
**High-pressure decorative laminates
(HPL, HPDL) — Sheets based on
thermosetting resins (Usually called
Laminates) —**

Part 8:

**Classification and specifications for
alternative core laminates**

iTeh STANDARD PREVIEW
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*Stratifiés décoratifs haute pression (HPL, HPDL) — Plaques à base de
résines thermodurcissables (communément appelées stratifiés) —*

*Partie 8: Classification et spécifications des différents modes de base
laminés*



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ISO 4586-8:2015

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2. www.iso.org/directives

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For an explanation on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the WTO principles in the Technical Barriers to Trade (TBT), see the following URL: [Foreword - Supplementary information](#)

The committee responsible for this document is ISO/TC 61, *Plastics*, Subcommittee SC 11, *Products*.

This first edition of ISO 4586-8:2015 cancels and replaces (ISO 4586-1:2004), which has been technically revised. <https://standards.iteh.ai/catalog/standards/sist/d7d7873c-ac9b-48a4-a8eb-4d41f3c4f011/iso-4586-8-2015>

ISO 4586 consists of the following parts, under the general title *Plastics — High-Pressure Decorative Laminates (HPL, HPDL) — Sheets based on Thermosetting Resins (Usually called Laminates)*:

- *Part 1: Introduction and general Information*
- *Part 2: Determination of properties*
- *Part 3: Classification and specifications for laminates less than 2 mm thick intended for bonding to supporting substrates*
- *Part 4: Classification and specifications for compact laminates of thickness 2 mm and greater*
- *Part 5: Classification and specifications for flooring grade laminates less than 2 mm thick intended for bonding to supporting substrates*
- *Part 6: Classification and specifications for exterior-grade compact laminates of thickness 2 mm and greater*
- *Part 7: Classification and specifications for design laminates*
- *Part 8: Classification and specifications for alternative core laminates*

High-pressure decorative laminates (HPL, HPDL) — Sheets based on thermosetting resins (Usually called Laminates) —

Part 8: Classification and specifications for alternative core laminates

1 Scope

This part of ISO 4586 specifies performance requirements for high-pressure decorative laminates (HPL, HPDL) intended for interior use that have core compositions not covered by ISO 4586-1 through ISO 4586-7. The core composition types (coloured core and metal reinforced core) are defined in this part of ISO 4586.

High-pressure decorative laminates are characterized by their qualities, durability and functional performance. HPL sheets are available in a wide variety of colours, patterns and surface finishes; they are resistant to wear, scratching, impact, moisture, heat and staining; and possess good hygienic and anti-static properties, being easy to clean and maintain.

ISO 4586-2 specifies the methods of test relevant to this part of ISO 4586.

In an effort to harmonize ISO 4586 with other High-Pressure Decorative Laminate standards, multiple methods may be published that demonstrate similar properties. In these instances, the same test method title is given and is annotated as either “Method A” or “Method B”. This is the case in the following tests: Edge Squareness - 8/9, Dry Heat - 17/18, Dimensional Stability at Elevated Temperatures - 19/20, Dimensional Stability at Ambient Temperature - 21/22, Staining - 30/31, Lightfastness - 32/33, Cigarette Burns - 36/37, Formability - 38/39, and Blistering - 40/41. In these instances, either method may be utilized in testing. Compliance to both methods is not required. While these tests are similar they are by no means identical and results of one method do not necessarily correspond to the results of the accompanying test. In these situations, consult the documentation in specific sections of ISO 4586 for performance requirements. Each specific method has performance requirements particular to that method for individual grades of high-pressure decorative laminate.

2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 4586-2, *High-pressure decorative laminates (HPL, HPDL) — Sheets based on thermosetting resins (Usually called Laminates) — Part 2: Determination of properties*

ISO 178, *Plastics — Determination of flexural properties*

ISO 527-2, *Plastics — Determination of tensile properties — Part 2: Test conditions for moulding and extrusion plastics*

ISO 1183-1, *Plastics — methods for determining the density of non-cellular plastics — Part 1: Immersion method, liquid pycnometer method and titration method*

ISO 11664-2, *Colorimetry — Part 2: CIE standard illuminants*

3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

3.1

High-Pressure Decorative Laminate(s)

HPL

HPDL

sheet(s) consisting of layers of cellulosic fibrous material (normally paper) impregnated with thermosetting resins and bonded together by the high pressure process described below

Note 1 to entry: The back of the sheet(s) is made suitable for adhesive bonding to a substrate.

3.2

High-Pressure Process

simultaneous application of heat (temperature $\geq 120^{\circ}\text{C}$) and high specific pressure ($\geq 5\text{ MPa}$), to provide flowing and subsequent curing of the thermosetting resins to obtain a homogeneous non-porous material with increased density ($\geq 1,35\text{ g/cm}^3$), and with the required surface finish

Note 1 to entry: This is a general definition of high-pressure decorative laminate(s). More specific product definitions can be found in ISO 4586-3 to ISO 4586-8.

3.3

Alternative Core Laminate

High pressure decorative laminate(s), consisting of decorative surface layers and alternative core layers

Note 1 to entry: The decorative surface layer(s) impregnated with melamine resin may appear on one or both sides of the laminate.

Note 2 to entry: Due to the variability of available alternative core materials, no performance requirements are set forth in this standard as of this edition of the standard.

3.4

Colored Core Laminate

High pressure decorative alternative core laminate, the core material of which consists of cellulosic fibrous layers (normally paper), impregnated with thermosetting resins (typically aminoplastic thermosetting resins)

Note 1 to entry: To achieve a coloured core laminate, either the cellulosic fibres or the resins can be coloured. A translucent laminate can be achieved by using clear resins and bleached fibres.

Note 2 to entry: The surface and the core layers can have a similar colour producing a uniformly coloured laminate or be different colour to achieve a succession of coloured layers.

3.5

Metal Reinforced Core Laminate

High pressure decorative alternative core laminate, the core material of which consists of metal layer(s) or mesh(es) and cellulosic fibrous layers (normally paper) impregnated with phenolic or aminoplastic thermosetting resins

Note 1 to entry: The purpose of including metal layers is to improve the mechanical, fire, or permeability performance of the laminate. Additionally the metal layers can give aesthetic improvements to the edge.

4 Material types

High pressure decorative alternative core laminates are defined using a three letter classification system as shown in [Table 1](#).

Table 1 — Numerical classification

First letter		Second letter		Third letter	
B	(Coloured core laminate)	C	(Compact)	S	(Standard grade)
H	(Metal reinforced core laminate)	T	(Thin laminate, < 2 mm)	F	(Flame-retardant grade)

Type S - Standard grade high pressure decorative alternative core laminates.

Type F - High pressure decorative alternative core laminates with improved fire retardance; similar to type S but also complying special requirements of specified fire tests which may vary according to the application (e.g. construction, marine, transport) and the country of use (see 5.4.5).

In addition to the abbreviation “HPL” or “HPDL” and the number of this ISO standard, materials shall be specified by the alphabetical classification system.

NOTE E.g. Coloured core standard grade thin high-pressure decorative laminate is designated as HPL/ISO 4586-8 BTS or HPDL/ISO 4586-8 BTS.

5 Requirements

5.1 Compliance

High-pressure decorative design laminates classified in [Table 1](#) shall comply with all the appropriate requirements specified in [5.2](#), [5.3](#), and [5.4](#). This applies to both full-size sheets and cut-to-size panels.

5.2 Inspection requirements

5.2.1 General

Inspection shall be carried out in accordance with ISO 4586-2:2015, Clause 4, at a distance of 1,5 m.

5.2.2 Colour, pattern and surface finish

When inspected in daylight or D65 standard illuminant, as specified in ISO 11664-2, and under tungsten-filament lighting illuminant A as specified in ISO 11664-2, a slight difference between the corresponding colour reference sample held by the supplier and the specimen under test is acceptable.

As colour and surface finish are critical, it is recommended that the sheets are checked for colour and surface finish compatibility without protective film before fabrication or installation.

5.2.3 Surface finish

When inspected at different viewing angles, there shall be no significant difference between the corresponding surface finish reference sample held by the supplier and the specimen under test is acceptable.

As colour and surface finish are critical, it is recommended that the sheets are checked for colour and surface finish compatibility without protective film before fabrication or installation.

5.2.4 Reverse side

The reverse side of single-sided sheets shall be suitable for adhesive bonding (e.g. sanded). In the case of sanded backs, slight chatter marks shall be permitted.

5.2.5 Visual inspection

5.2.5.1 General

The following inspection requirements are intended as a general guide, indicating the minimum acceptable quality for laminates. Cut-to-size panels and certain applications involving full-size sheets

may call for special quality requirements which can be negotiated between the supplier and purchaser, in such cases the following requirements may be used as a basis for agreement. Only a small percentage of sheets in a batch (the level to be agreed upon between the supplier and the customer) shall contain defects of the minimum acceptable level.

In the case of a double faced laminate, it may be agreed between the purchaser and supplier that the visual quality standard applies to one decorative face only.

5.2.5.2 Surface quality

The following defects are permissible:

- Dirt, spots dents, and similar surface defects.

The admissible size of such defects is based on a maximum contamination area equivalent to 1,0 mm²/m² of laminate and is proportional to the sheet size under inspection.

The total admissible area of contamination may be concentrated in one spot or dispersed over an unlimited amount of smaller defects:

- Fibres, hairs, and scratches.

The admissible size of such defects is based on a maximum contamination area equivalent to 10 mm²/m² of laminate and is proportional to the sheet size under inspection.

The total admissible area of contamination may be concentrated in one spot or dispersed over an unlimited amount of smaller defects.

5.2.5.3 Edge quality

Visual defects (e.g. moisture marks, lack of gloss, corner damage) can be present on all four edges of the laminate, providing the defect-free length and width are at least the nominal size minus 20 mm.

For compact laminate grades, edge chipping up to 3 mm on each side is permissible.

5.3 Dimensional tolerance requirements

5.3.1 Dimensional tolerance requirements for coloured core laminates

Dimensional tolerance requirements for coloured core laminates are specified in [Tables 2](#) and [3](#).

Table 2 — Dimensional tolerance requirements for thin coloured core laminates

Property	Test method (ISO 4586-2 clause no.)	Requirement
Thickness	5	0,5 mm ≤ d ≤ 1,0 mm: ± 0,15 mm maximum deviation 1,0 mm < d ≤ 2,0 mm: ± 0,18 mm maximum deviation where d = nominal thickness
Length and width ^a	6	+10 mm/-0 mm
Straightness of edges ^a	7	1,5 mm/m maximum deviation
Squareness (Method A) ^a	8	1,5 mm/m maximum deviation
Squareness (Method B) ^a	9	< 6 mm
Flatness ^b	10	100 mm/m maximum deviation

^a Tolerances for cut-to-size panels shall be agreed between supplier and purchaser.

^b Provided that the laminates are stored in the manner and conditions recommended by the manufacturer they shall comply with the flatness requirements specified in [Table 2](#) when measured in accordance with ISO 4586-2:2015, Clause 10.

Table 3 — Dimensional tolerance requirements for compact coloured core laminates

Property	Test method (ISO 4586-2 clause no.)	Requirement
Thickness	5	$2,0 \text{ mm} \leq d < 3,0 \text{ mm}$: $\pm 0,25 \text{ mm}$ maximum deviation $3,0 \text{ mm} \leq d < 5,0 \text{ mm}$: $\pm 0,40 \text{ mm}$ maximum deviation $5,0 \text{ mm} \leq d < 8,0 \text{ mm}$: $\pm 0,50 \text{ mm}$ maximum deviation $8,0 \text{ mm} \leq d < 12,0 \text{ mm}$: $\pm 0,70 \text{ mm}$ maximum deviation $12,0 \text{ mm} \leq d < 16,0 \text{ mm}$: $\pm 0,80 \text{ mm}$ maximum deviation $16,0 \text{ mm} \leq d < 20,0 \text{ mm}$: $\pm 0,90 \text{ mm}$ maximum deviation $20,0 \text{ mm} \leq d < 25,0 \text{ mm}$: $\pm 1,00 \text{ mm}$ maximum deviation $25,0 \text{ mm} \leq d$: to be agreed upon between the supplier and customer where d = nominal thickness
Length and width ^a	6	+ 10 mm / - 0 mm
Straightness of edges ^a	7	1,5 mm / m maximum deviation
Squareness (Method A) ^a	8	1,5 mm / m maximum deviation
Squareness (Method B) ^a	9	< 6 mm
Flatness ^b	10	$2,0 \leq d < 6,0 \text{ mm}$: 12,0 mm / m maximum deviation $6,0 \leq d < 10,0 \text{ mm}$: 8,0 mm / m maximum deviation $10,0 \leq d$: 5,0 mm / m maximum deviation where d = nominal thickness
^a Tolerances for cut-to-size panels shall be agreed between supplier and purchaser.		
^b Provided that the laminates are stored in the manner and conditions recommended by the manufacturer they shall comply with the flatness requirements specified in Table 2 when measured in accordance with ISO 4586-2:2015, Clause 10.		

5.3.2 Dimensional tolerance requirements for metal reinforced core laminates

Dimensional tolerance requirements for metal reinforced core laminates are specified in [Table 4](#) and [Table 5](#).

Table 4 — Dimensional tolerance requirements for thin metal reinforced core laminates

Property	Test method (ISO 4586-2 clause no.)	Requirement
Thickness	5	$0,5 \text{ mm} \leq d < 2,0 \text{ mm}$: $\pm 0,18 \text{ mm}$ maximum deviation where d = nominal thickness
Length and width ^a	6	+10 mm/-0 mm
Straightness of edges ^a	7	1,5 mm/m maximum deviation
Squareness (Method A) ^a	8	1,5 mm/m maximum deviation
Squareness (Method B) ^a	9	< 6 mm
Flatness ^b	10	100 mm/m maximum deviation
^a Tolerances for cut-to-size panels shall be agreed between supplier and purchaser.		
^b Provided that the laminates are stored in the manner and conditions recommended by the manufacturer they shall comply with the flatness requirements specified in Table 2 when measured in accordance with ISO 4586-2, Clause 10.		

Table 5 — Dimensional tolerance requirements for compact metal reinforced core laminates

Property	Test method (ISO 4586-2 clause no.)	Requirement
Thickness	5	2,0 mm ≤ <i>d</i> < 3,0 mm: ± 0,25 mm maximum deviation 3,0 mm ≤ <i>d</i> < 5,0 mm: ± 0,40 mm maximum deviation 5,0 mm ≤ <i>d</i> < 8,0 mm: ± 0,50 mm maximum deviation 8,0 mm ≤ <i>d</i> < 12,0 mm: ± 0,70 mm maximum deviation 12,0 mm ≤ <i>d</i> < 16,0 mm: ± 0,80 mm maximum deviation 16,0 mm ≤ <i>d</i> < 20,0 mm: ± 0,90 mm maximum deviation 20,0 mm ≤ <i>d</i> < 25,0 mm: ± 1,00 mm maximum deviation 25,0 mm ≤ <i>d</i> : to be agreed upon between the supplier and customer where <i>d</i> = nominal thickness
Length and width ^a	6	+10 mm / -0 mm
Straightness of edges ^a	7	1,5 mm/m maximum deviation
Squareness (Method A) ^a	8	1,5 mm/m maximum deviation
Squareness (Method B) ^a	ISO 4586-8:2015	< 6 mm
Flatness ^b	10	2,0 mm ≤ <i>d</i> < 6,0 mm: 8,0 mm/m maximum deviation 6,0 mm ≤ <i>d</i> < 10,0 mm: 5,0 mm/m maximum deviation 10,0 mm ≤ <i>d</i> : 3,0 mm/m maximum deviation where <i>d</i> = nominal thickness
^a Tolerances for cut-to-size panels shall be agreed between supplier and purchaser. ^b Provided that the laminates are stored in the manner and conditions recommended by the manufacturer they shall comply with the flatness requirements specified in Table 2 when measured in accordance with ISO 4586-2:2015, Clause 10.		

5.4 Test requirements

5.4.1 General requirements for coloured core laminates

General requirements for coloured core laminates are specified in [Table 6](#)

Table 6 — General requirements for coloured core laminates

Property	Test method (ISO 4586-2 Clause no. Unless otherwise stated)	Property or attribute	Unit (max or min)	Laminate grade	
				BTS	BCS
Resistance to surface wear	11	Wear resistance	revolutions (min)		
			initial point wear value	150	150
Resistance to immersion in boiling water	13	Appearance	Rating (min)		
			gloss finish	3	3
		other finishes	4	4	
		Mass increase	% (max) ^a		
			2 mm ≤ d < 5 mm	-	5,0
		d ≥ 5 mm		3,0	
Thickness increase	% (max) ^a				
	2 mm ≤ d < 5 mm	-	6,0		
d ≥ 5 mm		4,0			
Resistance to water vapour	14	Appearance	Rating (min)		
			Gloss finish	3	3
Resistance to dry heat (Method A)	17	Appearance	Other finishes	4	4
			Rating (min)		
Resistance to dry heat (Method B)	18	Appearance	Gloss finish	3	3
			Other finishes	4	4

^a Where d = nominal thickness

^b L = in the longitudinal (or machine) direction of the fibrous sheet material (normally the direction of the longest dimension of the laminate).

^c T = in the cross-longitudinal (cross-machine) direction of the fibrous sheet material (at right angles to direction L).

^d Extraneous darkening and/or photochromism are due to the shock effect of accelerated exposure and are not characteristic of natural exposure.

^e Machine crosshead speed of 2 mm/min

^f Specimen type 1A. Machine crosshead speed 5 mm/min. Tested in accordance with procedure A using specimen III.