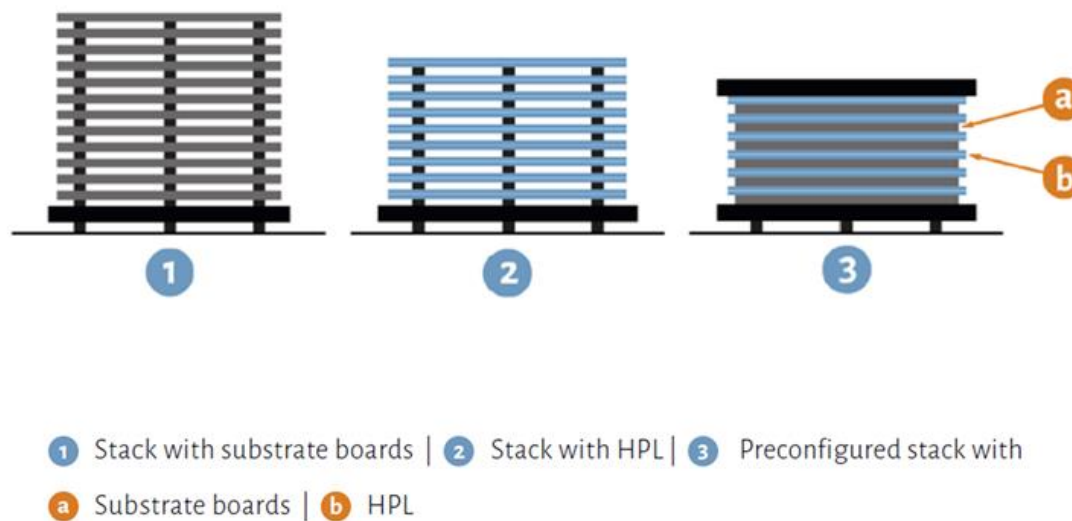


In accordance with the criteria determined by the International Decorative Laminate Industry Committee (ICDLI); In order to protect the products against humidity and direct sunlight, it is necessary to store them in a normal room climate, that is, at a temperature of about 18-25 °C and a relative humidity of 50-60%.

HPL and substrates must be conditioned together before being processed to achieve a similar moisture content for both materials. Materials that are processed while moist tend to shrink over time, which can cause cracking and warping. Materials that are too dry are more difficult to machine and can expand later, causing warping. The climatic conditions during subsequent use should always be taken into account when planning and designing composite elements (HPL and substrates). Adequate air circulation around each layer for at least ten days (see figure below) is recommended. Additionally, HPL and substrates should be stacked in the order in which they will then be bonded for at least three days. The relative humidity should be similar to that of the future application.



If the composite element (HPL and substrates) to be fabricated will be constantly exposed to low relative humidity during future use, it is recommended that the HPL and substrate be exposed to the corresponding humidity during conditioning to estimate the shrinkage stress that occurs subsequently.