

MORE FROM WOOD.

Quality Management ISO 9001



Coding: PI CL EN
Revision: 02
Approved: 08.01.2018
Page: 1 of 22

Processing instructions

EGGER Compact Laminates



1 Storage

EGGER compact laminate must be stored in enclosed, dry areas at approximately 18 °C to 25 °C and a relative humidity of approximately 50 % to 65 %. Once the original packaging is removed, the compact laminate must be stored on full-surface, horizontal, straight, stable protective boards.

Direct floor contact and / or exposure to sunlight must be avoided at all times. A laminated protective board (no raw chipboard) of at least the same format must be used to cover the top board.

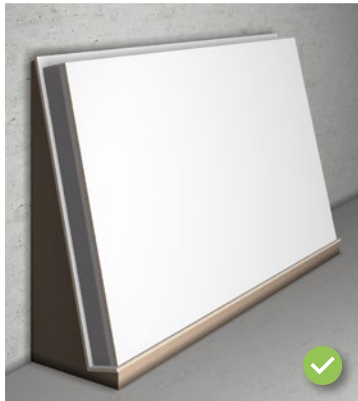


Figure 1

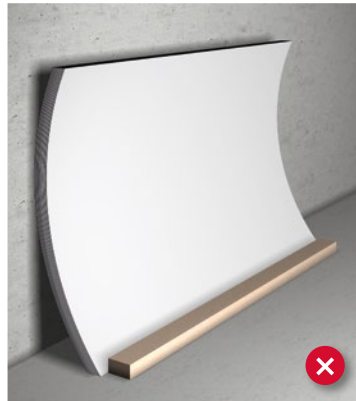
Responsible: PM Furniture and interior design



If horizontal storage is not possible, the compact laminate must be stored at an angle of approximately 80° against a full-surface support with counter-support. Using a laminated protective board of at least the same format is required for upright storage as well.



Right
Figure 2



Wrong
Figure 3

1.1 Handling

After removing the packaging and prior to processing, the compact laminates should be inspected for visible damage. In view of the relatively heavy weight, special care is required when transporting and handling compact laminates. As a rule, all persons transporting and / or handling compact laminates should wear personal safety equipment such as gloves, safety footwear and suitable work wear. The boards must be lifted. The decor sides should never be pushed against one another or dragged over one another (see Figure 4).

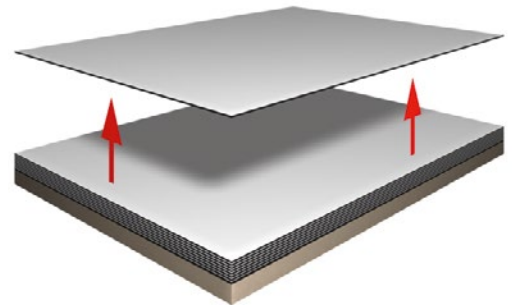


Figure 4

1.2 Conditioning

Compact laminate reacts to changes in ambient conditions with dimensional movement. For this reason, storage and processing conditions for the elements should correspond as closely as possible to the climate at the subsequent place of use. Prior to installation, compact laminate elements should be conditioned for an adequate period of time at the installation location under the conditions of subsequent use. Compliance with the storage recommendations is required on construction sites as well.

2 Fabrication

Due to the high density and resulting cutting forces, the processing of compact laminate, compared to other wood-based materials, leads to higher tool wear. Sharp blades should be used to ensure optimal shredding and to avoid odour generation. Hard metal tools are mainly used. Diamond-tipped tools are recommended for processing large quantities and automated processing centres. Ensure that the tool blades are maintained in good condition in order to obtain satisfactory results. To ensure economical fabrication, especially prior to processing a large production batch or implementing challenging projects, it is advisable to consult manufacturers on the most appropriate tool selection.

2.1 Extraction

Compliance with all safety standards and regulations, applicable to the wood processing industry in terms of dust extraction, fire prevention etc., is essential when processing compact laminates. Breathing protection has to be worn if no adequate extraction system is in place. Fabricating compact laminate is not a critical issue, but there are a small number of people who can experience an allergic reaction to all types of dust.

2.2 Sägen

Panel or circular bench saws are recommended for cutting compact laminates to size. In order to obtain a good cutting result, the relationship between number of teeth (Z), cutting speed (vc), and the feed rate (vf) should be taken into account.

Please pay attention to:

- visible side (decor side) on top
- correct saw blade projection
- adjust the number of revolutions and number of teeth to the feed speed
- The use of a scoring circular blade is recommended to obtain clean cuts on the bottom of the board

Depending on saw blade projection, the entry and exit angle change, and thus also the quality of the cut edge. If the upper cut edge becomes unclean, the saw blade must be set higher. The saw blade must be set lower in case of an unclean cut on the bottom. The best height setting must be identified.

In the case of format and panel saws, the following saw blade projections (X) must be set depending on diameter (D):

Circular blade diameter D [mm]	Projections X [mm]
250	approx. 5 – 10
300	
350	
400	
450	

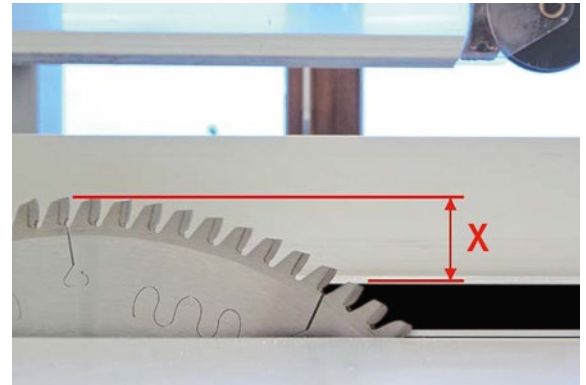


Figure 5 Source: Leitz

Saw blades with a high number of teeth are generally recommended for good processing quality. In the case of circular blades, the recommended cutting speed v_c is 60 – 90 m/s.

Recommended saw tooth shapes

In order to process compact laminates on both sides, a scoring saw is also needed in order to avoid splintering on the bottom. Please observe our tool recommendations for the professional fabrication of EGGER Compact Laminate at www.egger.com



TR/TR
(Trapezoidal tooth/
Trapezoidal tooth)

Figure 6 Source: Leitz



FZ/TR
(Flat tooth/
Trapezoidal tooth)

Figure 7 Source: Leitz

2.3 Milling

Diamond-tipped tools are recommended for machining compact laminate. The suitability of carbide-tipped tools is limited. Tools with segmented blades should not be used as far as possible, as the overcut in the overlap zone usually remains visible. To ensure a good edge quality, adding a processing allowance when cutting blanks is recommended, which, however, depends on subsequent edge processing.

Because of the high cutting pressure, secure work piece and tool control is of particular importance. Numerous edge profiling options are available. Remaining signs of milling can be removed by sanding. An even edge colour can be achieved by applying a silicone-free oil. Sharp corners and edges should be rounded to eliminate the risk of injury.

2.4 Drilling

Drill bits designed for plastic sheet materials are the best choice for drilling compact laminates. The point angle should be between 60° and 80°. The cutting speed and feed rate depend on the material of the chosen drill bit – HSS, HM, DIA. Please observe the specifications of the tool manufacturer. Spiral drill bits for drilling metal or wood can also be used, however, the rotational speed and feed rate must be reduced.



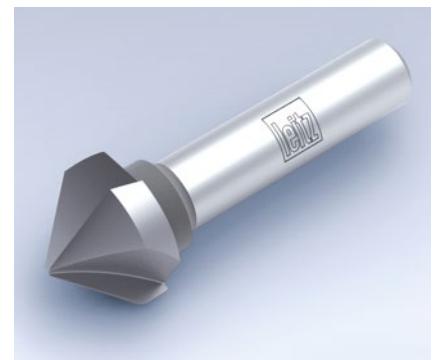
Dowel drill

Figure 8
 Source: Leitz



Spiral drill – HW

Figure 9
 Source: Leitz



One-piece counterbore

Figure 10
 Source: Leitz

For through holes, the compact laminate should be resting on a solid base which can be drilled into. Before the drill bit breaks through, the feed rate should be reduced in order to avoid break-outs on the exit side. For drill holes that do not go through, so-called blind holes, the minimum board thickness that must remain is 1.5 mm. For drill holes parallel to the board surface, the minimum board thickness that must remain on either side of the drill hole is 3 mm (see Figure 11).

Cutting, milling and drilling tools should always be selected in coordination with the tool manufacturer.



Figure 11

3 Fabrication

Despite the good dimensional stability of compact laminate, changes in the ambient conditions can result in dimensional movement. The orientation of the fibrous core layer gives the compact laminate a production or machine direction (see Figure 12).

Format changes are approximately half as large in the lengthwise direction as in the crosswise direction. Format changes have to be taken into account from the outset in design and processing. As a rule, an expansion play of 2.0 mm / m should be provided. Different ambient conditions in front and to the rear of the compact laminate elements can lead to warping. It is therefore essential that compact laminate wall panelling installations always make provision for adequate ventilation to the rear of the panels, which allows temperature and humidity to equalise.

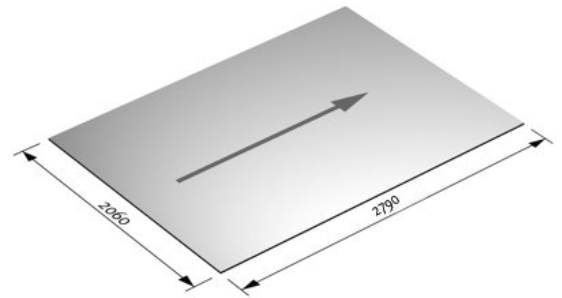


Figure 12

With compact laminate that has decor on both sides, the production direction is only discernible based on the production dimensions. It cannot be identified on compact laminate that has been cut to size. Wood and directional printed decors constitute an exception. When working with cut-size panels, it is important to ensure that the production direction is always matched up during installation. In view of the risk of confusion with cut-size panels, the machine direction should be marked on board remnants.

3.1 Cut-outs

Cut-outs and apertures, for example for switches, ventilator grills or access openings, always have to be rounded, since sharp corners can lead to the formation of cracks (see adjacent figures).

Inside corners should be cut with an inner radius of at least 5 mm. All edges must be smooth, free of cracks and notches. Grooves and rebates also have to be rounded in order to avoid notch cracks. Cut-outs can be made directly with a router or pre-drilled with an appropriate radius and then sawn out from drill hole to drill hole. Sufficient expansion gaps must be allowed for integrated components.

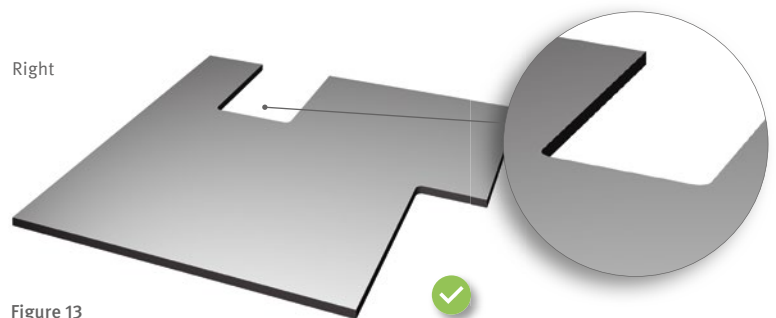


Figure 13

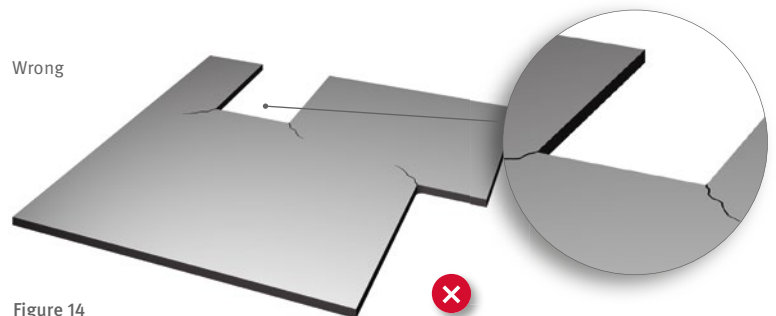


Figure 14

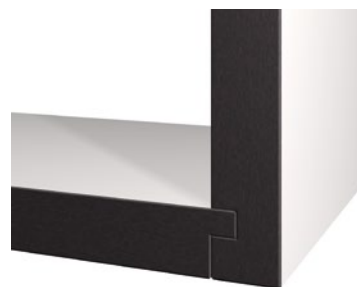


3.2 Worktop connection profiles

Joints between compact laminate elements, capable of withstanding higher stresses, can be achieved with a combination of gluing and fixing devices, splines or biscuits (e.g. made of compact laminate), or grooves. Note that compact laminate elements may only be joined to each other in the same production direction. Figures 15 to 20 below illustrate some possibilities for creating sturdy compact laminate joints.



Grooved
Figure 15



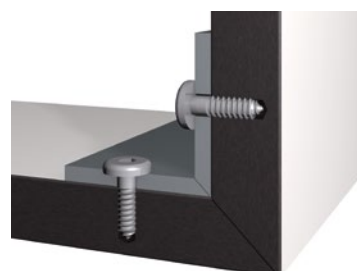
Grooved / rebated
Figure 16



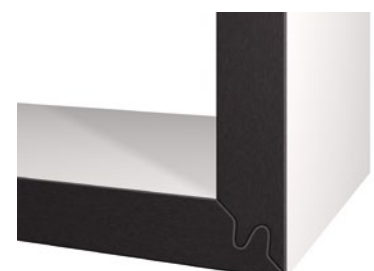
Tongue and groove
Figure 17



Angle spring
Figure 18



Metal profile, screw-fixed
Figure 19



Profiled connections
Figure 20

3.3 Bonding

When bonding together two compact laminates, it is important to ensure that dimensional movements are not obstructed. To avoid stress, only adequately conditioned compact laminates should be bonded together and always only in the same machine direction. Surface gluing of large dimensions is only possible in exceptional cases. Joints that are subject to major stress, for example due to vibrations, impacts or similar, should be reinforced with mechanical connecting elements. Prior to gluing, the boards have to be sanded, free of dust, grease and dirt, and pre-treated as necessary. Own attempts are recommended. Please observe the processing guidelines of the glue manufacturer.

Suitable types of glue for gluing EGGER compact laminate include:

Glue type	Glue type	Glue type
Jowat® 2K SE-Polymer 690.00	MBE Panel-loc	Ottocoll P85, Ottocoll M500
Jowat AG info@jowat.at www.jowat.at	Moderne Befestigungs Elemente GmbH info@mbe-gmbh.de www.mbe-gmbh.de	Hermann Otto GmbH info@otto-chemie.de www.otto-chemie.de

Compact laminate can not only be bonded to compact laminate, but also to solid wood or wood-based materials such as chipboard, MDF or multiplex board. In order to invisibly glue compact laminate onto the substructure, we recommend e.g., Panel-loc from MBE.

Visually thicker boards can be produced by doubling or upstands.

3.3.1 Doubling

With doubling corresponding compact laminate strips are glued along the edge. Once again, the same machine direction has to be observed. The tension-equalising single-component 1K Ottocoll M500 adhesive by Otto Chemie is, for example, a suitable product.



Figure 21

3.3.2 Upstand

For thicknesses up to 100 mm or if the decor has to be visible on the edge for aesthetic reasons, a downturn or upstand (Figure 22) is a possible solution. First, the two components to be connected together are mitred at 45 degrees. Then the work piece is placed on a level surface, face side down, so that the tips of the mitres are touching. Adhesive tape is then applied to this butt joint.

Finally, both work pieces have to be turned over carefully. Then the glue is applied (Figure 23) and then the shorter work piece or upstand is flipped up (Figure 24). Until the glue has set, the upstand has to be secured in the correct position with adhesive tape. Ottocoll P 85 is an example of a possible glue.



Figure 22

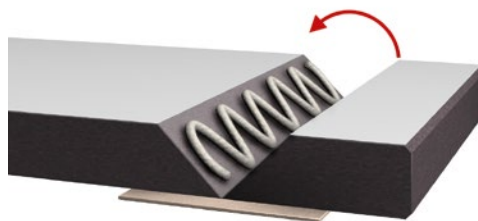


Figure 23



Figure 24

3.4 Screwing

Cutting screw threads in compact laminate is straightforward. Self-tapping screws can also be used without a problem. Screws with a slow thread are recommended as they achieve a better pull-out resistance. Pre-drilling is essential in all cases. Metal and chipboard screws are suitable for screw connections parallel to the board surface. Screws must penetrate to a minimum depth of 25 mm and the diameter of the drill hole must be selected appropriately to prevent splitting.

Surface screw connections with trough holes must have sufficient clearance to compensate for the dimensional movement resulting from temperature and humidity fluctuations. The diameter of the drill hole should be 2 – 3 mm larger than the diameter of the fixing device. In this way, tension due to the dilation and shrinking movement during changing weather can be avoided. The use of countersunk head screws should be avoided (see Figure 26). If countersunk head screws must be used, this is only possible with screw rosettes. Floating points and a fixed point are implemented on the individual elements for this purpose.

The basic execution of fixed and floating points is equally suitable for vertical and horizontal variants independent of the use.

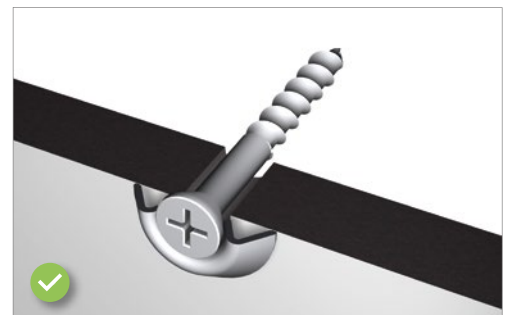


Figure 25

Right



Figure 26

Wrong

3.4.1 Fixed point

The fixed point serves to evenly distribute the expansion movement and should be positioned as centrally as possible. The bore hole diameter is equal to the diameter of the fastener.

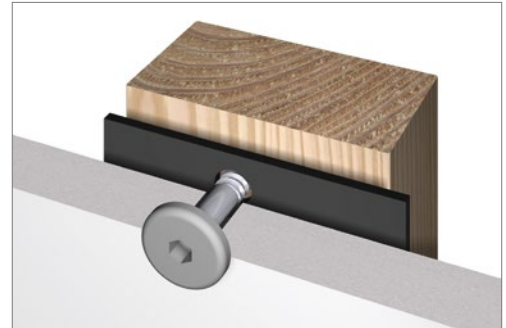


Figure 27

3.4.2 Floating points

The bore hole diameter of the floating points should be 2 – 3 mm larger than the fastener. The bore hole should be covered by the head of the screw. Washers should be used when necessary. In the figures, an EPDM sealing band has been applied to the wooden substructure for protection against moisture.

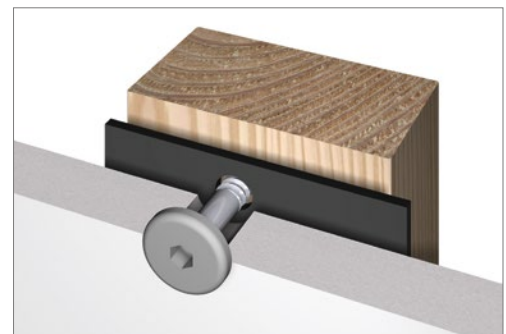
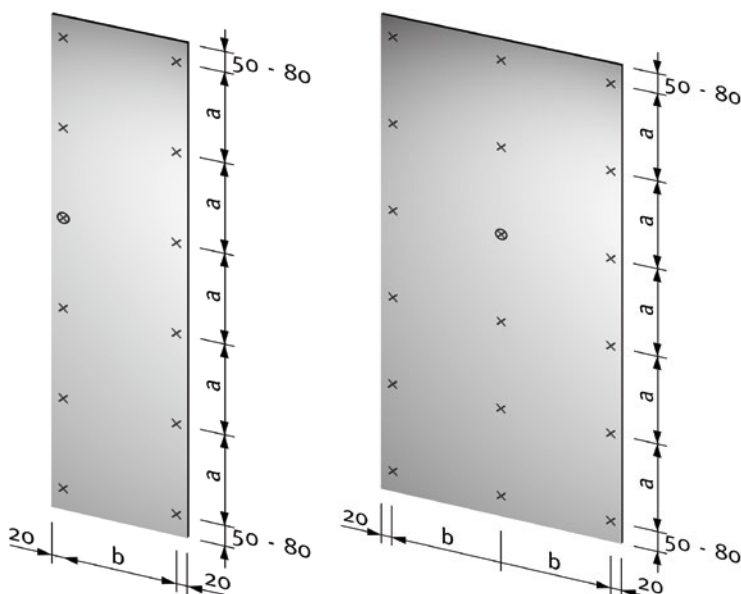


Figure 28

The required expansion play is established based on the largest distance of the fixed point to the board edge. The floating point drill hole diameter must be increased by 2 mm for every metre of length. For interior applications, the fixing distances listed in the table can be used:

Plattendicke [mm]	Maximaler Befestigungsabstand	
	a [mm]	b [mm]
8	790	500
10	920	670
12	960	900
13	970	920



⊗ = fixed point, x = floating point

Figure 29



4 Applications

4.1 Wall cladding

Thanks to its robustness and suitability for everyday use, EGGER compact laminate is particularly well suited to interior wall panelling applications. We recommend a minimum board thickness of 8 mm for such applications. The walls and substructure should be completely dry prior to commencement of the panel installation. Always make provision for adequate air circulation behind the panels. The material should not be exposed to trapped moisture. All panels to be joined together must follow the same production direction.

4.1.1 Substructure and ventilation

Compact laminate should be fixed to a sturdy, corrosion-resistant and interlocking substructure which securely supports the weight of the wall panelling and ensures that ventilation behind the panels is provided. In dry construction applications, the attachment of the substructure and the compact laminate must be anchored to the stud framing.

The selection of the fasteners has to be tailored to the substructure and the weight of the wall panelling. Different ambient conditions in front of and behind the elements can lead to warping. It is therefore essential that compact laminate wall panelling installations always make provision for adequate ventilation to the rear of the panels, which allows temperature and humidity to equalise. The installation should be vented into the room.

Vertical studs generally permit air circulation. Where substructures are arranged horizontally, an appropriate construction must ensure that adequate ventilation is provided. The substructure should be vertically plumb to allow stress free mounting of the entire panel surface. Suitable substructures include vertical strips of wood, aluminium or compact laminate.

The maximum spacing of the battens and / or substructure depends on the chosen compact laminate thickness. It is important to ensure that air inlet and outlet areas remain unobstructed so that air circulation is not impeded. Also ensure that the moisture of the surface to be panelled does not differ significantly from the moisture of the finished wall panel.

The following are differentiated:

- visible mechanical fixation
- invisible mechanical fixation
- invisible glued fixation

4.1.2 Visible mechanical fixation

Fixation is done via screws or rivets on the substructure. A sufficient dilation gap and the right positioning of floating and fixed points must be taken into account. An EPDM tape must be used for decoupling when using wood as substructure.



Figure 30

- 1 Luftspalt
- 2 EPDM Band

4.1.3 Invisible mechanical fixation

The invisible fixation of compact laminates by suspension permits straightforward disassembly and is aesthetically more appealing than visible fixation methods. Removing the boards is quick and simple. Cables and pipework installed behind the elements are easy to reach. Depending on the chosen mounting system, another advantage is that the elements can be adjusted later on. Stress-relieved mounting of the elements is also possible. For all mounting methods that involve hanging, sufficient space must be allowed to raise and lower the elements. This clearance or “suspension gap” will remain visible as a shadow gap.

Hanging by means of sectional strips

For this mounting method, a groove is cut into the horizontal substructure to hold the rebate rail attached to the wall element. For ease of fitting, the tongue of the rebated rail should be thinner than the groove. The rebated rails on the compact laminate elements should not extend across the full width of the elements, they should be intermittent in order to permit vertical air circulation. Rebate rails made of plywood or metal Z-profiles can be readily used. If a secure screw connection cannot be achieved with thin compact laminate elements, additional gluing is also possible.

Hanging by means of metal hardware

Systems with metal hardware are also offered for mounting wall elements (see Figure 31). The chosen system must be used according to the recommendations of the manufacturer in order to ensure secure installation.



Figure 31

4.1.4 Invisible glued fixation

Compact laminate can also be mounted by gluing the panels to a rigid substructure, using permanently elastic adhesive systems specially developed for this purpose. When using wood as a substructure, it is necessary to apply a primer as a preliminary step in order to ensure secure adhesion and moisture decoupling.

gluing. The mounting tape is intended for the first fixation. The permanent fixation is done with the glue. Setting the defined distance is another function of the mounting tape. This ensures the required glue thickness is achieved in order to be able to elastically absorb any movements of the board. Observe the processing instructions of the glue manufacturer.

The systems consist of the glue, an installation band and the corresponding products for priming the surfaces prior to

Suppliers of suitable glue systems include:

Austria	Austria	Austria
Innotec Österreich info@innotec.at www.innotec.at	DKS Technik GmbH office@dks.at www.dks.at	Pro Part Handels GmbH info@propart.at www.propart.at
France	United Kingdom	Germany
Sika France SA / Le Bourget www.fra.sika.com	Sika Limited / Watchmead www.gbr.sika.com	Moderne Befestigungs Elemente GmbH info@mbe-gmbh.de www.mbe-gmbh.de

4.1.5 Detailed designs

Irrespective of the selected substructure and the mounting system, the following detailed designs are usual in practice and provide the continued and unproblematic mounting of wall cladding.

Stack and joint formation

Numerous options are available to create horizontal and vertical joints or seams (see Figure 32 – 34). However, it is important to ensure that the elements have sufficient clearance for expansion.

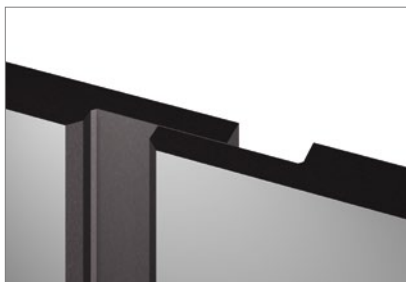


Figure 32

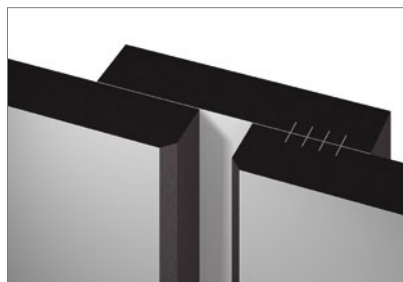


Figure 33



Figure 34

Upper closure

The upper closure of the wall cladding must be at a distance from the ceiling in order to ensure functional ventilation and is used for internal ventilation. The distance between the ceiling and the compact laminate also provides the necessary expansion gap. In order to ensure the full functionality of the ventilation, the distance to the ceiling must correspond at least to the size of the ventilation gap.



- 1 Air gap
- 2 Mounting tape
- 3 Glue

Figure 35

Bottom closure

The bottom closure of wall cladding with compact laminate can be achieved in two ways.

Closure at a distance from the floor generally functions in the same way as the closure of the compact laminate. The distance between the compact laminate and the floor provides sufficient air circulation behind the compact laminate and prevents moisture from stalling behind the wall cladding. But a minimum distance of 50 mm to the floor must be observed. Installed bases should be as thin as possible, so that a sufficiently large ventilation cross-section remains available.



- 1 Air gap
- 2 Tile base
- 3 Silicone joint
- 4 Minimum distance to floor 50 mm

Figure 36

A flushfloor installation, used primarily for compact laminate in shower areas, requires the compact laminate to not be directly on the floor, as the board will expand and shrink. A so-called compression tape maintains the necessary distance during installation, ensuring the later expansion gap of the board.

The split between the compact laminate and floor can subsequently be sealed with a silicone joint in order to prevent moisture from entering. In order to achieve air circulation in the case of a bottom closure, the ventilation split must be larger.

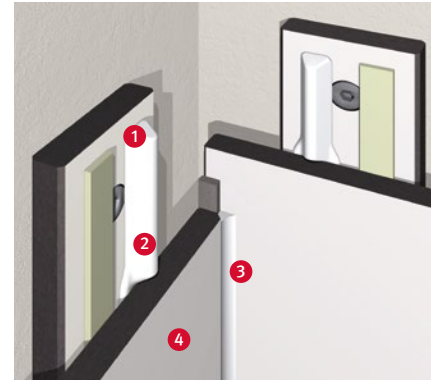


- 1 Compression tape
(sealing tape)
- 2 Silicone joint

Figure 37

Corner solution

In the case of corner solutions with compact laminate, a distance between the compact laminate and the wall equal to at least the thickness of the substructure must also be in place. The corner connection between the two compact laminates must be sufficiently large so that size changes due to climate modifications can be balanced out. If the corner connection needs to be sealed, for example when used in shower spaces, this is again done with the help of compression tape, in order to provide the expansion gap. The split between the individual compact laminates is protected from incoming moisture with an additional sealing silicon joint (Figure 38).



1 Compact laminate strip Figure 38
 2 Compression tape (sealing tape)
 3 Silicone joint
 4 Compact laminate

Surface stack

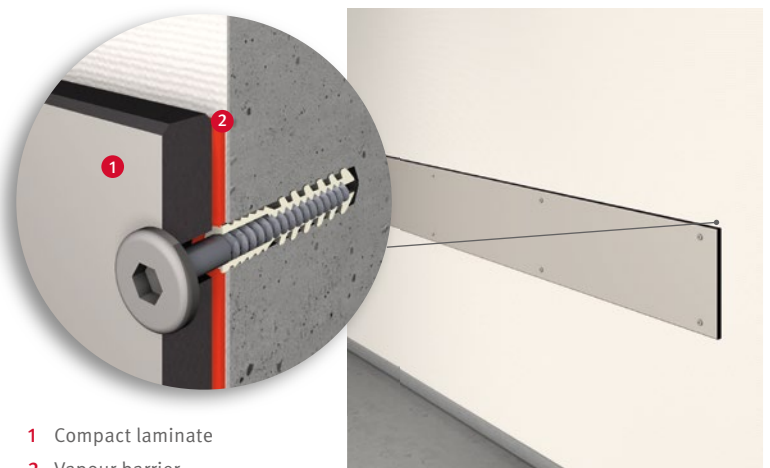
A usual crash protection solution in hospitals involves the use of compact laminate as half-height wall cladding. A seamless transition from the compact laminate to the drywall is necessary to this end. In order to guarantee a functional ventilation of the compact laminate, a stainless steel angle bracket can be used as optical closure (Figure 39).



1 Wallpapered gypsum fibreboard Figure 39
 2 Stainless steel bracket
 3 Compact laminate

Direct installation

For partial wall cladding, compact laminate panels are usually fixed directly to the wall by means of visible screw connections. As there is no ventilation to the rear of the elements, a vapour barrier must be installed between the compact laminate and the wall. A maximum height of the compact laminate of 300 mm is recommended.



1 Compact laminate
 2 Vapour barrier

Figure 40

4.2 Sanitary and shower partitions

When compact laminate is used in sanitary facilities, it is important to ensure during design and installation that the compact laminate is not subject to standing water and that there is sufficient ventilation of the room. It is imperative to use only corrosion-free construction materials and fixing devices. Application in areas with high humidity requires the mechanical reinforcement of corner connections, for example using dowels or clips, and the use of an adhesive system that is waterproof after setting. For commercial applications subjected to increased wear and tear, a minimum distance of 120 mm must be maintained between the floor and lower edge of the board.



Providing adequate ventilation in the rooms and ensuring that the compact laminate can dry after the shower stall is used is important.

Absorbent mineral sub-layers such as walls and / or plaster have to be primed with a waterproof, elastic barrier. This barrier is generally brushed on and prevents water from penetrating the substructure. The German Construction Confederation offers a leaflet for such sealing and barrier products (“Waterproofing barriers for installations with tiles and boards”). This leaflet describes sealing compounds processed in the liquid state with tiles and boards for interior and exterior applications, taking into account defined moisture exposure classes and sub-layers. The moisture exposure classes of the materials have to be coordinated with the manufacturers or suppliers. Compliance with the processing instructions of the relevant manufacturers is mandatory.

4.3 Furniture doors

Doors should not be wider than they are high. Since format changes are only half as large in the lengthwise direction compared to the crosswise direction, cutting door leaves in the lengthwise direction of the compact laminate is recommended. Excessive differences in temperature or relative humidity between the front and reverse sides of the door can cause the compact laminate to warp. This is why sufficient air circulation must be ensured, for example when installing toilet cubicles or changing rooms. The door width, height and weight are deciding factors for the number of hinges required. Other factors, such as the installation location or whether additional stress is to be expected from the attachment of coats hooks, for example, can vary greatly from case to case and must be taken into account.

The information provided (see Figure 42) should therefore be regarded as a guideline only for a door in 13 mm thickness and a width of up to 600 mm. Performing a trial mounting is recommended. For heavy duty applications, an additional hinge can be fitted at max. 100 mm below the upper hinge. The upper and lower hinges should be located at a minimum distance of 100 mm max., measured from the outer edge of the panel. Suitable hinges are offered by the companies HAEFELE or Prämeta, for example (see Figure 43).

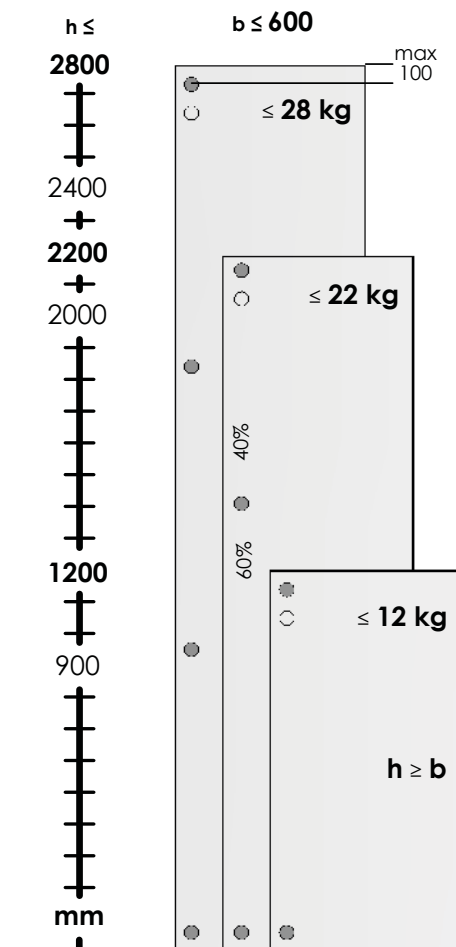


Figure 42
 Source: Prämeta



Figure 43
 Source: Prämeta

4.4 Table tops

Compact laminate is very well-suited for table top applications, for example in offices, conference rooms, schools, and workshops. The board thickness, mounting distances and projection over the base frame have to be laid out depending on the expected loads.

Tabletops must have a minimum thickness of 10 mm so that sufficient material is available for secure screw connections. Fastening to the substructure can occur in several ways. It is important to guarantee a tension-free assembly. Screws can be driven directly into the board or a screw-in sleeve may be used. The fixing points in the substructure must be implemented with sufficient clearance for expansion. The diameter of the drill hole should be 2 – 3 mm larger than the diameter of the fixing device.



Figure 44

Board thickness [mm]	Overhang [mm]	Mounting distance [mm]
10	170	310
12	240	390
13	270	440

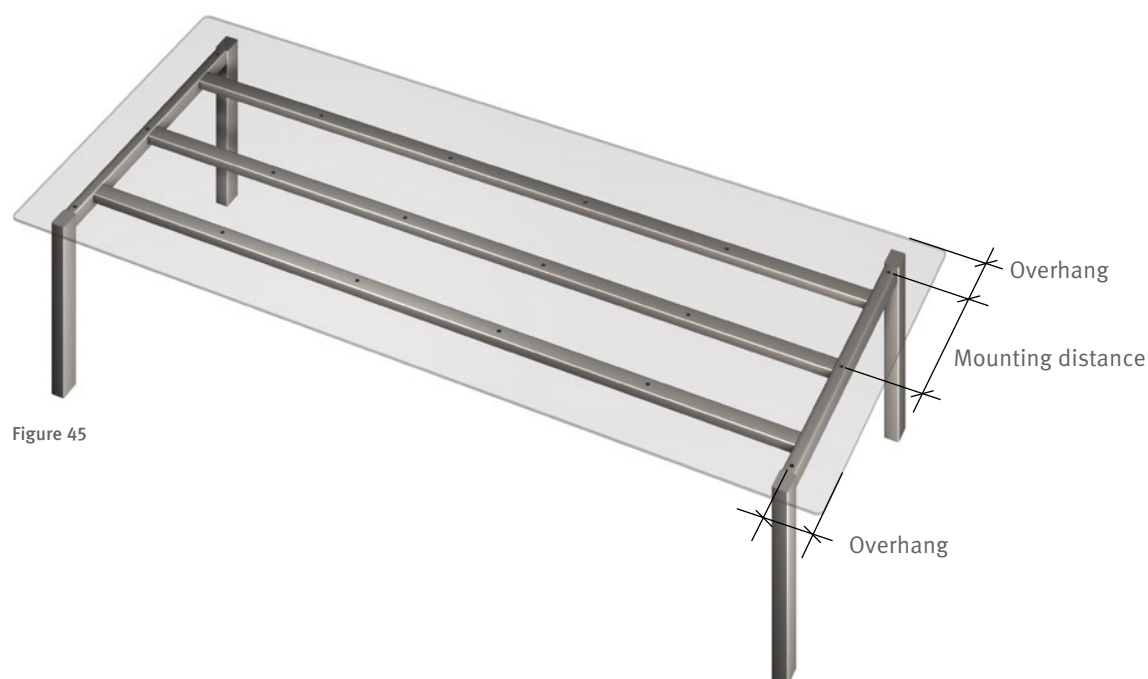


Figure 45

4.5 Sink and ceramic stove top installation

Compact laminates are also very often used as work surfaces in kitchens as well as in toilet areas for wash basins. In these fields of application, the installation of ceramic stove tops, as well as kitchen or bathroom sinks is necessary and the solutions that follow are generally used.

Installation of ceramic stove top



Figure 46

Installation of sink top

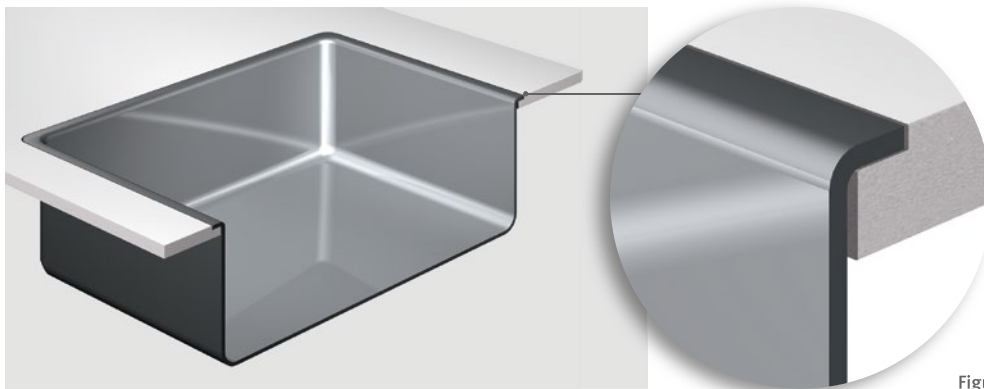


Figure 47

Installation of sink bottom

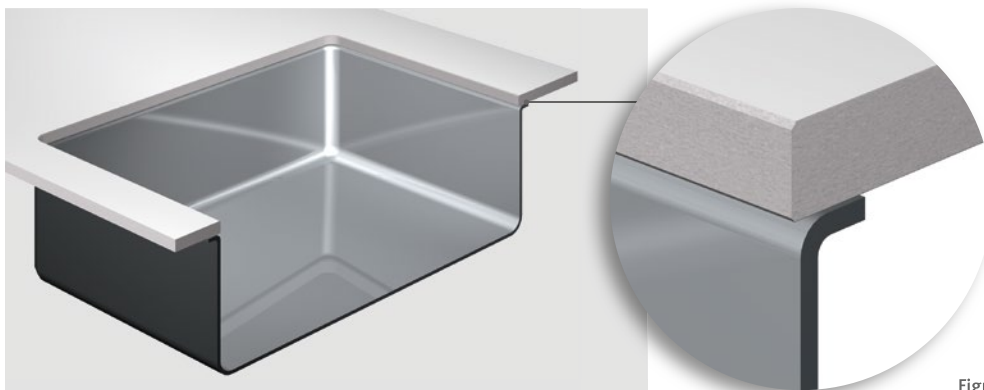


Figure 48

4.6 Worktops

Compact laminates are very often used as worktops in kitchens of wash basins thanks to their moisture resistance and robustness. To connect to the corpus, the boards can be either screwed in (instructions under 3.4) or glued (instructions under 3.3). Irrespective of the fixation type selected, it is necessary to provide an expansion gap of 2 mm / m.

In order to properly ventilate the compact laminate, it is necessary to design the upper part of the corpus as a traverse.



Figure 49

The corner connections of two worktops are achieved with connection discs, such as lamella. To this end, the board edges should generally also be slightly milled in the stack area of the two board elements.

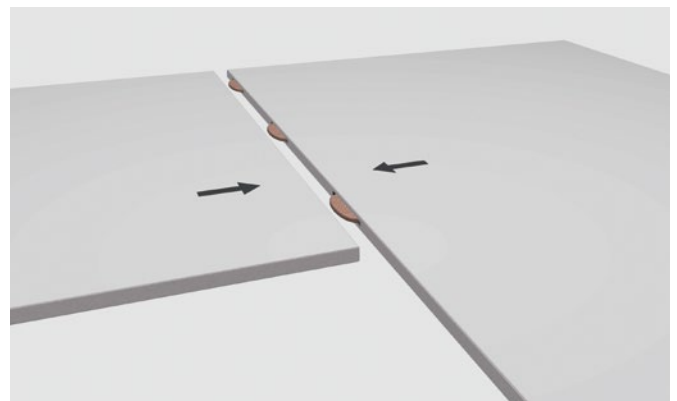


Figure 50

5 Cleaning and use instructions

Due to the resistant, hygienic and dense surface, EGGER Compact Laminate does not require any special form of care. As a general rule, stains and spilled substances such as tea, coffee and wine etc. should be cleaned up immediately, as the cleaning effort increases if they are left to dry. When cleaning is necessary, mild agents should be used. Cleaning agents must in particular not contain any abrasive components, as they may adversely affect the gloss level or scratch the surface.

The following information should be observed for daily use:

- Placing burning cigarettes on the surface of compact laminate causes surface damage. **Always use an ashtray.**
- Compact laminate surfaces should not be used as a cutting surface, as this can also leave cutting marks on highly resistant compact laminate surfaces. **Always use a cutting board.**
- Placing hot cooking utensils such as saucepans and frying pans directly from the hob or oven onto the compact laminate surface should be avoided, as, depending on the heat exposure, a change in the gloss appearance or damage to the surface can arise. **Always use heat protection.**
- **Spilled liquids should always be wiped or cleaned up immediately** since extended exposure to certain substances can change the gloss level of compact laminate surfaces. Especially in the areas around cut-outs and joints, spilled liquids should always be cleaned up quickly and thoroughly.
- These recommendations apply especially to matt compact laminate surfaces. These have a distinctive look and feel, but have a greater tendency to show wear and tear. More detailed information can be found in our **“EGGER Compact Laminate cleaning and maintenance instructions”** leaflet at www.egger.com/compactlaminate.

6 Disposal

Due to their very high calorific value, compact laminates are very suitable for thermal disposal in appropriate combustion plants. Specific national laws and ordinances on disposal in general have to be observed.

These processing instructions were prepared based on the best available information and with due diligence. The information provided is based on practical experience, in-house testing and reflects our current level of knowledge. It is intended for information only and does not constitute a guarantee in terms of product properties or its suitability for specific applications. We accept no liability for any mistakes, errors in standards, or printing errors. Furthermore, the continuous further development of EGGER Compact Laminate products as well as the amendment of standards and public documents may result in technical changes. Therefore, the content of these processing instructions cannot serve as instructions for use nor as a legally binding agreement. Our General Terms and Conditions apply.