact with **Dekodur®** is advised.

This quality is certified by Lloyd’s Register and fulfils the requirements of IMO FTC.

A protective surface foil is absolutely necessary. This foil must be removed after 6 months at the latest, as by later removal the surface could be damaged.

All *rustikal* sheets are available only in standard quality

Application and Processing

Dekoriel-rustikal is intended for use as decorative vertical surfaces in interior application and for surfaces which are not exposed to heavy wear.

Typical applications are: Wall cladding, ceiling cladding, home furniture, hotel and restaurant furniture, fronts of drawers, signs for shops and firms, shelve cladding, counters and displays in shops, surfacing for doors and doorframes, shipbuilding and coach fittings etc.

For use on surfaces exposed to heavy wear, it is recommended that the surface be protected by a glass sheet.

The *rustikal* laminates can be sawed routed and drilled using tipped tools.

Cautions to be taken when bonding in surface presses:

Maximum temperature 60C°
Press pressure 0.15 – 0.20 N/mm² (1.5 – 2.0 bar)
Soft cushioning between laminate surface and press plates

All standard commercial glues which can be used for bonding standard high pressure laminates can be used.

Glue types:

- dispersion glues (PVAc)
- condensation resin glues (Urea resin)
- contact glues
- 2 component glues
- hot melt glues

When PU glues are used great care must be taken that the glue residues are completely removed from the surface before they harden.

With compound elements, a symmetric construction is necessary. This is obtained by the use of a balancing sheet which must be bonded to the reverse side. A flat element can be obtained by using a sheet of the same type in 2nd quality or a blancing sheet A 209.

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 separation 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)

Glues employed	Condensation glues		
	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 ² 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 ² 2-15 min 3-5 bar 20°C approx. 9 hours 80°C approx. 10 min 110°C approx. 5 min

Glues employed	Contact glues		
	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 ² 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 Maintenance

Cleaning the surface of a *rustikal* sheet is best carried out using a clean cloth, or a soft sponge using soap and plenty of water or a glass cleaner.

Abrasive cleaners, acids, or alkalise should never be used.

Storage

The *rustikal* sheets should be stored in a closed room with a temperature of 18-25°C and 50-60% relative humidity. Furthermore, they have to be stored full-laminar and horizontally with a distance of 200 mm to the ground.

The sheets

- are to be protected from moisture
- should not be exposed to direct sunlight
- should not be stored in a warm-air-stream

Should horizontal storage not be possible a skew of 80°, with the surface being entirely supported by a fully covering back-support, is recommended.

Waste Disposal

Rustikal waste can be **burnt** in officially accepted incinerators.

Rustikal can also be disposed of in landfills in accordance with the local regulations.

The German authorities classify high pressure laminate waste as “other hardened plastic waste material”, which means that it is similar to household waste.

Should you have any further questions, please do not hesitate to contact our service department.

If you need samples you can order these in the form of chains, A5 or A4 from Dekodur®.