



**DORBY**<sup>®</sup>  
IMAGINE. IMPLEMENT

# 1mm Laminates

HPL  
High Pressure Laminates

Technical Data Sheet

## Technical Specifications | 1mm Laminates | High Pressure Laminates



1		Product Features		Dorby 1mm Laminates			
2		Classification (BIS 2046:1995)		Table 1 - Clause 4		Surface Type	
				HGS	HGS	HGS	HGS
				Texture	High Gloss	Anti Finger	Uni/Colour Core
S.NO.	PROPERTIES	TEST METHOD AS PER IS 2046:1995	UNIT	SPECIFIED VALUES	SPECIFIED VALUES	SPECIFIED VALUES	SPECIFIED VALUES
<b>DIMENSIONAL PROPERTIES</b>							
1	Length & Width	5.4.6	mm	1220 x 2440 +10 -0	1220 x 2440 +10 -0	1220 x 2440 +10 -0	1220 x 2440 +10 -0
2	Thickness & Maximum Variation	5.3.1	mm	1.00 mm ±0.10 %	1.00 mm ±0.10 %	1.00 mm ±0.10 %	1.00 mm ±0.10 %
3	Flatness	5.4.5	mm	120mm (max)	120mm (max)	120mm (max)	120mm (max)
4	Edges Straightness	5.4.7	mm/M	1.5mm (max)	1.5mm (max)	1.5mm (max)	1.5mm (max)
5	Edges Squareness	5.4.8	mm/M	1.5mm (max)	1.5mm (max)	1.5mm (max)	1.5mm (max)
<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)	1mm <sup>2</sup> /M <sup>2</sup> (max)	1mm <sup>2</sup> /M <sup>2</sup> (max)	1mm <sup>2</sup> /M <sup>2</sup> (max)
	b) Fibers, Hairs & Scratches	5.4.1.2	mm	10mm/M <sup>2</sup> (max)	10mm/M <sup>2</sup> (max)	10mm/M <sup>2</sup> (max)	10mm/M <sup>2</sup> (max)
2	Resistance to dry heat at 180°C	5.5 - Table 7 (iii)	Grade	Not worse than 4	Not worse than 3	Not worse than 4	Not worse than 4
3	Resistance to steam	5.5 - Table 7 (xv)	Grade	Not worse than 4	Not worse than 4	Not worse than 4	Not worse than 4
4	Resistance to surface wear	5.5 - Table 7 (i)	Rev.	350 (min) (FP)	350 (min) (FP)	350 (min) (FP)	350 (min) (FP)
5	Resistance to scratching	5.5 - Table 7 (ix)	N	> = 2	> = 2	> = 2	> = 2
6	Resistance to staining	5.5 - Table 7 (x)					
		Group 1 & 2	Grade	Not worse than 5	Not worse than 5	Not worse than 5	Not worse than 5
		Group 3 & 4	Grade	Not worse than 4	Not worse than 4	Not worse than 4	Not worse than 4
7	Resistance to cigarette burns	5.5 - Table 7 (xii)	Grade	Not worse than 3	Not worse than 3	Not worse than 3	Not worse than 3
8	Resistance to color change						
	a) In xenon Arc light	5.5 - Table 7 (xi)	Min	6 (min)	6 (min)	6 (min)	6 (min)
	b) In enclosed Carbon Arc light	5.5 - Table 7 (xi)	Min	5 (min)	5 (min)	5 (min)	5 (min)
<b>PHYSICAL PROPERTIES</b>							
1	Resistance to immersion in boiling water						
	a) Mass increase	5.5 - Table 7 (ii)	%	10 (max)	10 (max)	10 (max)	10 (max)
	b) Thickness increase	5.5 - Table 7 (ii)	%	12 (max)	12 (max)	12 (max)	12 (max)
	c) Appearance	5.5 - Table 7 (ii)	Grade	Not worse than 4	Not worse than 4	Not worse than 4	Not worse than 4
2	Dimensional stability at deviated temperature						
	a) Longitudinal	5.5 - Table 7 (iv)	%	0.55	0.55	0.55	0.55
	b) Transverse	5.5 - Table 7 (iv)	%	1.05	1.05	1.05	1.05
3	Resistance to impact by small diameter ball	5.5 - Table 7 (vi)	N	20 (min)	20 (min)	20 (min)	20 (min)
4	Resistance to cracking	5.5 - Table 7 (viii)	Grade	Not worse than 4	Not worse than 4	Not worse than 4	Not worse than 4

**Nomenclature :**

1) Class/Rating - 1 = Surface Damage, 2 = Severe appearance alteration, 3 = Moderate change, 4 = Slightly visible change at certain angle, 5 = No change

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.



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