

## Technical data

### Duropal HPL Compact, black core

Compact high-pressure laminate in standard quality according to EN 438-4:CGS. With uniform black-coloured core and decorative melamine resin surface on both sides.



Melamine impregnated decorative paper

Impregnated craft paper, black

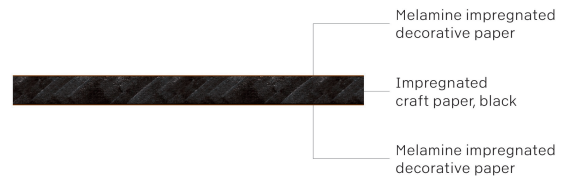
Melamine impregnated decorative paper

Specification								Unit	Standard
<b>Nominal thickness</b>	<b>2</b>	<b>3</b>	<b>4</b>	<b>5</b>	<b>6</b>	<b>7</b>	<b>8</b>	<b>mm</b>	
Tolerance on thickness	± 0.2	± 0.3	± 0.3	± 0.4	± 0.4	± 0.4	± 0.5	mm	EN 438-2:2016
Tolerance on length				+ 10				mm	EN 438-2:2016
Tolerance on width				+ 10				mm	EN 438-2:2016
Surface defects				max. 1 <sup>1)</sup> max. 10 <sup>2)</sup>				mm <sup>2</sup> /m <sup>2</sup> mm/m <sup>2</sup>	EN 438-4:2016
Edge defects				max. 3				mm	EN 438-4:2016
Straightness of edges				max. 1.5				mm/m	EN 438-2:2016
Squareness				max. 1.5				mm/m	EN 438-2:2016
Flatness	max. 8	max. 8	max. 8	max. 8	max. 5	max. 5	max. 5	mm/m	EN 438-2:2016
Density				min. 1,350				kg/m <sup>3</sup>	EN ISO 1183-1
Bending strength				min. 80				MPa	EN ISO 178
Flexural modulus				min. 9,000				MPa	EN ISO 178
Resistance to crazing				min. 4				rating	EN 438-2:2016
Dimensional stability at elevated temperature (length)	max. 0.4	max. 0.4	max. 0.4	max. 0.3	max. 0.3	max. 0.3	max. 0.3	%	EN 438-2:2016
Dimensional stability at elevated temperature (width)	max. 0.8	max. 0.8	max. 0.8	max. 0.6	max. 0.6	max. 0.6	max. 0.6	%	EN 438-2:2016
Resistance to wet heat, 100 °C (smooth finishes)				min. 3				rating	EN 438-2:2016
Resistance to wet heat, 100 °C (textured finishes)				min. 4				rating	EN 438-2:2016
Resistance to dry heat, 160 °C (smooth finishes)				min. 3				rating	EN 438-2:2016
Resistance to dry heat, 160 °C (textured finishes)				min. 4				rating	EN 438-2:2016
Resistance to water vapour (smooth finishes)				min. 3				rating	EN 438-2:2016
Resistance to water vapour (textured finishes)				min. 4				rating	EN 438-2:2016
Resistance to immersion in boiling water (smooth finishes)				min. 3				rating	EN 438-2:2016
Resistance to immersion in boiling water (textured finishes)				min. 4				rating	EN 438-2:2016
Resistance to immersion in boiling water (edge)				min. 3				rating	EN 438-2:2016
Resistance to immersion in boiling water	max. 5 <sup>3)</sup> max. 6 <sup>4)</sup>	max. 5 <sup>3)</sup> max. 6 <sup>4)</sup>	max. 5 <sup>3)</sup> max. 6 <sup>4)</sup>	max. 2 <sup>3) 4)</sup>	max. 2 <sup>3) 4)</sup>	max. 2 <sup>3) 4)</sup>	max. 2 <sup>3) 4)</sup>	%	EN 438-2:2016
Resistance to surface wear				min. 150				cycles	EN 438-2:2016
Resistance to scratching (smooth finishes)				min. 2				rating	EN 438-2:2016
Resistance to scratching (textured finishes)				min. 3				rating	EN 438-2:2016
Resistance to impact by large diameter ball – impression diameter				max. 10				mm	EN 438-2:2016

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### Duropal HPL Compact, black core

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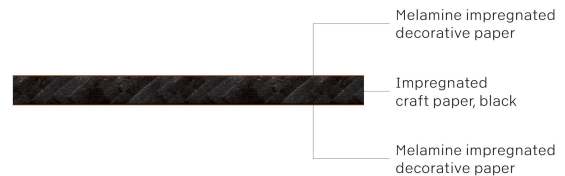
Specification								Unit	Standard
<b>Nominal thickness</b>	<b>2</b>	<b>3</b>	<b>4</b>	<b>5</b>	<b>6</b>	<b>7</b>	<b>8</b>	<b>mm</b>	
Resistance to impact by large diameter ball - Fall height	min. 1,400	min. 1,400	min. 1,400	min. 1,400	min. 1,800	min. 1,800	min. 1,800	mm	EN 438-2:2016
Stain resistance (groups 1 & 2)	min. 5							rating	EN 438-2:2016
Stain resistance (group 3)	min. 4							rating	EN 438-2:2016
Resistance to colour change (xenon arc light)	4 to 5 Grey Scale Grade								EN 438-2:2016
Reaction to fire	normally flammable								
Reaction to fire (Euroclass)	not classified	not classified	not classified	not classified	D-s2,d0	D-s2,d0	D-s2,d0		EN 13501-1, CWFT acc. to 2003/593/EG
Formaldehyde emission class	E1								EN 717-1

- 1) Dirt, spots and similar surface defects  
 2) Fibres, hairs and scratches  
 3) Mass increase  
 4) Thickness increase

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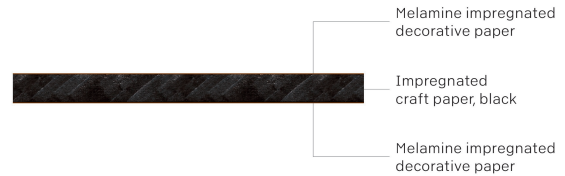


Specification							Unit	Standard
<b>Nominal thickness</b>	<b>9</b>	<b>10</b>	<b>11</b>	<b>12</b>	<b>13</b>	<b>15</b>	<b>mm</b>	
Tolerance on thickness	± 0.5	± 0.5	± 0.5	± 0.6	± 0.6	± 0.6	mm	EN 438-2:2016
Tolerance on length				+ 10			mm	EN 438-2:2016
Tolerance on width				+ 10			mm	EN 438-2:2016
Surface defects				max. 1 <sup>1)</sup> max. 10 <sup>2)</sup>			mm <sup>2</sup> /m <sup>2</sup> mm/m <sup>2</sup>	EN 438-4:2016
Edge defects				max. 3			mm	EN 438-4:2016
Straightness of edges				max. 1.5			mm/m	EN 438-2:2016
Squareness				max. 1.5			mm/m	EN 438-2:2016
Flatness	max. 5	max. 3	max. 3	max. 3	max. 3	max. 3	mm/m	EN 438-2:2016
Density				min. 1,350			kg/m <sup>3</sup>	EN ISO 1183-1
Bending strength				min. 80			MPa	EN ISO 178
Flexural modulus				min. 9,000			MPa	EN ISO 178
Resistance to crazing				min. 4			rating	EN 438-2:2016
Dimensional stability at elevated temperature (length)				max. 0.3			%	EN 438-2:2016
Dimensional stability at elevated temperature (width)				max. 0.6			%	EN 438-2:2016
Resistance to wet heat, 100 °C (smooth finishes)				min. 3			rating	EN 438-2:2016
Resistance to wet heat, 100 °C (textured finishes)				min. 4			rating	EN 438-2:2016
Resistance to dry heat, 160 °C (smooth finishes)				min. 3			rating	EN 438-2:2016
Resistance to dry heat, 160 °C (textured finishes)				min. 4			rating	EN 438-2:2016
Resistance to water vapour (smooth finishes)				min. 3			rating	EN 438-2:2016
Resistance to water vapour (textured finishes)				min. 4			rating	EN 438-2:2016
Resistance to immersion in boiling water (smooth finishes)				min. 3			rating	EN 438-2:2016
Resistance to immersion in boiling water (textured finishes)				min. 4			rating	EN 438-2:2016
Resistance to immersion in boiling water (edge)				min. 3			rating	EN 438-2:2016
Resistance to immersion in boiling water				max. 2 <sup>3) 4)</sup>			%	EN 438-2:2016
Resistance to surface wear				min. 150			cycles	EN 438-2:2016
Resistance to scratching (smooth finishes)				min. 2			rating	EN 438-2:2016
Resistance to scratching (textured finishes)				min. 3			rating	EN 438-2:2016
Resistance to impact by large diameter ball – impression diameter				max. 10			mm	EN 438-2:2016

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Specification							Unit	Standard
Nominal thickness	9	10	11	12	13	15	mm	
Resistance to impact by large diameter ball - Fall height	min. 1,800						mm	EN 438-2:2016
Stain resistance (groups 1 & 2)	min. 5						rating	EN 438-2:2016
Stain resistance (group 3)	min. 4						rating	EN 438-2:2016
Resistance to colour change (xenon arc light)	4 to 5 Grey Scale Grade							EN 438-2:2016
Reaction to fire	normally flammable							
Reaction to fire (Euroclass)	D-s2,d0							EN 13501-1, CWFT acc. to 2003/593/EG
Formaldehyde emission class	E1							EN 717-1

- 1) Dirt, spots and similar surface defects  
 2) Fibres, hairs and scratches  
 3) Mass increase  
 4) Thickness increase

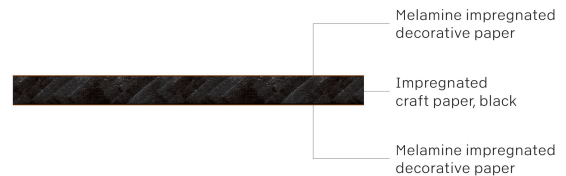
#### Additional information

Product standard	<ul style="list-style-type: none"> <li>EN 438-4</li> </ul>
Areas of application	<ul style="list-style-type: none"> <li>For unusual furniture and interior concepts in the home and contract sectors, in leisure and spa facilities, in shop design, in catering, as well as in humid and wet conditions in which particular robustness, durability and high hygienic standards including aesthetics are required of the material. The material is suitable for open edge solutions as well as for engraving for individual 3D effects.</li> </ul>
Core material	<ul style="list-style-type: none"> <li>Compact laminate black</li> <li>Solid, black pigmented compact laminate core, impact resistant and moisture resistant for applications with high specification demands.</li> </ul>
Product safety	<ul style="list-style-type: none"> <li>The decorative surface and the core consists of paper layers that are impregnated with thermosetting resins. The resins harden completely during the manufacturing process by heat and high pressure. They form a stable, resistant and non-reactive material.</li> <li>The surface is physiologically safe, and approved for direct contact with food acc. to Regulation (EU) No. 10/2011.</li> <li>This product follows the REACH regulation EC 1907/2006 an article. Following Article 7 it does not need to be registered.</li> </ul>

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#### Special

- Certificate Blue Angel - Ecolabel (RAL DE-UZ 76)
- FSC®-certification (license code: FSC-C011773) or PEFC-certification (license code: PEFC/04-32-0828) - available on request.
- The coarser the structure and the lighter the decor, the greater the scratch resistance.
- The smoother the structure and the the darker the decor, the more sensitive it is to stains.
- For production-related reasons, there may be minor colour variations in the black material core.
- Due to the black core of the material, minor decorative deviations to other products cannot be avoided.
- Depending on the decor and surface texture, slightly different surface visual impressions can result between cut panels viewed from different angles. This is a result of the production methods and does not constitute a quality defect.
- Especially for large applications, we recommend paying attention to the colour and texture uniformity of the boards and cut products used when further processing and installing and that the production direction is taken into account.
- Also in anti-bacterial quality – with Duropal microPLUS®.

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