

# OPAK

## Technical Information



### Product Description

#### Composition

Opak laminate is made of a high-tech thermosetting resin and decorative papers that give it design and high-performance surface properties. The core or support is composed of kraft paper with phenolic resin, which are subjected to a specific pressure of 90 Kg./cm<sup>2</sup> and a temperature of 135 ° C (275°C). Once pressed, OPAK laminate is cut into nominal dimensions and sanded on its back to provide greater adhesion when applied using adhesives on the wood substrate.

#### Recommended Applications

Opak laminate is specially formulated to provide a high performance surface: High scratch resistance, high durability, easy to clean, anti-fingerprint effect, has nice and soft feel to the touch, is hydropelling, resistant to wet and dry heat. Designed for applications in institutional projects, residential and commercial on vertical or horizontal surfaces, is recommended for kitchen countertops or high performance surfaces. Its ultramatte finish gives it anti-reflective properties.

#### Basic Limitations

OPAK laminate is a surface for indoor use, does not allow extreme humidity or temperatures above 135 ° C (275 ° C), it should not be exposed to continuous direct sunlight. To avoid deterioration in activities such as transport, handling in warehouse, transformation processes, installation, etc. the product comes with a protective film which should only be removed when its installation finishes. It is sold as decorative laminate and available in the following colors: Black 2160, White 2261 and Gray 2262. It is only manufactured in ultra matte finish and standard quality (No Post-formable). For additional information please contact our representatives [experts@lamitech.com.co](mailto:experts@lamitech.com.co)

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Product Identification							
TYPE OF LAMINATE	LAMITECH GRADE	NOMINAL THICKNESS	SIZES				FINISHES
		(Inches) mm	Feet (ft)				ULTRAMATE
			4 x 8	4 x 10	5 x 8	5 x 12	
			Meters (mt)				
Horizontal Standard Opak	70	1.20 (0.048)	X	X	NO	NO	
Horizontal Standard Opak	50	1.00 (0.039)	X	X	NO	NO	X
Vertical Standard Opak	30	0.70 (0.028)	X	X	NO	NO	X

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\*Xtreme Matte laminate can be ordered in any thickness of line from 0.7mm to 12mm

### Useful Information

1. The OPAK laminate must be conditioned and stored in a dry and ventilated place, never in the open. It must be horizontally stowed and stored as far as possible at room temperature below 30°C and relative humidity below 60%. To avoid deterioration in activities such as transport, handling in warehouse, transformation processes, installation, etc. the product is always marketed with protective film which should only be removed when the installation is complete.
2. In the selection of the adhesive to be used there are several alternatives, the most common is contact cement in solvent-neoprene, which is recommended for manual applications where the pressure exerted is low. When it comes to industrial applications we recommend PVA (polyvinyl acetate) adhesives, which are not heat reactive and have high resistance to moisture. For good adhesion of OPAK laminate, we recommend the use of 80 to 140 g/m<sup>2</sup> of PVA adhesive and to apply a pressure of 7 to 9 kg / cm<sup>2</sup>. At the end of the application, if there is adhesive residue on the laminate, wipe the surface with a soft cloth moistened with organic varsol solvent or a 50:50 mixture of alcohol-organic solvent.

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3. To avoid that the OPAK laminate surface is buckled or deformed, we suggest to apply - on the back side of the veneer - the balance laminate, in order to obtain the optimal balance in the moisture absorbed by the wood layer.
4. Cutting of the OPAK laminate should be done with disc saws of speeds between 8-12 m / min and 3,000 to 5,500 rpm. Saws with teeth of alternating trapezoidal flat geometry. For routing work you must use cylindrical cutters of 12,000 rpm, minimum. With routing the finishing in the edges is of better quality.
5. To drill the OPAK laminate, use drills of 10,000 rpm. With biangular carbide-tipped carbide drill. The selected drill bit should be 0.002 inches (0.05 mm) larger than the specified hole diameter to be made.
6. OPAK laminate is sold only in ultra matte finish. If you are going to cut or place very hot objects (temperature above 135°C) such as hot oil pans and plates, among others on surfaces covered with OPAK laminate, use a wood or ceramic base as a protective element.
7. For the routine maintenance of OPAK laminate, we recommend the use of water, mild non-abrasive soaps and nylon sponges. For slightly more difficult stains use chlorine bleach diluted in water. Avoid the use of strong bleaches, organic detergents and abrasive sponges, which can discolor and scratch the laminate. For greasy or heavily soiled stains, wipe the surface with a soft cloth or use a 50:50 blend of alcohol and organic solvent, so as not to affect its original tone and design.
8. OPAK High Pressure laminates provide a durable and easy maintenance surface. Resistance to staining is high, however we do not recommend its use on laboratory work surfaces where they use oxidizing chemicals, alkalis and strong acids in their daily work.

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Especificaciones técnicas					
NEMA LD.3 / EN-438 MÉTODO DE ANÁLISIS	PROPERTY	UNITS	LAMITECH S GRADO 70	NEMA CGS	LAMITECH F20 -F60
	NOMINAL THICKNESS	In (mm.)	0.248 (1.20)	0.248 (1.20)	-
	THICKNESS TOLERANCE	In (mm.)	+/- 0.005 (+/- 0.12)	+/- 0.005 (+/- 0.12)	-
3.1/4.0	APPEARANCE	Defects	No A,B,C Defects	No A,B,C Defects	-
3.3/27	LIGHT RESISTANCE	Effect /gray scale	5	EL	4-5
3.4/26	CLEANABILITY	Top Score	8	20	-
	STAIN RESISTANCE				
	REACTIVES 1-10	Effect	NE	NE	-
	REACTIVES 11-15	Effect	EL	M	-
	Group 1	grade	5	-	5
	Group 2	grade	5	-	5
	Group 3	grade	4	-	4
3.5	BOILING WATER RESISTANCE	Effect	NE	NE	-
3.6/16	HIGH TEMPERATURE RESISTANCE	Effect /grade	EL	EL	4
3.7/25	SCRATCH RESISTANCE	Newton	4	4	4
3.8/21	BALL IMPACT RESISTANCE	In. (mm) mín.	59 (1.500)	50 (1.250)	32 (800)
3.11/17	DIMENSIONAL CHANGE				
	LONGITUDINAL	% máx.	0.30	0.5	0.45
	TRANSVERSAL	% máx.	0.50	0.9	0.90
3.13/10	WEAR RESISTANCE	Cycles (mín.)	800	400	350
3.14/32	POST-FORMABILITY	In (mm.) Radio, mín.	NA	NA	NA
3.15/34	BLISTER RESISTANCE	Sec (mín)	NA	NA	NA

SL=Slight Effect=4, NE=No Effect=5, M=Moderate Effect=3, NA=Not Apply, S=Standard, F: Formability  
Surface Finish = 3 – 5 Units ULTRA MATE

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### Limited Warranty

Lamitech warrants its products to be free from defects in accordance with current standards, through quality control and production process, properly used to comply with the tolerances of the product specifications. This warranty extends to the original purchaser for a period of one (1) year from the date of dispatch by Lamitech. It does not include damages caused by accidents, abuses, misuse or adulteration.

Since Lamitech laminates have a wide range of applications and Lamitech can not supervise the manufacture of final products, Lamitech assumes no obligations or liabilities arising from the application, installation, repair, use or sale of any final product to any person or entity.

The content of this useful information corresponds to the general knowledge of high pressure laminates. Lamitech offers this information only as a suggestion for its application. As it is impossible to anticipate all possible variations for its final use, no warranty or liability can be assumed by Lamitech regarding the use of this information.