

# Inner Laminates

HPL  
High Pressure Laminates

Technical Data Sheet

## Technical Specifications | Inner Laminates | High Pressure Laminates



0.8MM LAMINATES/HPL					
1	Product Features	Dorby ARC 0.7mm/0.8mm Inner Laminates			
2	Classification (BIS 2046:1995)	Table 1 - Clause 4	VLS	VLS	
S.NO.	PROPERTIES	TEST METHOD AS PER IS 2046:1995	UNIT	SPECIFIED VALUES	Typical Dorby Vesta Values
<b>DIMENSIONAL PROPERTIES</b>					
1	Length & Width	5.4.6	mm	1220 x 2440 +10 -0	Conforms
2	Thickness & Maximum Variation	5.3.1	mm	0.7mm/0.80 mm ±0.10 %	Conforms
3	Flatness	5.4.5	mm	120mm (max)	80mm (max)
4	Edges Straightness	5.4.7	mm/M	1.5mm (max)	Conforms
5	Edges Squareness	5.4.8	mm/M	1.5mm (max)	Conforms
<b>SURFACE PROPERTIES</b>					
1	Surface Quality				
	a) Spot, Dirt & similar surface defects	5.4.1.1	mm <sup>2</sup>	1mm <sup>2</sup> /M <sup>2</sup> (max)	Conforms
	b) Fibers, Hairs & Scratches	5.4.1.2	mm	10mm/M <sup>2</sup> (max)	Conforms
2	Resistance to steam	5.5 - Table 7 (xv)	Grade	Not worse than 3	Conforms
3	Resistance to surface wear	5.5 - Table 7 (i)	Rev.	50 (min) (FP)	Conforms
4	Resistance to scratching	5.5 - Table 7 (ix)	N	> = 1.50	1.75 (Min)
5	Resistance to staining	5.5 - Table 7 (x)			
		Group 1 & 2	Grade	Not worse than 5	Conforms
		Group 3 & 4	Grade	Not worse than 4	Conforms
6	Resistance to color change in xenon Arc light	5.5 - Table 7 (xi)	Min	6 (min)	Conforms
<b>PHYSICAL PROPERTIES</b>					
1	Resistance to immersion in boiling water				
	a) Mass increase	5.5 - Table 7 (ii)	%	12 (max)	11 (Max)
	b) Thickness increase	5.5 - Table 7 (ii)	%	14 (max)	10 (Max)
	c) Appearance	5.5 - Table 7 (ii)	Grade	Not worse than 4	Conforms
2	Dimensional stability at deviated temperature				
	a) Longitudinal	5.5 - Table 7 (iv)	%	0.65	Conforms
	b) Transverse	5.5 - Table 7 (iv)	%	1.15	Conforms
3	Resistance to impact by small diameter ball	5.5 - Table 7 (vi)	N	15 (min)	Conforms
4	Resistance to cracking	5.5 - Table 7 (viii)	Grade	Not worse than 4	Conforms
	Production Manager				Operation Manager
<b>Nomenclature :</b>					
<b>1) Class/Rating - 1 = Surface Damage, 2 = Severe appearance alteration, 3 = Moderate change, 4 = Slightly visible change at certain angle, 5 = No change</b>					
<b>Note : Whereas Dorby products are manufactured thoroughly to standards, the nature of the application procedure is beyond our control. The values given above are to the best of our knowledge but without liability/warranty, expressed or implied.</b>					

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