



# Product Update

OCT 18, 2013

#P143F

Revision 03

Applies to Flush doors

## HPDL FACED WOOD DOORS VS. LPDL FACED DOORS

High pressure decorative laminate (HPDL) is comprised of several layers of phenolic resin-impregnated kraft paper and a high-grade decorative print paper that is compressed under high pressure and heat for an extended period of time (approximately 1400 psi at two hundred-eighty degrees Fahrenheit (280° F) for fifty-four (54) minutes). The bottom layer of kraft paper is sanded to provide proper adhesion between the laminate and a substrate material.

Low pressure decorative laminate (LPDL) is a single thin sheet of decorative paper that is saturated and compressed under low pressure and heat for a short period of time (approximately 600 psi at three hundred-ninety two degrees Fahrenheit (392° F) for twenty (20) seconds) and is the material fused directly to a wood substrate and is often used on the vertical surface of various kitchen, bath and furniture applications. The term melamine is often used interchangeably with low pressure decorative laminate (LPDL), and thermally fused panels within the laminate industry.

### I. FACE MATERIAL PERFORMANCE:

<b>NEMA LD 3, LATEST EDITION</b>	<b>Standards</b>	<b>HPDL</b>	<b>LPDL</b>
3.8 Ball Impact Resistance Scope: This test measures the ability of high pressure decorative laminate to resist fractures due to impact by a polished stainless steel ball, weighing 224 ± 3 grams.	50" minimum	58-66" (exceptional impact performance)	15"
3.13 Wear Resistance Scope: This test measures the ability of the surface of high pressure decorative laminate to resist abrasive wear-through of the decorative layer.	400 cycles minimum	700-1,000 cycles, solids, patterns or woodgrains (exceptional wear performance)	400-500 cycles, solid colors; 125-150 cycles, patterns or woodgrains
<b>AWS, EDITION 1, SECTION 9</b>	Face Material	Recognized as quality standard	Not Recognized
<b>WDMA I.S. 1-A QUALITY STANDARDS</b>	Face Material	Must meet NEMA Standard LD 3, latest edition.	Must meet LMA, latest edition, Voluntary Product Standards and Typical Physical Properties of Decorative Overlays.

### II. VT DOOR CONSTRUCTION PERFORMANCE:

<b>WDMA I.S. 1-A QUALITY STANDARDS</b> TM-7 Cycle-slam	1,000,000 +
<b>CONSTRUCTION METHODS</b>	Edge-before-face eliminates delamination, locks edge in place
<b>COLOR OPTIONS</b> solids, woodgrains & patterns	Unlimited
<b>EDGE OPTIONS</b>	Matching HPDL, stained or painted, inquire if you need other options
<b>FIRE RATING</b>	Wide range of sizes & hardware machining
<b>WARRANTY</b>	Lifetime of installation