

Pressing of SRM Decors

Important information on the pressing of Homapal SRM Decors

It is absolutely essential to make sure you **keep everything completely clean when glueing** Homapal SRM metal laminates onto the support panels. When SRM laminates are glued, white marks can appear. These are caused by indentations in the lacquer, caused by chips or dirt particles that lie or adhere to the HPL surface and are pressed into the hard lacquer surface. It appear small lacquer cracks and these become discolored, the transparent paint turns white in these areas and slowly breaks up further.

You can avoid this by cleaning up the surface and removing all chips and dirt particles from the surface, leaving the protective film on the HPL and **pressing the HPL surface with a soft intermediate layer (foam mat, silicone mat or MDF board).**

These marks occur especially when the laminate is cut to size before glueing, leaving lacquer residues on the protective film. These often adhere relatively strongly to the film due to electrostatic charging. These paint residues/chips and other contaminants are then pressed into the paint during pressing and cause the white marks appear.

Alternative:

If you work very cleanly, you can remove the protective film immediately before pressing so that the surface of the SRM HPL is perfectly clean. Then press the laminate in the clean press. **In this case it is also recommended to use a soft intermediate layer (foam mat, silicone mat or MDF board).**

Please do not press in blocks because the pressure exerted on the bottom elements is then higher than the maximum permitted pressure.

The pressing temperature should not be above 60°C and the pressing force should not be higher than 0.1 N/mm² or 1 bar.