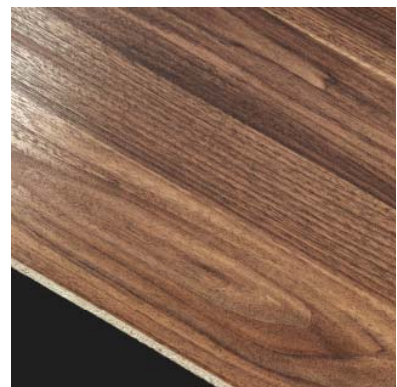


IHD-Quality-Guideline for decor finish foils

Version: 01 (2010)



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Leading manufacturers of decor finish foil have joined forces with the Institut für Holztechnologie Dresden gemeinnützige GmbH to form a “decor finish foils” work group for the purpose of drafting a uniform guideline for testing and defining the quality of their products regarding surface and environmental parameters.

Thereby, uniform, reproducible and differentiating test methods were to be derived by test-methodological investigations and verification in round-robin tests.

The objective of the investigations was to guarantee uniform declaration of product properties of decor finish foils (regardless of later application requirements) of all companies involved.

Decor finish foils are mainly used in the furniture industry, but also in the field of interior work (panels, strips, ...) for the decorative design of substrate materials made of chipboard or fibreboard.

Such decor finish foils are special papers, coloured or printed on, with a lacquer-coated surface. Thereby, the quality of the future decor finish foil is determined by the paper substrate, the printing process and the lacquer coating.

Figure 1 shows various ways of manufacturing decor finish foils.

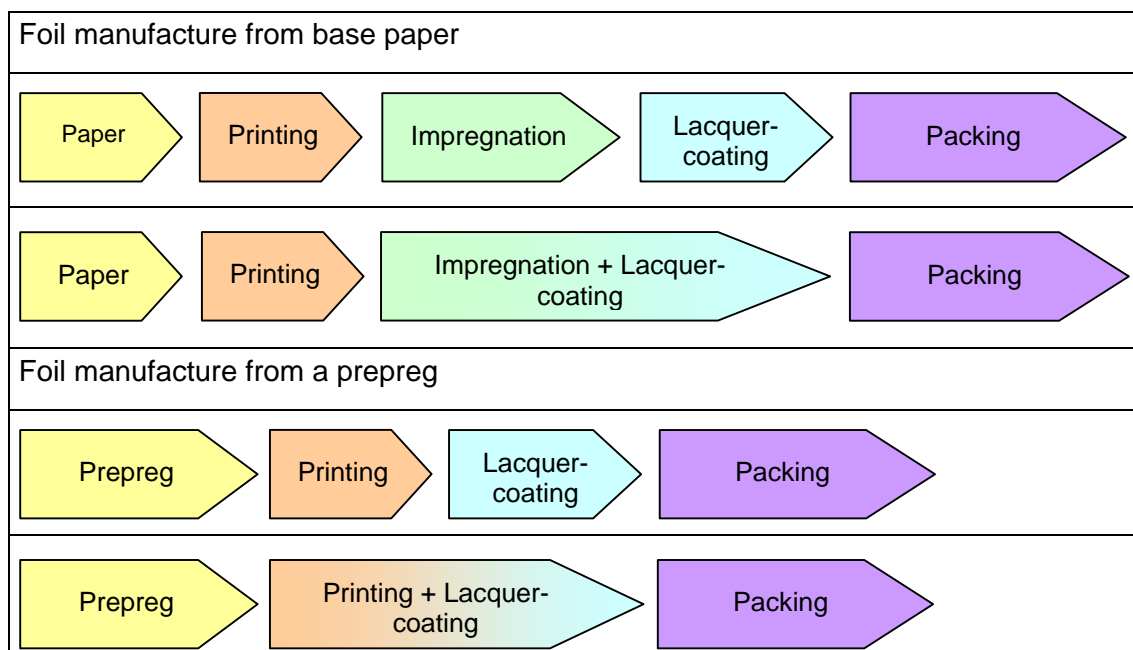


Figure 1: Possibilities of decor finish foil manufacture (Source: BauschLinnemann GmbH)

The processing firm is usually supplied with decor finish foils in reels and, by way of a separate layer of adhesive, glued to a substrate (generally a wood-based material) to form a final product.

Specifications for the declaration of properties of decor finish foils

| | Properties/Test Methods | Unit/ Category | Specification of the Property/Result (Example) |
|----|---|---|--|
| 1 | Thickness acc. to IHD-W-454 (06/2009) | µm | 70 |
| 2 | Grammage acc. to IHD-W-455 (06/2009) | g/m ² | 80 |
| 3 | Degree of gloss acc. to IHD-W-456 (06/2009) | at a measuring geometry of 60° | 34 (60°) |
| 4 | Opacity acc. to IHD-W-458 (06/2009) | grey-scale degree | 3,5 |
| 5 | Surface tension acc. to IHD-W-459 (06/2009) | mN/m | 44 |
| 6 | Chemical resistance acc. to: DIN 68861 T1/ IHD-W-460 (06/2009) | stress group 1C | fulfilled |
| | IKEA Standard IOS-MAT 0066/ IHD-W-460 (06/2009) | stress group R2/ R4 | fulfilled |
| | FIRA-Standard 6250 (horizontal stress)/ IHD-W-460 (06/2009) | FIRA 6250 (horizontal) | fulfilled |
| 7 | Abrasion resistance acc. to IHD-W-461 (06/2009) | class | 3 |
| 8 | Scratch resistance acc. to IHD-W-462, Test Method 1 (06/2009) | N | 0.3 |
| 9 | Tesa adhesive strength acc. to IHD-W-463 (06/2009) | assessment level / (time of exposure) | 1 – 5 / (16 h – 21 d) |
| 10 | Adhesive strength acc. to IHD-W-464 (06/2009) | cross-cut parameter | 1 – 5 |
| 11 | Light fastness acc. to EN 15187 | level | > 6; = 6 or < 6 |
| 12 | Formaldehyde emission on the basis of EN 717-2 | reference value (≤ 1,3 mg HCHO/hm ²) | is observed |
| 13 | Migration behaviour acc. to EN 71-3 | limit values for heavy metals in mg/kg | are observed |

Decor finish foils that have been tested by the independent and accredited test laboratory of the Institut für Holztechnologie Dresden gemeinnützige GmbH (IHD)

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in accordance with the provisions of this Quality-Guideline can be awarded a special test certificate and labelled with the quality seal as shown.



After having tested their own products by themselves in accordance with the IHD-Quality-Guideline for decor finish foils, the members of the work group label them with the jointly used and protected mark.



The IHD-Quality-Guideline and drafted test standards (in the form of IHD-Works Standards) are available free of charge as pdf-files on the Internet at

www.Dekorfinishfolien.de (in German)

or

www.decorfinishfoils.com (in English).

The following members of the work group “decor finish foils” at the IHD have joined in drafting this IHD-Quality-Guideline:

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