

## HANDLING AND PROCESSING LAMINATE SHEETS

### 1. DESCRIPTION OF THE PRODUCT

ELS laminates are decorative laminates based on curable resins. They are constructed by fusing multiple layers and consist of melamine resin impregnated decor paper and one or several phenolic resin impregnated core layers. These multiple layers are pressed together by means of high pressure and heat. The composition of the laminate, the qualities of resins and papers, the surface texture, the use of special overlays as well as the press parameters during production determine the quality of the laminate and ultimately the field or area of application for which it is suitable.

### 2. STORAGE

ELS laminates must be stored in enclosed, dry areas at approximately 18 °C to 20 °C and a relative humidity of approximately 55 % to 65 %.

After removing the original packaging, the laminate sheets should be stacked horizontally on a flat base of equal or greater dimension, with their edges flush.

### 3. HANDLING

Remove the packaging immediately and check for obvious signs of damage. Be sure to wear personal safety equipment such as gloves, safety shoes and other work wear. Abrasion between decorative faces and rubbing movements should be avoided. Care should be taken when handling decorative laminates to avoid breakages and damage.

- When loading and unloading, sheets should be lifted, not slid.
- Individual sheets should be carried with the decorative face towards the body.
- Sheets become rigid and thus easier to handle if they are bowed along the longitudinal axis.
- Large sheets should always be handled by two persons.
- Sometimes it is convenient to roll the sheet, decorative face inward, into cylinder of approximately 600mm diameter.

### 4. CUTTING LAMINATE

The laminate can be cut to size using standard woodworking equipment, e.g. panel saws, jigsaws, routers or hand-held circular saws. A good result will depend on many factors such as decorative face up, saw blade protection, feed rate, tooth pitch, rotation and cutting speed

### 5. CONDITIONING

Before processing both the timber substrate and the laminate should be conditioned under normal climatic conditions (approx. 20°C and relative humidity of 55% to 65%, so that both materials are at equilibrium of moisture content. Materials that are processed when they are too moist tend to shrink over time which can lead to cracks and distortion.