

BP, BP-HG, BP-HR, BP ANTISTATIC,  
BP ANTI BACTERICAL, HP

## PRODUCT CLASS

Decorative melamine papers (for low and high pressure lamination).

## DESCRIPTION

MEL products are decorative papers impregnated with melamine or melamine-ureic resins, dedicated to the furniture industry. The range includes products for chipboards producer or MDF (BP, BR-HR, BP-HG) types or for the production of laminates HPL and CPL (HP) type.

- MEL BP melamine paper for low pressure lamination
- MEL BP-HG high gloss melamine paper for low pressure lamination
- MEL BP-HR high resistance melamine paper for low pressure lamination
- MEL BP ANTISTATIC melamine paper for low pressure lamination with antistatic properties
- MEL BP ANTIBACTERICAL melamine paper with anti-bacterial properties
- MEL HP melamine paper for high pressure lamination

Generally the use of MEL papers gives coated surfaces special characteristics of resistance against abrasion, scratch and chemical agents. The types MEL BP-HG can reach up to a 100 gloss finishing (specular brightness) if used in a press equipped with a specific plate. The type MEL BP-HR gives the coated surfaces a higher resistance against abrasion, without using overlay and with a lower gramage balancing paper.

## ADVANTAGES

- Wide range of decors (of wood grain, fancy, plain colours etc);
- E1 class finishings at low emission of formaldehyde are possible;
- Higher surface scratch resistance;
- Higher surface abrasion resistance, particularly MEL BP-HR;
- Higher surface against cold liquids;
- Higher surface against water and steam.

## APPLICATIONS

MEL BP, MEL BP-HG, MEL BP-HR (low pressure lamination)

- Temperature of the press oil: 190° ÷ 200°C
- Running pressure: 20 ÷ 30 kg/cm<sup>2</sup>
- Pressing time: 15" ÷ 45"
- Closing-time: max 3"

MEL HP (high pressure)

Conditions vary according to the plant.

The suggested conditions are purely indicative and must be adjusted according to the plant, the type of panel and the type of paper (gramage, dark or light décor). The use of our melamine papers for the production of fire-proof and water-proof chipboards are special applications; tests before industrial production are recommended.

## AVAILABLE SIZES

The product can be supplied in sheets or on rolls:

- Raw gramage: 60 g/m<sup>2</sup> and more;
- Standard widths: 125, 127, 132, 155, 188, 207, 215, 220 and 228 cm;
- Sheet length: from 2460 to 5600 mm.

## TECHNICAL CHARACTERISTICS

Technical characteristics of MEL papers are summarized in the table (see page next page).

## PACKAGING AND STORAGE

All MEL papers are available as rolls and sheets, protected by shock-proof packaging.

Sheets are packed on pallets with covers or on wooden pallets. The rolls are available with vertical and horizontal packaging on pallet. MEL BP and MEL HP shelf life is of six months, if kept in the original packaging and at correct environmental conditions (relative humidity 55-60% and temperature 10-25°C). MEL BP-HG, MEL BP-HR papers and in general the metallized and the special variations of MEL papers preserve their characteristics unaltered for three months at proper environmental conditions (relative humidity 55-60% and temperature of 10-25 °C).

## NOTES

The information contained in this document is based on our current knowledge and experiences. However it cannot be considered as exhaustive, but purely indicative. We suggest to test the product in advance in your own plant. Neodecortech S.p.A. can not be considered as responsible for any eventual damage deriving from the use of the above mentioned product. For further information, the safety sheets concerning every product of Neodecortech S.p.A. are available.

## TECHNICAL DATA

Decorative melamine papers (for low and high pressure lamination).

TECHNICAL PARAMETERS <sup>(1)</sup>			Melamine paper for low pressure lamination	High gloss melamine paper for low pressure lamination	High resistance melamine paper for low pressure lamination	Melamine paper for low pressure with antistatic properties lamination	Melamine papers with anti-bacterial properties	Melamine paper for high pressure lamination
PROPERTIES	Test method	Measure unit/ class/ level	MEL BP	MEL BP HG	MEL BP HR	MEL BP ANTI-STATIC	MEL BP ANTI-BACTERIAL	MEL HP
1	Raw grammage	Acc. to DIN EN ISO 536	g/m <sup>2</sup>	≥ 60	≥ 60	≥ 60	≥ 60	≥ 60
2	Scratch resistance	Acc. to EN 438-2 punto 25.6	N	≥ 2.0	≥ 2.0	≥ 2.0	≥ 2.0	≥ 2.0
3	Stain resistance	Acc. to UNI EN 12720 Class. secondo UNI 10944	Class	A/B	A/B	A/B	A/B	A/B
4	Abrasion resistance	Acc. to EN 438-2 punto 10.2 Class. secondo EN 14322	Class	1	1	2	1	1
5	Resistance against steam	Acc. to UNI EN 14323 punto 5.11	Class	≥ 4	≥ 4	≥ 4	≥ 4	≥ 4
6	Dry heat resistance	Acc. to UNI EN 12722	Class	5	5	5	5	5
7	Wet heat resistance	Acc. to UNI EN 12722	Class	5	5	5	5	5
8	Tendency to retain dirty	Acc. to UNI 9300	Class	5	5	5	5	5
9	Light resistance	Acc. to EN ISO 4892-2	Level (blue scale)	≥ 6	≥ 6	≥ 6	≥ 6	≥ 6
10	Formaldehyde emission	Acc. to UNI EN 717/2	mg/m <sup>2</sup> h	≤ 0,3	≤ 0,3	≤ 0,3	≤ 0,3	≤ 0,3
11	Anti-bacterial properties	Acc. to JIS Z 2801:2000 / ISO 22196:2007	Log Reduction (%)	-	-	-	-	2.7-4.6 (99.8-99.9)
12	Antistatic proprieties	Acc. to EN 1815	in conformity / not in conf.	-	-	-	In Conf.	-

<sup>(1)</sup> In the table are shown only the properties of MEL/BP on a chipboard and not those of MEL HP, because these latter are strictly connected to the lamination treatment characteristics. This version cancels and replaces the previous ones.

<sup>(2)</sup> The data mentioned in the above table have to be considered as purely indicative as they depend on the press conditions and on the used chipboard.