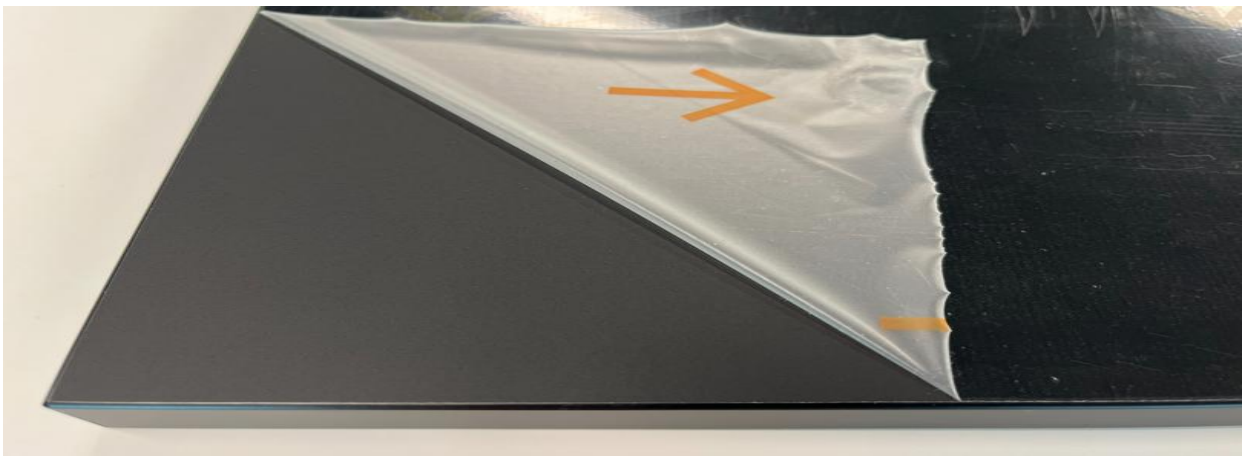
# PRODUCT INFORMATION
## XTreme- and HPL products with transport foil*



* Lacquered boards, HPL laminates, Compact laminates, HPL elements

## PROPERTIES AND APPLICATION OF TRANSPORT FOILS

### Properties

- Transport foils for Pfleiderer interior products are based on PE-, PP- or PET-plastics and have an adhesive layer based on acrylate or rubber. For surface inspection purposes, they are transparent or colour-transparent.
- Transport foils for Duropal XTerior compact (lacquered board) are not transparent, as UV protection of the adhesive layer is required.
- Depending on the surface structure, Pfleiderer products are supplied with transport foil as standard or on request. The application of foil to compact laminates is carried out in coordination with the production plant.
- Duropal products manufactured as rolled goods are generally supplied without transport foil.
- Minimum order quantities for transport foil application correspond to the minimum production quantities.

### Application

- Self-adhesive transport foils are intended for temporary protection of Pfleiderer products. This includes protection against damage such as scratches or abrasion, as well as contamination, moisture or chemicals during storage, transport, processing and installation.
- Any additional requirements for Pfleiderer products with transport foil, such as milling, drilling, edge lacquering and processing, or postforming, are the responsibility of the customer. The customer must ensure suitability through appropriate production tests.
- **Transport foils must in all cases be removed within 6 months after delivery by Pfleiderer!**
- Every Pfleiderer product is subject to incoming goods inspection, regardless of whether transport foil is applied.

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## TRANSPORT, STORAGE AND PROCESSING OF TRANSPORT FOILS

### Transport and storage

- Foil-coated Pfleiderer products must be stored in enclosed spaces protected from direct sunlight, heat and moisture. These influences alter the required properties of the transport foil and may increase adhesive strength or leave adhesive residues on the product surface. Ideal storage conditions are a cool, dry place at **temperatures of 18–25 °C and relative humidity of 50–65 %**.
- During transport, loading and unloading, or stacking of Pfleiderer products with transport foil, care must be taken to ensure that the foil is not cut or detached by sharp objects.
- Pfleiderer products with transport foil should ideally be transported lying flat on pallets. Compression during rolling of Duropal HPL for shipment in cartons or drums may lead to detachment of the foil from the HPL surface. In such cases, altered adhesive behaviour of the foil does not constitute a defect.
- Pfleiderer transport foils are designed for climatic conditions in Central Europe. During air freight transport, temperatures of up to -20 °C may occur in unheated cargo holds. Sea transport via containers can result in temperatures exceeding 60 °C in tropical or subtropical regions. Both transport methods may affect the adhesive strength of the transport foil. Volume deliveries must be approved by the customer through suitable trial shipments.

### HPL postforming

- Transport foils are temperature-resistant up **to a maximum of 80 °C**. HPL postforming is not possible with this foil.
- Duropal HPL with high gloss or enhanced high gloss surfaces can be supplied, upon customer request, with either a transport foil or a foil suitable for postforming. The temperature resistance is up to a **maximum of 180 °C**.
- Suitability of the postforming foil must be verified by the customer through testing.

### Processing

- Especially for large-format applications, it is recommended to ensure colour and structure uniformity of the panels and cut sizes used during further processing and installation, and to process the material taking the production direction into account.
- This can be achieved by observing the HPL production direction (sanding pattern on the HPL rear side) or the print pattern on the transport foil (e.g. directional arrows).
- Lifting by vacuum lifters is carried out at the user's own risk. No liability is accepted for damage caused by handling Pfleiderer products with transport foil.
- All requirements relating to the handling and processing of foil-coated Pfleiderer products must be tested by the customer through their own trials.

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**Disposal / Recycling**

- Transport foils can be disposed of via recyclable waste collection (e.g. yellow recycling bin). Commercial users should collect the foils as separated plastic waste and dispose of them via a certified waste disposal company or recycling centre, as the material is readily recyclable.
- Example waste code:
  - Germany: AVV 15 01 02
  - UK / Ireland: EWC 15 01 02
  - France: CED 15 01 02
  - Italy: CER 15 01 02
  - Spain: LER 15 01 02

## REMOVAL OF TRANSPORT FOILS

- Transport foils should be removed smoothly and evenly at room temperature, ideally at a 90° angle to the HPL surface. Overstretching the foil should be avoided. A small distance between the panel and the point of tension reduces foil stretching.

- If the foil adheres strongly (due to low temperature, direct sunlight, or storage), it can be carefully warmed with a hairdryer or hot air dryer. Heat softens the foil and adhesive layer, making foil removal significantly easier.
- Any remaining adhesive residue on the product surface should be removed with the cleaning agents listed below.
- To prevent panel warping, foil removal on compact laminates and HPL elements should ideally be performed simultaneously on both the front and back.
- “Easy-to-Peel” behaviour: Duropal HPL XTreme plus (XPSM) with transport foil type 42 has a special feature. A quick, jerky peel makes foil removal easier in this case. The foil adhesion appears to be lower.

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## REMOVAL OF ADHESIVE RESIDUES

The following cleaner recommendations are based on Pfleiderer's own HPL cleaning tests involving foil adhesive residues. The manufacturers' instructions for the cleaning agents must be observed and complied with in all cases.

- Koch-Chemie GmbH – Eulex Eu Klebstoff- & Fleckenentferner – www.koch-chemie.com
- Mellerud Chemie GmbH – Aufkleber & Klebereste Entferner – www.mellerud.de

In general, a basic cleaning must be carried out after treatment with special cleaners.

## DISCLAIMER

Failure to follow the specified processing, storage, and application instructions will void any liability for resulting damages. The user is responsible for independently verifying the suitability of the product for its intended use.





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