TREATED MELAMINE DECORATIVE PAPER PROGRAM
TECHNICAL DATA

PRODUCT DESCRIPTION
Melamine decorative papers are fused with heat and pressure directly to particleboard or medium density fiberboard (MDF) substrate in a short-cycle press. The melamine product compliments Laminate by Formica Group — Solid Colors, Patterns and Woodgrains.

COLOR SHEET AVAILABILITY
Solid Colors Range, Patterns and Woodgrains. Some exclusions apply, see availability list on www.formica.com.

SHEET WIDTHS
50", 62"

SHEET LENGTH
6', 7', 8', 10' and 12'

RECOMMENDED APPLICATION
Formica® Treated Melamine Decorative Papers can be used to product thermally fused melamine (TFM) panels for case-goods, institutional and hospitality furniture, office furniture, store fixtures, cabinetry, millwork and other vertical surfaces where indentation resistance and high wear are not required.

COMPOSITION OF PRODUCT
Formica Corporation decorative papers are alpha-cellulose papers with melamine-formaldehyde resins to meet the performance characteristics of today’s quick press cycles and surface requirements. The resins are introduced into the paper during an impregnation operation. The paper is first impregnated with a solution of the resin and then dried and partially cured (b-staged) in the curing ovens that are an integral component of the impregnation equipment (treater).

Cured melamine-formaldehyde resin is noted for its hardness, scratch-resistance and color stability; it is the most commonly used resin in the production of TFM laminates.

STORAGE
Saturated melamine papers should be stored in a controlled atmosphere to prevent an increase or decrease in their volatiles content, which will affect laminating performance. High humidity could also lead to blocking, while low humidity can dry out the paper and make it brittle. Polyester papers are not affected by humidity and have a longer shelf life. Extremes in temperatures should be avoided for all types of impregnated papers.

PRECONDITIONING
For best laminating results, the board substrate and saturated paper should both be brought to equilibrium at 35% to 45% relative humidity and 70°F (21°C).

PRESSING
It is recommended to press at 350 psi. Temperature can vary between 280°F to 370°F depending on the color and the type of press.

SUBSTRATES
Resin-impregnated papers are good vapor barriers, allowing very little moisture to escape through the surfaces of the substrate during pressing. Conversely, they provide resistance to moisture entering the panel after pressing. Hence, high moisture content of the substrate should be avoided as this may contribute to bond degradation within the substrate, steam blows, warp and poor bonding between the substrate and décor paper. Substrate moisture content should not exceed 6-8%; thus, shipping and storage conditions are important. Attempting to laminate on raw board that is either too hot or too cold can negatively affect laminating performance and the quality of the panels produced.

LIMITATIONS
TFM panels made with Formica® Treated Melamine Decorative Papers are for interior use only. Not all Laminate by Formica Group — Solid Colors, Patterns and Woodgrains can be matched exactly. The texture and gloss of the panel can change its apparent color. There are no specific industry standards for TFM panels.

Formica Corporation has no control over lamination process or substrate. Therefore, no warranty is expressed or implied for the finished melamine panel.

TECHNICAL SERVICES
Technical assistance may be obtained by calling 1-800-FORMICA™ / Jon Kaylor (Customer Service).

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