

## HIGH-PRESSURE LAMINATE AND COMPACT HPL

Touch finishes



Touch, Touch Roche and Touch Linimat are installed in the same way as the other finishes available in high-pressure and compact HPL (incl. the Monochrom range).

For more information, please refer to the Polyrey Collection brochure under the section "Usage Advice".

### 1. ESSENTIAL GUIDELINES TO BE FOLLOWED

- Adhere to the drying times of the panels and substrates before processing: minimum 48 hrs – 18/25 °C – 40–60% relative humidity in Europe.  
This recommendation specifically applies to the Monochrom high-pressure laminate range.
- The usual cutting, machining and drilling tools may be used. Tools must be diamond- or tungsten carbide-treated.  
The higher density of Monochrom high-pressure laminate makes it necessary to adjust feed rate and cutting speed settings to prevent any yellowing caused by heating of the tools. Additionally, a finishing step after cutting is recommended.
- It is recommended to keep the oversize to a minimum during rough cutting to prevent chipping during finishing owing to the highly resistant Touch surface.
- Glueing: note that a PVA glue that cures at room temperature is recommended for glueing Monochrom high-pressure laminate. If using heat-cured adhesive, do not exceed 60 °C for 120 s. PVA glue yields better aesthetic results (visibility of adhesive joint) and better substrate/laminate panel bonding, thereby avoiding the risk of cracking during processing.
- The inside corners of openings and cuts must be rounded to the widest radius possible (at least 5 mm for a 250 mm opening). With Monochrom high-pressure laminate panels, this radius must be increased to 8 mm to eliminate any risk of cracking.  
The radius must be increased in proportion to the length of the opening.

## 2. SPECIFIC CONSIDERATIONS WITH THE TOUCH FINISHES



- **Cutting:** Ensure that all panels are cut in the same direction, i.e. crosswise or lengthwise (consider marking them before cutting). This is to prevent any difference in shade due to the reflection of light. Similarly, placing a panel vertically or horizontally may create a minor difference in shade owing to a slight reflection of light by the finishes.



- **Protective film:** Protects the surface against dirt and any minor scratches during transport and handling. Keeping it intact during machining is recommended. It is suggested to carry out an initial test cut to make sure that it will work with the protective film.



- **Balance or backing (for high-pressure laminate):** Use an identical panel for backing.

This recommendation is particularly important with the Monochrom high-pressure laminate range, whose dimensional stability is lower than that of the high-pressure laminate panels. It also applies to critical applications such as:

- . A freestanding panel not supported by any rigid structure,
- . The installation of a large area of panelling,
- . Wall panelling,
- . Rooms or areas subjected to variations in temperature and humidity (such as air-conditioned rooms or installation near a source of heat).

Additionally, to prevent any subsequent warpage of the finished panel, both sides must be kept under the same temperature and humidity conditions and must be cut in the same sanding direction.

For applications in non-critical settings such as small surface areas, mechanical fastening and average humidity and temperature conditions, it is possible to use another high-pressure laminate backing sheet of the same kind and thickness with a smooth surface. In this scenario, note that the risk of warpage cannot be totally eliminated, so the following recommendations are made:

- . Minimum substrate thickness 16 mm
- . Average humidity and temperature conditions 18 to 25 °C – 45 to 55% relative humidity
- . Use room-temperature bonding with a PVA glue to limit stress on the high-pressure laminate panel.
- . The use of contact glues is not recommended.

The use of a low-cost backing sheet must always be tested beforehand. This particularly applies to the Monochrom high-pressure laminate range, which is more sensitive to variations in temperature and humidity. The responsibility for imperfections in flatness owing to the use of asymmetrical assemblies lies with the person who has made them.



- **Cold bending:** Available in standard (non-postformable) grade, the high-pressure laminate can be cold-bent. A panel may be bent to a radius of:
  - . 20 cm if 0.8 mm high-pressure laminate
  - . 30 cm if 1.2 mm Monochrom high-pressure laminate



- **Edges:** A selection of decors in thermoplastic edging with anti-fingerprint technology is available from our partners. Please contact us for information.