

## High Pressure Laminates: 0.6mm & 0.8mm

S. No	Type Test Description	UNIT	P, VGP-(THICK. 0.6mm) FLEXI LAM		S, HGS-(THICK. 0.8mm) PRIME LAM	
			Standard Value	ASIS Value	Standard Value	ASIS Value
	Dimension Tolerance					
1	Thickness	mm	±0.1	complies	±0.1	complies
2	Length	mm	+10, -0	complies	+10, -0	complies
3	Width	mm	+10, -0	complies	+10, -0	complies
4	Staightness of Edges	mm/m	1.50	complies	1.50	complies
5	Warping t <2.0mm (max)	mm	120	complies	120	complies
6	Squareness of Laminates	mm/m	1.50	complies	1.50	complies
7	Appearance		Free form Surface Defects	complies	Free form Surface Defects	complies
8	Resistance to surface Wear (Rev.)	>	150	200	350	400
9	Resistance to immersion in boiling water					
	(a) Thickness Increase (max)	%	23.0	20.13	14.0	10.1
	(b) Mass Increase (max)	%	21.0	18.25	12.0	8.30
	(c) Appearance Grade : (not worse than)		3	3	4	complies
10	Dimensional stability at Deviated temp (max)	%	-MD-0.70, CD-1.20	-MD-0.35, CD-0.65	-MD-0.625, CD-1.10	-MD-0.30, CD-0.65
11	Resistance to impact by small diameter ball (min)	N	15.0	20.0	20.0	30
12	Resistance to scratching (min)	N	1.75	2.50	2.0	4.0
13	Resistance to staining					
	(a) Group 1 & 2 Grade : (not worse than)		5	complies	5	complies
	(b) Group 3 & 4 Grade : (not worse than)		3	complies	4	complies
	(c) Resistance to steam Grade : (not worse than)		3	complies	3	complies
14	Formability Test (max)	mm	10	6	NA	NA
15	Resistance to Blistering (min)	sec	10	17	NA	NA
16	Resistance to dry heat at 180 C Grade : (not worse than)		NA	NA	4	complies
17	Resistance to cracking (thin laminates) Grade : (not worse than)		NA	NA	4	complies
18	Resistance to cigarette burns Grade : (not worse than)		NA	NA	3	complies

### High Pressure Laminates: 1.0mm & 1.5mm

Properties	Unit	Thickness 1.0 MM ASIS LAM		Thickness 1.5 MM ASIS LAM	
		Standard Value	ASIS Value	Standard Value	ASIS Value
<b>Thickness</b>	mm	±0.1	1.0	±0.15	1.5
Resistance to surface Wear (revolutions)	>	350	400	350	450
Resistance to immersion in boiling water					
Mass increase (Max)	%	10.0	6.0	7.5	5.5
Thickness increase (Max)	%	11.8	7.0	8.5	7.0
Resistance to dry heat 180 C		passes	Complies	passes	Complies
Dimensional stability at deviated temperature					
(a) Longitudinal (max)	%	0.55	0.275	0.44	0.30
(b) Transverse (max)	%	1.025	0.48	0.86	0.66
Dimensional stability at 20 C					
(a) Longitudinal (max)	%	0.375	0.275	0.31	0.23
(b) Transverse (max)	%	0.60	0.48	0.49	0.38
Resistance to impact by small diameter ball (min)		20N	25N	20N	30N
Resistance to cracking		passes	Complies	passes	Complies
Resistance to scratching (min)		2N	3N	2N	3.5N
Resistance to staining		passes	Complies	passes	Complies
Resistance to colour change		Wool Standard		Wool Standard	
1. In Xenon light		6	6	6	6
2. In Enclosed Carbon ARC light		5	5	5	5
Resistance to cigarette burns		3	3	3	3
Resistance to steam		4	4	4	4
Appearance		Free form surface defects	Complies	Free form surface defects	Complies
Specific gravity gm/c.m (min)			1.36		1.4