

LAMINTEX WINDOWSILLS DATA SHEET 2021 ver4

LAMINTEX windowsills are composite elements consisting of raw chipboards, bonded seamlessly on surface and profile areas with CPL/HPL laminate. Different profiles, sizes, chipboard qualities, laminate thicknesses, surfaces and decors are available.

AREAS OF APPLICATION

Due to their modern design and functionality windowsills are used for interior applications at homes, offices, shops etc. Before installation, windowsills should be acclimatized 96 hours in the place where they will be installed.

STORAGE

Horizontal, even storage in closed, dry areas [approx. 20°C and 50% to 60% relative humidity] to exclude warping or dimensional changes due to climatic conditions. Vertical storage is not recommended. Windowsills should be handled and transported with due care.

Numerous factors, including changes in temperature and relative humidity, such as occurring at construction sites, storage rooms with various atmospheric conditions can cause irreversible twisting of boards and panels. Therefore, the following parameters responsible for the twisting of boards and panels are therefore only applicable at the time of delivery.

PROCESSING

Lamintex windowsills can be processed with conventional woodworking machines. For best quality/results of windowsills, use of cutting/saw device with milling cutter is needed.

QUALITY CHARACTERISTICS / TECHNICAL DATA

The quality characteristics of windowsills are dictated by the application of laminate conforming to the norm EN-438 and chipboard agreed with norm EN-312. For standard postformed windowsills, the laminate is classified as HGP (Horizontal-General purpose Postforming). That means it is suitable for horizontal applications with postforming requirements. The quality characteristics such as surface abrasion, impact resistance and scratch resistance, require a high performance which is classified as below.

For standard postformed windowsills, the chipboard is classified as P2 (furniture use). That means that it is suitable for applications with interior requirements. The raw chipboard type P5 is suitable for interior applications with higher humidity (bathrooms etc.) and for both load bearing and high moisture areas. It has an extremely low swell factor and moisture-resistant properties. The chipboard P2 Stop Fire (hardly flammable) is suitable for spaces with higher fireproof requirements. Chipboard types P5,P2 Stop Fire are made on special customer's request.

FSC CERTIFICATE

Windowsills with FSC Certificate are available on special customer's request.

FORMALDEHYDE

Lamintex windowsills are manufactured in accordance with the requirements that apply from January 1, 2020 and are recorded in the standard ChemVerbotsV DIN EN 16516 also EN 717-1 as a reference method in terms of reducing formaldehyde emissions.

LAMINATE CPL

Property	Test method	Property or attribute	Unit	Values
Thickness tolerance	EN 438-2.5	thickness (t)	mm	0,4 ±0,08 0,5 <=t<=0,8 ±0,10 where t: is nominal
Resistance to surface wear	EN 438-2.10	wear resistance	revs	IP >=150 A>=350
Resistance to impact stress with a small ball bearing	EN 438-2.20	Spring force	N	>=15
Resistance to dry heat (180 °C)	EN 438-2.16	appearance	rating	>=4
Resistance to scratching	EN 438-2.25	force	rating	>=3
Resistance to staining	EN 438-2.26	app.groups 1-2 appear.groups 3	rating	5 >=4
Resistance to steam	EN 438-2.14	appearance	rating	>=4
Density	ISO 1183	density	g/cm ³	600-720
Lightfastness (Xenon arc lamp)	EN 438-2.27	Contrast	Gray scale	4-5
Swelling behaviour	DIN EN 317	appearance	-	24h max. 1% 2h max. 4%
Bending strength	DIN EN 310	-	N/mm ²	>9,0
Internal bond	DIN EN 319	-	N/mm ²	>0,2
Surface soundness*	DIN EN 311	-	N/mm ²	>=1,0

*- values might be lower for full pearlescent decors and therefore these decors are not recommended for horizontal applications.

CHIPBOARD

P2 according to EN-312 standard

Property	Requirement	Unit	Test Method
Thickness tolerance	+/- 0,3	mm	EN 324-1
Length and width	±5	mm	EN 324-1
Tolerance on the mean density within a board	±10	%	EN 323
Internal bond	0,20 - 0,45	N/mm ²	EN 319
Bending strength	7 - 13	N/mm ²	EN 310
Modulus of elasticity in bending	1050 - 1950	N/mm ²	EN 310
Formaldehyde content	E1	mg/100g	EN 120
Formaldehyde release	E1	mg/m ³	EN 717-1
Adhesion	>0,8	N/mm ²	EN 311
Rectilinearity	maximum 1,5	mm/m	EN 324-2
Right angle	<=2	mm/m	EN 324

* The values are characterized by a moisture content in the material corresponding to a relative humidity of 65% and a temperature of 20°C

P3 according to EN-312 standard

Property	Requirement	Unit	Test Method
Thickness tolerance	+/- 0,3	mm	EN 324-1
Length and width	±5	mm	EN 324-1
Tolerance on the mean density within a board	±10	%	EN 323
Internal bond	0,25 - 0,50	N/mm ²	EN 319
Bending strength	7,5 - 15	N/mm ²	EN 310
Modulus of elasticity in bending	1350 - 2050	N/mm ²	EN 310
Formaldehyde content	E1	mg/100g	EN 120
Formaldehyde release	E1	mg/m ³	EN 717-1
Swelling in thickness, 24h	12 - 25	%	EN 317
Rectilinearity	maximum 1,5	mm/m	EN 324-2
Right angle	<=2	mm/m	EN 324

* The values for bending properties, internal bond and swelling in thickness are characterized by a moisture content in the material (before treatment in the case of swelling in thickness) and other parameters in the table corresponding to a relative humidity of 65% and a temperature of 20°C

P5 according to EN-312 standard

Property	Requirement	Unit	Test Method
Thickness tolerance	+/- 0,3	mm	EN 324-1
Length and width	±5	mm	EN 324-1
Tolerance on the mean density within a board	±10	%	EN 323
Internal bond	0,25 - 0,50	N/mm ²	EN 319
Bending strength	9 - 19	N/mm ²	EN 310
Modulus of elasticity in bending	1550 - 2550	N/mm ²	EN 310
Formaldehyde content	E1	mg/100g	EN 120
Formaldehyde release	E1	mg/m ³	EN 717-1
Swelling in thickness, 24h	9 - 16	%	EN 317
Rectilinearity	maximum 1,5	mm/m	EN 324-2
Right angle	<=2	mm/m	EN 324

* The values for bending properties, internal bond and swelling in thickness are characterized by a moisture content in the material (before treatment in the case of swelling in thickness) and other parameters in the table corresponding to a relative humidity of 65% and a temperature of 20°C

WINDOWSILLS

TECHNICAL DATA / TOLERANCES / DIMENSIONS

Substrate:	raw chipboard E1 according to EN-312
Substrate type:	P2, P3, P5 according to EN 312
Lamination:	laminate CPL according to EN 438
Laminate thicknesses:	CPL standard, thickness 0,4-0,5 mm;
Reverse side:	covered by moisture resistant paper as follow
	- White paper – weight 80 g/m ² for width 150-450 mm
	- Gray paper – weight 105 g/m ² for width 500-1200 mm
Nose:	for models 6060-P, 1010-P, 3030-P is made with chipboard - thickness 18, 19 or 25 mm;
Nose tolerance [mm]:	width/length/thickness+/- 1 mm
Standard lengths [mm]:	4100 and 3000 mm;
Other lengths [mm]	from 2400 – 4150 mm depending on decor/ profile/ thickness
Length tolerance [mm]	+10 mm, -50 mm
Standard widths [mm]	150, 200, 250, 300, 350, 400, 450, 500, 550, 600 mm one side postformed; 305, 405, 505, 605, 705, 805, 905 mm both side postformed
Other widths [mm]	from 150 – 1200 mm depending on decor/ profile/ thickness
Width tolerance:	< 300 mm ± 2 mm ≥ 300 mm for each additional 50 mm plus ± 0.5 mm
Standard thicknesses:	18, 19 mm [bolded to 30/38/40 mm with nose] or 18, 19, 22 and 28 mm without nose
Thickness tolerance:	± 0.50 mm
Angular accuracy:	2.0 mm for every 1,000 mm in length per side
Straightness of cut:	0.8 mm for every 1,000 mm in length per side
Radius tolerance:	± 0.50 mm (inner radius)
Surface bonding:	D3 according to DIN EN 204
Postforming bonding:	D2 or D3 according to DIN EN 204
Back long edge:	impregnated paper edge min. 205 g/m ² or melamine, CPL, HPL, ABS edges. Back cut as option (without paper edge)
Side short edges:	sanded or not sanded
Sealing:	models 5500, PUR hot adhesive melt (see details on pictures); models 6060-P, 1010-P – without sealing

STANDARD DIMENSIONS

Windowsills are available in standard lengths and widths, in dimensions specified by the customer or tailor-made, finished elements. Lamintex is able to cut and edge the windowsills to size required by customer.

Size range of blanks:

Width:	150-1200 mm
Length:	2400 mm to 4100 mm
Thickness:	16 mm to 38 mm (max. 55 mm with nose)

Size range of finished elements:

Width:	150 mm to 1200 mm
Length:	400 mm to 4100 mm
Thickness:	16 mm to 38 mm (max. 55 mm with nose)

Windowsills may be edged on short sides by paper, melamine, CPL, HPL, ABS edges (windowsills without nose).

Plastic caps molded to profile 6060-P available on request.

FLATNESS

Windowsills in a thickness spectrum of 16 mm to 28 mm	
Length or width of element, x mm	* Maximum concave/convex deviation viewed from face side.
	CPL bonded to one side
$x \leq 300$ mm	0,5 mm
$300 < x \leq 500$	0,8 mm
$500 < x \leq 600$	0,9 mm
$600 < x \leq 700$	1,1 mm
$700 < x \leq 800$	1,30 mm
$800 < x \leq 900$	1,60 mm
$900 < x \leq 1000$	2,0 mm
$1000 < x \leq 2000$	2,0 mm/metre

* Numerous factors, including changes in temperature and relative humidity such as are encountered on building sites, may cause boards and panels to bow and twist irreversibly. This requirement is therefore only applicable at the time of delivery.

DART DEFLECTION OF PARAMETRES – MODEL 6060-P, 1010-P applicable at the time of delivery

Windowsills on chipboard P2 – laminate 0,4 mm

Length	Width				
	150	200	300	400	600
3000	6 mm	5,5 mm	5 mm	4 mm	3 mm
4100	7,5 mm	7 mm	6,5 mm	5 mm	4 mm

Windowsills on chipboard P5 – laminate 0,4 mm

Length	Width				
	150	200	300	400	600
3000	6 mm	5,5 mm	5 mm	4 mm	3 mm
4100	7,5 mm	7 mm	6,5 mm	5 mm	4 mm

Windowsills on chipboard P5 – laminate 0,8 mm

Length	Width				
	150	200	300	400	600
3000	7 mm	6,5 mm	6 mm	5 mm	4,5 mm
4100	9 mm	8,5 mm	7,5 mm	6 mm	5,5 mm

DART DEFLECTION OF PARAMETRES – MODEL 5500 applicable at the time of delivery

Windowsills on chipboard P2 – laminate 0,4 mm

Length	Width					
	150	200	250	300	400	600
2800	4 mm	3,5 mm	3,25 mm	3,0 mm	2,5 mm	2 mm
4100	5,5 mm	5,0 mm	4,75 mm	4,5 mm	3,5 mm	2,75 mm

Windowsills on chipboard P5 – laminate 0,4 mm

	Width					
Length	150	200	250	300	400	600
4100	5,5 mm	5,0 mm	4,75 mm	4,5 mm	3,5 mm	2,75 mm

*dart/arrow deflection in mm/pcs/length (measured from the postforming edge side).

ADDITIONAL NOTES

Leaking of the glue on a reverse side of windowsills (connection between nose and chipboard) are not production defect. Sporadic glue soils on the surface are not production defect. Small corrugations, irregularities on the profile's surface or radius surface are not production defect. The damages, scratches, defects on both windowsill's endings in length no more than 50 mm are not production defect. The dirties, grimes on the bottom and profiled surfaces of windowsills are not production defect. The damages, scratches, dirties, spots on the reverse side surface of windowsills are not production defect. The dirties, spots and similar defects on the upper surface with an area less than 2 mm² on the area of 1 lm of products are not production defect. Fibres, hair and scratches up to 10 mm long on the surface on the area of 1 m² of products are not production defect. The quality control always must be done under natural daylight.

Lamintex responsibility for product does not cover defects or damages caused by normal wear and tear as well as brakes/cracks/etc. that could be the result of improper use, faulty installation or assembly, improper storage, neglect, accident modification of the product, etc. Also does not involve mechanical damages, damages resulting from inappropriate installation or improper use of this product. Lamintex is not responsible for defects that arose immediately before installation.

CARE AND CLEANING RECOMMENDATIONS

Due to their resistant and hygienic, dense surfaces Lamintex windowsills do not require any special maintenance.

Surfaces are generally easy to clean. Probable dirties emerging from production process can be removed by rubbing a surface with a cloth and acetone. This also applies to textured surfaces.

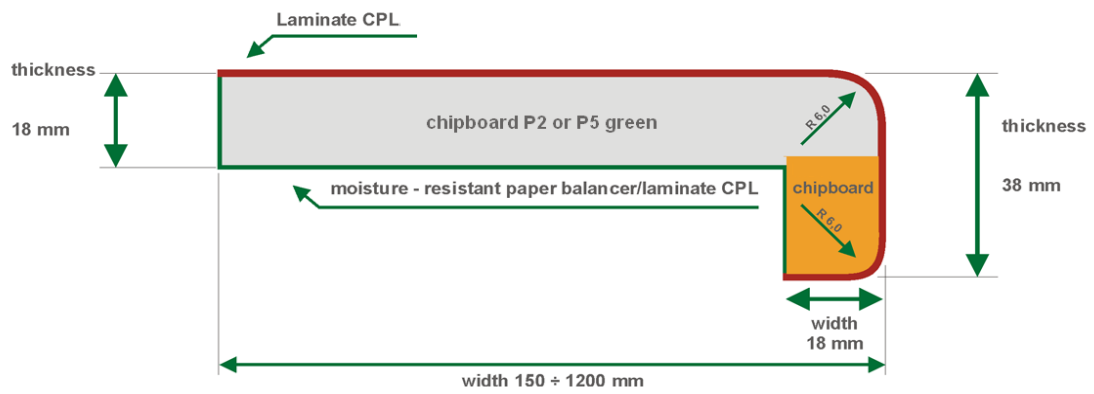
The details given in this data sheet are based on practical experience and in-door tests and reflect our current state of knowledge. They are for information only and do not constitute a guarantee with regard to product properties or suitability for individual application.

PACKING

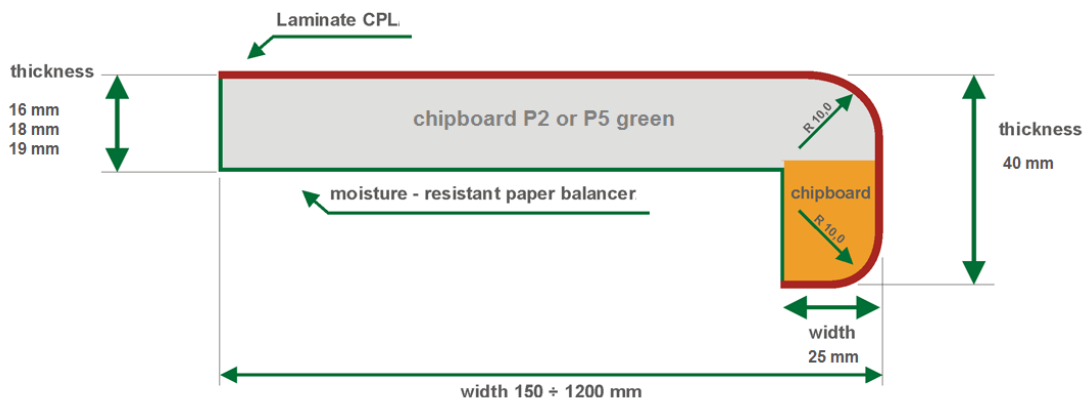
Company shall, at its expense, pack all Products in accordance with Company's standard packing system. However, if BUYER requests a modification of that packing system, SELLER shall make the requested modification and BUYER shall bear any reasonable expenses. Shrink foil packing of a single piece or two pieces is possible, additional edge strips, labels, EAN codes (with surcharges).

STANDARD PROFILE MODEL OPTION

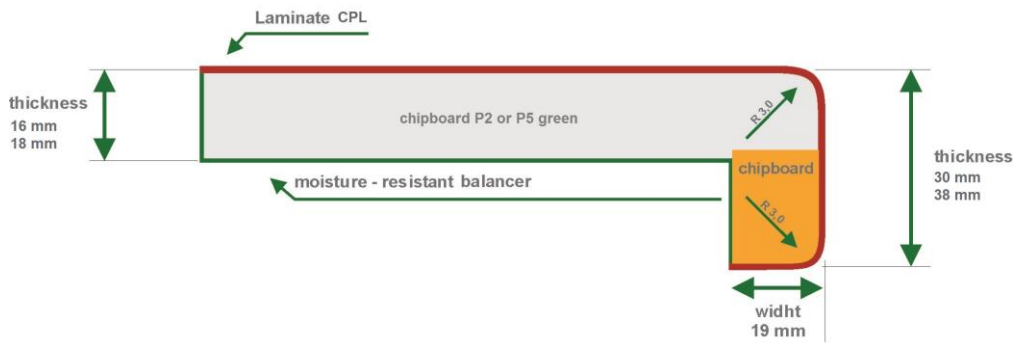
Profile 6060-P



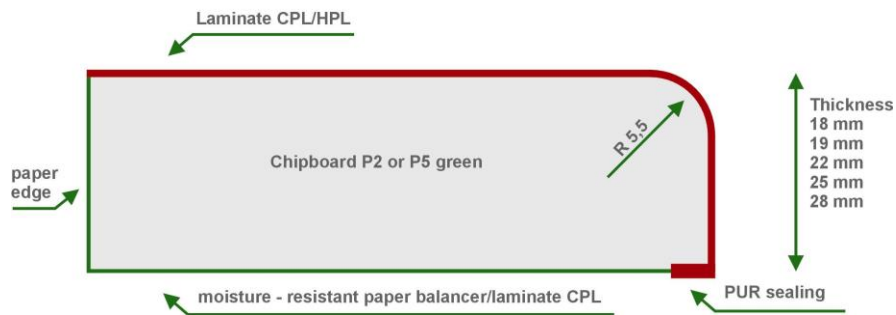
Profile 1010-P



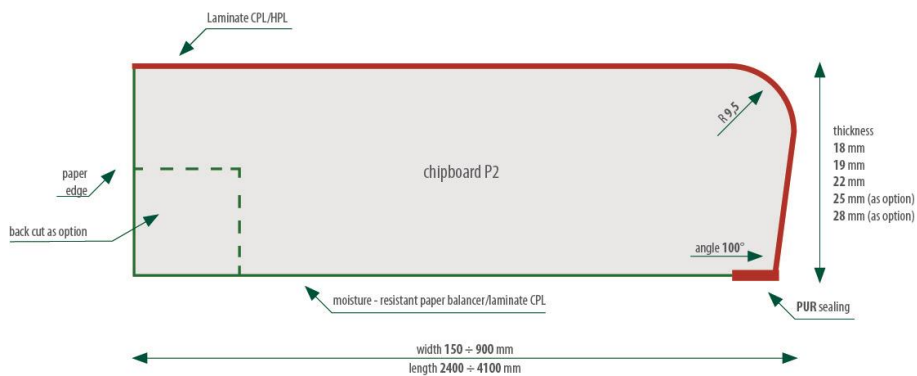
Profile 3030-P



Profile 5500



Model 9510



OTHER PROFILE MODELS POSSIBLE ON SPECIAL REQUEST.