GREENLAM COMPACT TECHNICAL INFORMATION

MAINTENANCE:

1. Maintenance & Cleaning:

The daily maintenance of Greenlam Compact laminates can be carried out easily using a soapy sponge or soft cloth. For more persistent marks and stubborn stains, use an appropriate non-scratch liquid or cream or organic solvent (preferably white spirit, toluene, IPA or acetone), rinsing well with warm water and ensure all residue is wiped away with an all-purpose paper towel or lint-free cloth. Proprietary window cleaners are excellent for avoiding drying marks and can be used safely.

You should never use abrasive products or harsh cleaners like acid or thinner (including scouring pads and powders, steel wool, black soap) or bleaching agents, wax furniture polishes and cleaning products with strong acid or alkali bases.

Any spots of glue must be removed immediately. Neoprene or silicone joint spots must be removed with the appropriate solvent and vinyl glue with hot water. Residual flakes of glue may be removed with IPA or acetone.

1.1 Important Cleaning Advisory (Hospitals & Clinics):

In hospital or clinical environments, disinfectant cleaners that may cause staining should not be used on laminate surfaces.

Before using any such cleaner, it is strongly recommended to confirm its suitability with the manufacturer. Additionally, the cleaner should first be tested on a small, inconspicuous area to check for any adverse effects. The product should only be used on the full surface once complete satisfaction and compatibility are confirmed.

Note: Ensure that the cleaning cloth is not excessively wet while using any disinfectant cleaner. After cleaning, always wipe the surface with a dry cloth to prevent stain deposition or marks.

1.2 A note on textured finishes:

By their nature, Greenlam textured finishes can be more difficult to clean than smooth surfaces. For stubborn marks in heavily textured Greenlam surfaces, a nylon bristle brush can be used in conjunction with any of the above cleaners to remove stains and stubborn marks.

1.3 Resistance to stains:

The non-porous nature of Greenlam laminates means they have excellent resistance to stains:

No discoloration to the surface after 16 hours	Coffee, tea, fizzy and cola drinks, wine vinegar, fruit and vegetables, alcoholic drinks, meats and poultry, animal fats and oils, mustard, water, salt solutions, detergents, toothpaste, hand cream, nail varnish and varnish remover, lipstick, watercolour paint, laundry marking ink, ballpoint ink, soapy solutions, commercial disinfectants, acetone-based scouring solutions and other organic solvents, 10% citric acid, basic stain removers diluted with water (<10%), oxygenated water, ammonia (concentrated at 10%)
No discoloration to the surface if thoroughly cleaned within 10–15 minutes	Formic acid (<10%), hydrochloric acid, methylene blue (at 25%), caustic soda in water (30% acetic acid), sanitary whitening and cleaning agents based on hydrochloric acid (at 3%), bleach, acid cleaning agents for metals, Mercurochrome®, wax polish, colouring and colour lightening agents for hair, iodine dye, boric

	acid, varnish, lacquer and adhesives, hardening paint (except fast-drying products), limescale removers based on aminodosulfonic acids (<10%)
Risk that the surface will deteriorate	**Acids concentrated at more than 10%:** Aminosulfonic acid, arsenic acid, hydrochloric acid, nitric acid, perchloric acid, phosphoric acid, sulphuric acid. **Strong acids:** Hydrobromic acid, chromic acid, hydrofluoric acid, sulfochromic acid, aqua regia.

STORAGE & HANDLING:

1. Handling:

Care should be taken when handling Greenlam Compact laminates to avoid accidental breakages and damage. When loading and unloading, sheets should be lifted and not slid. Care should be taken to avoid abrasion between decorative surfaces.

Individual sheets should be carried with the decorative face towards the body to reduce the risk of damage. Large sheets should always be handled by two people.

When transporting stacks of sheets with mechanical handling vehicles, suitable sized and strength pallets should be used.

If panels are covered in a protective film, this should be left on as long as possible after installation, but for no more than two months.

2. Storage:

It is recommended to store Greenlam Compact laminate panels flat face-to-face in a temperature range between 10°C and 30°C and in a humidity of between 40% and 60%**.**

If Compact sheets are not stored flat for any length of time, deformation can occur which is almost impossible to correct, particularly with thicker boards.

Panels should be allowed to acclimatize and stabilize before fabrication for a minimum of 48 hours**.**

3. Machining & Cutting:

The increased thickness of Compact laminate from Greenlam imposes more demand on cutting tools and causes greater wear. Slower feed-speeds than those generally used for cutting standard Greenlam HPL will need to be employed to ensure the best end result. The speed will depend on the thickness of Compact grade specified.

For optimum results, tool manufacturers should be consulted as to the type and quality of tungsten carbide tipping required. Where long production runs and a high-quality finish is required, PCD tooling is recommended. Localized heating through poorly maintained saws and cutters should be avoided.

Greenlam Unicore panels require the use of very sharp or diamond-tipped tools and will require finishing after cutting. The cutting speed should be reduced and the use of a sacrificial panel is essential.

3.1 Sawing:

Saw blades normally used for cutting dual-sided composites are recommended for cutting Compact grade laminates. Saws of less than 2.00mm thickness are to be avoided.

Breakout on the underside of Compact grade laminate can be reduced with the following methods:

- Use of a pre-scoring blade on the reverse side
- Using a base-board of plywood or hardboard beneath the Compact sheet
- Altering the exit angle of the saw blade by adjusting the height setting

3.2 Profile Cutting and Edge Finishing:

It is not necessary to apply edging strips or sealants to Compact grade laminate from Greenlam and for many applications, clean saw edges are sufficient.

Edge Finishing & Routing:

A spindle moulder or router may be used to achieve a superior finish or a profiled edge, though for this type of work PCD tooling is strongly advised. Although it is not possible to achieve no cutter marks, it is possible to minimize them for subsequent finishing by feeding the work at a constant controlled speed using a mechanical power feed.

Care should be taken to avoid pausing during cutting and profiling, as burn marks may result and these are difficult to remove.

Edges can be enhanced by buffing with steel wool and applying silicone-free oil. Chamfering the edges of Compact panels will reduce the risk of edge impact damage.

4. Pre-conditioning:

Compact grade laminate is less susceptible to changes in humidity than standard HPL. Prior to fabrication or installation, Compact grade laminate must be conditioned for a period of at least **48 hours** in a temperature range between **10°C and 30°C** and in a humidity of between **40% and 60%**, and kept away from direct heat.

Failure to adhere to these conditions can have adverse effects on the lifetime of the Compact grade laminate.

COMPOSITION:

Greenlam Compact grade laminates are high-density engineered materials manufactured from multiple layers of specially selected paper impregnated with thermoset synthetic resins, fused together under high pressure and heat.

The surface layers incorporate solid colours, patterns or natural decors, and utilize melamine-based resins to deliver high resistance to wear, impact, heat and staining. The core is composed of phenolic resin-impregnated kraft paper, delivering excellent mechanical strength, dimensional stability and durability.

Compact laminates are typically manufactured in thicker gauges, making them suitable for self-supporting applications.