



Engraving Laminate

Sawing (circular saw)

We recommend a carbon tipped saw for cutting this material. For best results, to be kept frequently sharpened. The saw must be shown approx: 3/8" - 1/2" above the material to get best cut. We do not recommend the use of high speed steel saws.

For drilling we recommend carbon tipped drills with a cutting angle of 60° and a slight flat ground on the cutting edge.

Method of Engraving

Any method of machine engraving which is capable of producing the required lettering or design is suitable.

Technical Data

Tests performed on specimen of thickness 1.5 mm and 3.0 mm.

| Mechanical Properties | Test Method | Values |
|-------------------------------|-----------------|---|
| Rockwell Hardness | ASTM D785 - 62 | 93 HRE |
| Resistance of surface to wear | NEMA LD1 – 2.07 | Weight loss: 70mg x 100 revs of the abraser |
| Tensile Strength | UNI | Longitudinal: 700 kg/sq.cm |

| Chemical Properties | Test Method | Values |
|--|-----------------|---|
| Immersion in boiling water | NEMA LD1- 2.07 | Weight increase: < 3% |
| Immersion in water at 20° C for 24 hrs | - | Weight increase: < 2 % |
| Surface resistance to boiling water | NEMA LD1 - 2.02 | No blisters or other visible alterations were noted |
| Colour fastness of surface to light | - | Xenotest index: 6 |
| Specific weight | ASTM C-303-56 | = 1,450 kg/m |
| Halogen Content | - | = Nil |

| Thermal Properties | Test Method | Values |
|--|-----------------|---|
| Surface resistance to high temperature | NEMA LD1 - 2/03 | No alteration except a light cloudiness in the finishes |
| Linear thermal expansion coefficient | ASTM D-696-44 | = 1.15 x 10-50 C-1 |

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