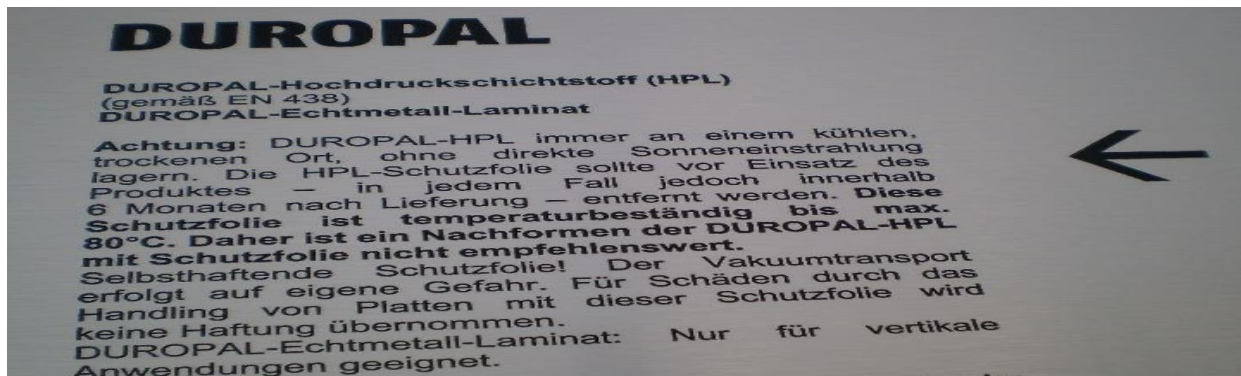


PRODUCT INFORMATION

Duropal HPL, Duropal HPL Compact and Duropal Elements with transport foil



CHARACTER AND PERFORMANCE OF THE TRANSPORT FOIL

Intended use

- Self-adhesive Duropal transport foils are intended for the temporary protection of Duropal HPL products. This includes protection against damage such as scratching or abrasion as well as soiling, during transport from the factory to the customer. Other requirements such as milling, drilling, edge varnishing and processing or postforming of Duropal HPL with film are the responsibility of the customer. These requirements must be tested by the customer.
- The transport foils must be removed before processing the Duropal HPL products, but in any case within 6 months after delivery.
- Duropal transport foils are developed for the climatic conditions in Central Europe. In the case of sea container transport and use in regions of tropical / subtropical climatic zones, the delivery of foiled Duropal products is at the risk of the customer. In the case of a planned sequence of deliveries, these must be approved by the customer by means of suitable test deliveries.

Transport and storage

- Duropal HPL with transport film is ideally transported flat on a pallet. Compression when rolling up for shipping via HPL carton or HPL drum can lead to detachment of the film from the HPL surface. In this case, a change in film adhesion does not represent a defect.
- When transporting by air, temperatures as low as -20°C are possible in the unheated cargo hold. This can also change the adhesive strength of the film.
- When transporting, loading and unloading or stacking Duropal HPL products with transport foil, make sure that the foil is not cut or detached by sharp objects.
- Lifting via vacuum lifter is at your own risk. No liability is accepted for damage caused by handling Duropal HPL panels with transport foil.

- Foiled Duropal HPL products must be stored away from direct sunlight, heat and moisture. These influences change the required properties of the transport foils and may lead to an increase in adhesive strength or to adhesive residues on the HPL surface. Storage in a cool, dry place at temperatures of 18 – 25 °C and a humidity of 50 – 65 % is ideal.

Postforming

- The transport foil is temperature-resistant up to max. 80 °C. Re-shaping of the Duropal HPL with this film is impossible.
- Duropal HPL in structure high gloss / enhanced high gloss can optionally be supplied with a transport foil and postforming properties. The temperature resistance is max. 180 °C.
- The suitability of the postforming film is to be ensured by the customer's own tests.

Processing

- Particularly in the case of large-area applications, attention must be paid to the colour and structural uniformity of the panels and blanks used and the material must be processed taking into account the direction of production.
- To avoid aesthetic and visual impairments, it is possible to process or install the Duropal HPL product with transport foil, observing the longitudinal direction or the printed direction arrows.
- All requirements for foiled Duropal HPL products with regard to machining and processing must be tested by the customer in his own trials.

Disposal / Recycling

- Removable protective films are recyclable. If recycling is not possible, the waste is disposed of properly in accordance with official regulations.
- Example of waste code number: AVV 150102

REMOVAL OF TRANSPORT FOILS

Removing the foil

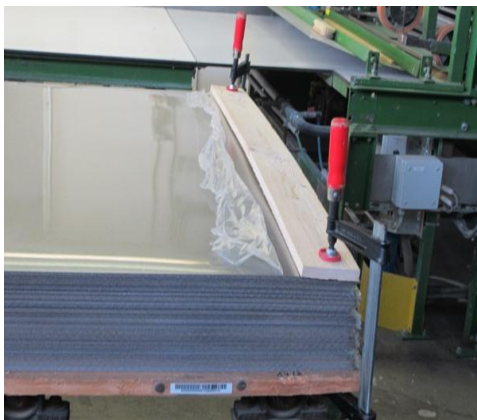
- Transport foils must be removed evenly at room temperature ≥ 18 °C, not erratically, and at a flat angle to the HPL surface. Overstretching of the film must be avoided. A small distance between the sheet and the tensile source reduces the stretching of the film.
- If the film adheres strongly (due to low temperature or after direct sunlight or overlaying), it can be warmed carefully with a hair dryer or a hot air dryer. Heat softens the film and the adhesive layer, and the heated film can be removed much more easily.
- Any adhesive residues remaining on the product surface can be removed with the adhesive residue removers listed at the end of this document.

January 2023

How to remove transport foils



carefully lift up the foil at the edge at one end



fix the laminate



wind the film around a "sleeve"



generally the foil can be pulled off with little effort

REMOVAL OF ADHESIVE RESIDUES

The following cleaning agent recommendations are based on Pfleiderer's own HPL cleaning tests of film adhesive residues. The manufacturer's instructions for the cleaners must always be observed and adhered to.

In general, carry out basic cleaning after treatment with special cleaners.

Cleaning agent	Evaluation
Sonax Professional Klebstoffrestentferner	☺*
Nigrin Repairtec Speziallöser	☺*
Mellerud Aufkleber und Klebereste Entferner	☺*
Hotrega Aufkleber und Klebereste Entferner	☺* ²
Würth Industrie-Clean	☺*
Koch Chemie Eulex-Speziallöser	☺* ²
Oranex Kraftreiniger	☺*
CLEANOFANT Aufkleber + Klebstoff-ENTFERNER	☺*

☺* good cleaning, surface film is to be removed separately

☺*² very good cleaning, dries without residues

PM HPL / Elements / Lacquered boards

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