foil

impress
THE DECOR COMPANY

Technical data sheet

Status: Feb. 2016

INFORMATIONEN	
Decor name	
Decor / color number	
material number	
Gloss	
Surface class	
Load class	

CHARACTERISTICS

impress technical foil is a flexible, high-grade thermosetting surface finishing film for the furniture industry based on refined cellulose. The processing is done on flat and continuous presses and on laminating plants.

APPLICATION

Furniture, doors, interior decoration.

CARRIER MATERIALS

Chipboards, hardboards, honeycomb boards, gypsum plasterboards and MDF. Processing trials are essential when using plywood, coreboard, gypsum fibre board and other carrier materials.

FOIL QUALITY	
iFoil EC	Decor foils for midrange to heavy use (in accordance with DIN EN 68861-1c Furniture Standard and DIN EN 71-3 Toys Standard)
iFoil BC	Decor foils for midrange to heavy use (in accordance with DIN EN 68861-1c Furniture Standard and DIN EN 71-3 Toys Standard). With chemical pore (Authentic).
iFoil FC	Decor foils for midrange to heavy use (in accordance with DIN EN 68861-1c Furniture Standard and DIN EN 71-3 Toys Standard). With optical pore.
iFoil HQ	Decor foils for heaviest use in accordance with IOS-MAT-0066.
SURFACE CHARACTERISTICS	
itec	A method which has been tried and tested over the years. With itec we can create fine pores and details which you can actually feel when touching the surface. These details are also visible as soft mattings which follow the wood grain.
itec+	A new and complex technique to emphasise and carve out distinctive structures. The effects enable even rustic pores and cracks to become clearly tangible. The matt-gloss effects, as well as the power of the haptic effects, are autonomous. This way structures can be created and displayed in a very individual manner.
itec pearl	The perfect surface for velvety, soft surfaces and a natural feel of waxed wood. The shimmering shades of velvety-matt and fine silky gloss refine the decor and add a unique, authentic finish.
Authentic	Here the pores are deepened and suitable for decors with open pores and elegant wood with lacquer surfaces. Just like a smoothly sanded veneer with a fine lacquer finish, you can feel the pore only very faintly. However, the fine structure of the wood is clearly visible.
Smooth	Looks like a sealed surface. Smooth and flawless in several different glossy and matt degrees, this foil presents itself particularly well-proportioned for solid surfaces and precious wood.

FORM OF DELIVERY	
core diameter	76 / 150 mm

roll diameter	420 - 520 mm
roll length / roll width	- 1400 m to max. 2600 m depending on thickness of inner core diameter; - max. 2,20 m or cut fractions thereof

PROCESSING

The temperature of the starting materials should not be below approx. +20°C prior to processing.

The adhesive application rate is conditional on the substrate and on the way our films are processed.

.... on chipboards	40 - 70 g/m² PVAc or urea resin glue
.... on hardboards	40 - 60 g/m² PVAc or urea resin glue
FLAT AND CONTINUOUS PRESSES	
Adhesive	urea resin glue
Press power	5 - 10 kp/cm² (= 50 – 100 N/cm²)
Press temperature	120 - 170 °C
Press time	30 - 10 sec.
Adhesive	PVAc-film adhesive
Press power	5 – 10 kp/cm² (= 50 – 100 N/cm²)
Press temperature	80 – 120 °C
Press time	60 – 40 sec.
ROLL LAMINATION WITH SHORT CYCLE PRESSING	
Adhesive	urea resin glue (highly reactive system)
Press power	6 kp/cm² (= 60 N/cm²) and above
Presstemperatur	150 °C and above
Press time	10 - 20 sec. depending on type of glue
COLD ROLL LAMINATION	
Adhesive	PVAc-film adhesive
Feed rate	20 - 25 m/min
THERMAL LAMINATION	
Adhesive	urea resin glue (highly reactive system)
or	PVAc-film adhesive
Roll temperature	180 - 200 °C
Feed rate	25 - 35 m/min

- Take note where necessary of the processing guidelines of your machinery and adhesive supplier.
- All the above processing parameters are intended to serve as a guideline only. You must carry out trials in order to optimise the parameters for your individual application.
- It is generally not possible to recoat finish-lacquering surfaces. Special lacquers may be used for repairs and special cases. Individual tests are essential. Consultation will be provided by the impress application technology team.

SERVICE

Please contact the Impress Applications Engineering Department at any time to discuss problems. Please provide exact data about your machinery, carrier materials and adhesive systems.

All the above processing parameters are conform to our today's knowledge and intended to inform you about our products and their application. They do not assure a certain characteristic or a certain individual use. Existing commercial copyrights must be considered. We guarantee perfect quality in accordance with our general sales conditions.