

RESOPAL® Traceless



1. Material description and composition

RESOPAL®-Traceless is a laminate panel with an anti-fingerprint, matt, low-reflection and soft-touch surface that is designed for use in interior design. Although RESOPAL®-Traceless meets the requirements based on DIN EN 438, Part 3, it is not a high-pressure laminate in the sense of DIN EN 438 on account of the surface material used (see Section 5 for technical specifications). RESOPAL®-Traceless is postformable within limits; it is therefore advisable to perform tests beforehand.

2. Application

Compared with panels of general, standard composition, HM (hard or carbide metal) tools must be used for machining the panels described here as a result of the surface material used. Diamond tools are recommended for machining major quantities.

The general recommendations provided by RESOPAL® for processing RESOPAL® HPL should also be followed in respect of storage, machining and processing.

A non-jagged edge will be achieved by using the specified or equivalent tools for cutting on woodworking machines. As the use of alternative tools may produce a white cut edge, we recommend a trial machining run first.

Jointing cutter:

The axial angles for machining RESOPAL® Traceless must be no less than 45°.
(Leuco ID No. 184633)

Axial angle: 70°

Tool: z = 3

Speed: n = 9000 rpm

Feed velocity: vf = 15 m/min

Feed rate per tooth: fz = 0.55 mm

Shank-type cutter:

(Leuco Dia -P-system D25mm ID no. 184382)

Axial angle = 70°

Tool: z = 2+2

Speed: n = 18000 rpm

Feed velocity: vf = 12 m/min

Feed rate per tooth: fz = 0.17 mm

Hogger:

(Leuco PowerTec III ID no.183450 + 183451)

Speed: n = 600 rpm

Feed rate: 30m/min

RESOPAL® Traceless



Drill:

Dowel drills and through-hole drills:
(Leuco Mosquito solid carbide drills)

Hole-saw:
(Leuco Light drill)

Speed: $n = 4500$ rpm
Feed velocity: $vf = 1.5$ m/min

RESOPAL®-Traceless is not recommended for heavily stressed horizontal surfaces (e.g. cash desks, tables in fast-food restaurants, etc.). It should also be noted, when cutting that RESOPAL® Traceless is with directional orientation.

3. Types

Surfaces:	Traceless (TL): matt, robust, resistant to dirt, finger-marks do not show
	Traceless smooth (TS): matt, finger-caressing silky feel, resistant to dirt, finger-marks do not show
TL sizes:	3650 mm x 1320 mm; 3050 mm x 1320 mm; 2350 x 1320 mm; 2180 x 1320 mm; 2180 x 1020 mm
TS sizes:	3650 mm x 1320 mm; 3050 mm x 1320 mm
Thickness:	0.8 – 2 mm;
Finishes:	Printed patterns and plain finishes Note: TL and TS surfaces in particular make dark finishes look as little lighter.
Protective film:	Both surface finishes can be supplied with a protective film for transport
Fire behaviour:	normal flammability B2 acc. to DIN 4102-1

4. Backing

When manufacturing composite elements with RESOPAL®-Traceless, particular attention must be given to compensating for tension by including opposite pulling force. For this reason, it is recommended to use identical RESOPAL®-Traceless material as backing. No liability can be accepted for any attempt to produce unsymmetrical composite elements. Before attempting to do so, it is recommended to try out the feasibility of such applications.

RESOPAL® Traceless



5 Technical specifications

Eigenschaften	Prüfverfahren	Einheit	HPL
Surface finish			TL/TS
Density	ISO 1183	g/cm ³	1,4
Abrasion resistance	DIN EN 438-2	Index	3-4
Impact resistance (depending on thickness)	DIN EN 438-2	Index	3
Scratch resistance (depending on texture)	DIN EN 438-2	Rating	3
Light fastness (xenon-arc lamp)	DIN EN 438-2	Grey scale rating (EN 20105-A02)	4-5
Resistance to dry heat (180°C)	DIN EN 438-2	Rating	3
Resistance to water vapour	DIN EN 438-2	Rating	4
Dimensional stability at elevated temperature lengthwise	DIN EN 438-2	%	0,45
crosswise		%	0,90
Resistance to cracking	DIN EN 438-2	Rating	≥4
Degree of gloss (Reflectometer value 60°)	DIN 67530		ca. 2-5

All the information given in this product data sheet is based on current scientific knowledge but cannot be warranted. Suitability for specific purposes or applications cannot be guaranteed.