2. Technical Datasheets, Certifications and Test reports.

For any queries, kindly contact our Specifications Manager
Michael Samuel +20 1122 049 075
Michael.eg@greenlam.com

Greenlam Compact Technical Information

Maintenance

1. Maintenance & Cleaning

The daily maintenance of Greenlam Compact laminates can be carried out easily using a soapy sponge or soft cloth. For more persistent marks and stubborn stains, use an appropriate non-scratch liquid or cream, or organic solvent (preferably white spirit or acetone), rinsing well with warm water and ensure all residue is wiped away with an all-purpose paper towel or lint-free cloth. Proprietary window cleaners are excellent for avoiding drying marks and can be used safely.

You should ***never use abrasive products or cleaners*** (including scouring pads and powders, steel wool, black soap) or bleaching agents, wax furniture polishes and cleaning products with strong acid or alkali bases.

Any spots of glue must be removed immediately. Neoprene or silicone joint spots must be removed with the appropriate solvent and vinyl glue with hot water. Residual flakes of glue may be removed with acetone.

1.1 A note on textured finishes

By their nature, Greenlam textured finishes can be more difficult to clean than smooth surfaces. For stubborn marks in heavily textured Greenlam surfaces, a nylon bristle brush can be used in conjunction with any of the above cleaners to remove stains and stubborn marks.

1.2 Resistance to stains

The non-porous nature of Greenlam laminates means they have excellent resistance to stains:

No discolouration to the surface after 16 hours	Coffee, tea, fizzy and cola drinks, wine vinegar, fruit and vegetables, alcoholic drinks, meats and poultry, animal fats and oils, mustard, water, salt solutions, detergents, toothpaste, hand cream, nail varnish and nail varnish remover, lipstick, watercolour paint, laundry marking ink, ballpoint ink, soapy solutions, commercial disinfectants, acetone-based scouring solutions and other organic solvents, 10% citric acid, basic stain removers diluted with water (<10%), oxygenated water, ammonia (concentrated at 10%)
No discolouration to the surface if thoroughly cleaned within 10-15 minutes	Formic acid (<10% hydrochloric acid, methylene blue (at 25%), caustic soda in water (30% acetic acid), sanitary whitening and cleaning agents based on hydrochloric acid (at 3%), bleach, acid cleaning agents for metals, Mercurochrome®, wax polish, colouring and colour lightening agents for hair, iodine dye, boric acid, varnish, lacquer and adhesives, hardening paint (except fast-drying products, limescale removers based on aminodosulfonic acids (<10%)

Risk that the surface will detoriate	**Acids concentrated at more than 10%:** Aminosulfonic acid, arsenic acid, hydrochloric acid, nitric acid, parchloric acid, phosphoric acid, sulphuric acid. **Strong acids:** Hydrobromic acid, chromic acid, hydrofluoric acid, sulfochromic acid, aqua regia.

Storage & Handling

1. Handling

Care should be taken when handling Greenlam Compact laminates to avoid accidental breakages and damage. When loading and unloading, sheets should be lifted and not slid. Care should be taken to avoid abrasion between decorative surfaces.

Individual sheets should be carried with the decorative face towards the body to reduce the risk of damage. Large sheets should always be handled by two people.

When transporting stacks of sheets with mechanical handling vehicles, suitable sized and strength pallets should be used.

If panels are covered in a protective film, this should be left on as long as possible after installation, but for no more than two months.

2. Storage

It is recommended to store Greenlam Compact laminate panels flat face-to-face in a temperature range between 10 and 30^{o}C and in a humidity of between 40% and 60%.

If Compact sheets are not stored flat for any length of time, deformation can occur which is almost impossible to correct, particularly with thicker boards.

Panels should be allowed to acclimatise and stabilise before fabrication for a minimum of 48 hours.

3. Machining & Cutting

The increased thickness of Compact laminate from Greenlam imposes more demand on cutting tools and causes greater wear. Slower feed-speeds than those generally used for cutting standard Greenlam HPL will need to be employed to ensure the best end result. The speed will depend on the thickness of Compact grade specified. For optimum results, tool manufacturers should be consulted as to the type and quality of tungsten carbide tipping required. Where long production runs and a high quality finish is required, PCD tooling is recommended. Localised heating through poorly maintained saws and cutters should be avoided.

3.1 Sawing

Saw blades normally used for cutting dual sided composites are recommended for cutting Compact grade laminates. Saws of less than 2mm thickness are to be avoided. Breakout on the underside of Compact grade laminate can be reduced with the following methods:

- By the use of a pre-scoring blade on the reverse
- Using a base-board of plywood or hardboard beneath the Compact sheet
- Altering the exit angle of the saw blade by adjusting the height setting

3.2 Profile Cutting and Edge Finishing

It is not necessary to apply edging strips or sealants to Compact grade laminate from Greenlam and for many applications, clean saw edges are sufficient.

A spindle moulder or router may be used to achieve a superior finish or a profiled edge, though for this type of work PCD tooling is strongly advised. Although it is not possible to achieve no cutter marks it is possible to minimise them for subsequent finishing by feeding the work at a constant controlled speed by the use of a mechanical power feed. Care should be taken to avoid pausing during cutting and profiling, as burn marks may result and these are difficult to remove.

Edges can be enhanced by buffing with steel wool and applying silicone-free oil. Chamfering the edges of Compact panels will reduce the risk of edge impact damage.

4. Pre-conditioning

Compact grade laminate is less susceptible to changes in humidity than standard HPL. Prior to fabrication or installation, Compact grade laminate must be conditioned for a period of at least 48 hours in a temperature range between 10 and 30°C and in a humidity of between 40% and 60%, and kept away from direct heat. Failure to adhere to these conditions can have adverse affects on the lifetime of the Compact grade laminate.

Composition

Greenlam Compact grade laminates are man-made surfaces of high density, consisting of layers of specially selected paper impregnated with thermoset synthetic resins fused together under extreme pressure and heat. The surface layers, which incorporate solid colours, patterns or natural decors, use melamine-based resins to provide high-resistance to wear, impact, heat and staining. The core layers use phenolic-based resins for strength and flexibility.