

**norm****NEN-EN 438-7**

Decoratief hoge-druk laminaat (HPL) -  
Platen gebaseerd op thermohardende  
harsen (gewoonlijk Laminaat genoemd) -  
Deel 7: Compact laminaat en  
samengestelde panelen van HPL voor  
wand- en plafondafwerking binnen en  
buiten

High-pressure decorative laminates (HPL) - Sheets based on thermosetting resins (Usually called Laminates) - Part 7: Compact laminate and HPL composite panels for internal and external wall and ceiling finishes

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Voorbeeld  
Preview

EUROPEAN STANDARD  
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**DRAFT**  
**prEN 438-7**

August 2019

ICS 83.140.20

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English Version

## High-pressure decorative laminates (HPL) - Sheets based on thermosetting resins (Usually called Laminates) - Part 7: Compact laminate and HPL composite panels for internal and external wall and ceiling finishes

Stratifiés décoratifs haute pression (HPL) - Plaques à base de résines thermodurcissables (communément appelées stratifiés) - Partie 7 - Panneaux stratifiés compacts et composites HPL pour finitions des murs et plafonds intérieurs et/ou extérieurs

Dekorative Hochdruck-Schichtpressstoffplatten (HPL) - Platten auf Basis härtpbarer Harze (Schichtpressstoffe) - Teil 7: Kompaktplatten und HPL-Mehrschicht-Verbundplatten für Wand- und Deckenbekleidungen für Innen- und Außenanwendung

This draft European Standard is submitted to CEN members for enquiry. It has been drawn up by the Technical Committee CEN/TC 249.

If this draft becomes a European Standard, CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration.

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Preview  
 prEN 438-7:2019

## European forward

This document (prEN 438-7:2019) has been prepared by Technical Committee CEN/TC 249 "Plastics" the secretariat of which is held by NBN.

This document is currently submitted to the CEN Enquiry.

This document will supersede EN 438-7:2005.

This document has been prepared under standardization request given to CEN by the European Commission and the European Free Trade Association.

For relationship with Regulation EU 305/2011 (CPR), see informative Annex ZA, which is an integral part of this document.

Forbiede  
Preview

## Introduction

An overview of European standards addressing compact laminate panels and HPL composite panels and related products for building applications is given below.

<b>Test methods</b>	<b>EN 438-2:2016+A1:2018</b> , High-pressure decorative laminates (HPL) — Sheets based on thermosetting resins (usually called laminates) — Part 2: Determination of properties
	<b>EN ISO 13894-1:2015</b> , High-pressure decorative laminates — Composite elements — Part 1: Test methods (ISO 13894-1)
	<b>EN 16094:2012</b> , Laminate floor coverings — Test method for the determination of micro-scratch resistance
<b>Product standards</b> <b>Classification, specifications</b>	<b>EN 438-3:2016</b> , High-pressure decorative laminates (HPL) — Sheets based on thermosetting resins (usually called laminates) — Part 3: Classification and specifications for laminates less than 2 mm thick intended for bonding to supporting substrates
	<b>EN 438-4:2016</b> , High-pressure decorative laminates (HPL) — Sheets based on thermosetting resins (usually called laminates) — Part 4: Classification and specifications for Compact laminates of thickness 2 mm and greater
	<b>EN 438-5:2016</b> , High-pressure decorative laminates (HPL) — Sheets based on thermosetting resins (usually called laminates) — Part 5: Classification and specifications for flooring grade laminates less than 2 mm thick intended for bonding to supporting substrates
	<b>EN 438-6:2016</b> , High-pressure decorative laminates (HPL) — Sheets based on thermosetting resins (usually called laminates) — Part 6: Classification and specifications for Exterior-grade Compact laminates of thickness 2 mm and greater
	<b>EN 438-8:2018</b> , High-pressure decorative laminates (HPL) — Sheets based on thermosetting resins (usually called laminates) — Part 8: Classification and specifications for Design laminates
	<b>EN 438-9:2017</b> , High-pressure decorative laminates (HPL) — Sheets based on thermosetting resins (usually called laminates) — Part 9: Classification and specifications for alternative core laminates
	<b>EN ISO 13894-2:2015</b> , High-pressure decorative laminates — Composite elements — Part 2: Specifications for composite elements with wood-based substrates for interior use (ISO 13894-2)
	<b>EN 13329:2016+A1:2017</b> , Laminate floor coverings — Elements with a surface layer based on aminoplastic thermosetting resins — Specifications, requirements and test methods
	<b>EN ISO 10874:2012</b> , Resilient, textile and laminate floor coverings — Classification
	<b>prEN 438-7, HPL</b> — Laminates — Part 7: Compact laminate and HPL composite panels for internal and external wall and ceiling finishes (This document)
<b>Product standards</b>	<b>EN 13986:2004+A1:2015</b> , Wood-based panels for use in construction — Characteristics, evaluation of conformity and marking
	<b>EN 14041:2018</b> , Resilient, textile and laminate floor coverings — Essential characteristics
	<b>EN 13964:2014</b> , Suspended ceilings — Requirements and test methods

<b>General standard</b>	<b>EN 438-1:2016</b> , High-pressure decorative laminates (HPL) — Sheets based on thermosetting resins (usually called laminates) — Part 1: Introduction and general information
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Voorbereid  
Preview



## 1 Scope

This document specifies characteristics for compact laminate panels and HPL composite panels both for non-structural uses in interior or external wall and ceiling finish applications (including in suspended ceiling).

This document deals with compact laminate panels of thickness 2 mm and greater.

The compact laminate panels are produced by using a high pressure process and the HPL composite panels are produced bonding an HPL sheet to a substrate.

This document covers compact laminate panels with the following types of laminates:

- compact laminates, as defined in EN 438-4:2016;
- exterior-grade compact laminates, as defined in EN 438-6:2016;
- pearlescent compact laminates, metal compact laminates and wood veneer compact laminates, as defined in EN 438-8:2018;
- coloured core layer compact laminates and metal reinforced core layer compact laminates, as defined in EN 438-9:2017.

This document covers full size and cut-to-size compact laminate panels and HPL composite panels, e.g. tiles and sidings.

This document specifies only compact laminate panels and HPL composite panels mechanically fixed using e.g. screws or rivets.

Both the compact laminate panels and HPL composite panels may contain flame retardant to improve their reaction to fire performance.

This document also specifies provisions for the assessment and verification of constancy of performance (AVCP) of the characteristics and includes provisions for marking these panels.

This document does not cover

- a) HPL sheets less than 2 mm thick as defined in EN 438-3:2016, EN 438-8:2018 or EN 438-9:2017, which are not glued on a substrate;
- b) overlaid or veneered wood-based panels, where the overlay/veneer is not an HPL;
- c) HPL composite panels intended for use as floor coverings;
- d) panels used for fire protection of walls or ceilings;
- e) performances of installed systems for walls and ceilings with compact or composite high pressure laminate panels.

## 2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 438-2:2016+A1:2014, *High-pressure decorative laminates (HPL) — Sheets based on thermosetting resins (usually called laminates) — Part 2: Determination of properties*

EN 717-1:2004, *Wood-based panels — Determination of formaldehyde release — Part 1: Formaldehyde emission by the chamber method*

EN 12664:2001, *Thermal performance of building materials and products — Determination of thermal resistance by means of guarded hot plate and heat flow meter methods — Dry and moist products of medium and low thermal resistance*

EN 13501-1:2018, *Fire classification of construction products and building elements — Part 1: Classification using data from reaction to fire tests*

EN 13238:2010, *Reaction to fire tests for building products — Conditioning procedures and general rules for selection of substrates*

EN 13823:2010+A1:2014, *Reaction to fire tests for building products — Building products excluding floorings exposed to the thermal attack by a single burning item*

EN 13986:2004+A1:2015, *Wood-based panels for use in construction — Characteristics, evaluation of conformity and marking*

EN 16516:2017, *Construction products: Assessment of release of dangerous substances — Determination of emissions into indoor air*

EN ISO 178:2019, *Plastics — Determination of flexural properties (ISO 178:2019)*

EN ISO 1183-1:2019, *Plastics — Methods for determining the density of non-cellular plastics — Part 1: Immersion method, liquid pycnometer method and titration method (ISO 1183-1:2019)*

EN ISO 7049:2011, *Cross-recessed pan head tapping screws (ISO/FDIS 7049:2011)*

EN ISO 10140-1:2016, *Acoustics — Laboratory measurement of sound insulation of building elements — Part 1: Application rules for specific products (ISO 10140-1:2016)*

EN ISO 10140-2:2010, *Acoustics — Laboratory measurement of sound insulation of building elements — Part 2: Measurement of airborne sound insulation (ISO 10140-2:2010)*

EN ISO 10140-4:2010, *Acoustics — Laboratory measurement of sound insulation of building elements — Part 4: Measurement procedures and requirements (ISO 10140-4:2010)*

EN ISO 10140-5:2010, *Acoustics — Laboratory measurement of sound insulation of building elements — Part 5: Requirements for test facilities and equipment (ISO 10140-5:2010)*

EN ISO 10456:2007, *Building materials and products — Hygrothermal properties — Tabulated design values and procedures for determining declared and design thermal values — Technical Corrigendum 1 (ISO 10456:2007)*

EN ISO 10456:2007/AC:2009, *Building materials and products — Hygrothermal properties — Tabulated design values and procedures for determining declared and design thermal values — Technical Corrigendum 1 (ISO 10456:2007/Cor 1:2009)*

EN ISO 12572:2016, *Hygrothermal performance of building materials and products — Determination of water vapour transmission properties — Cup method (ISO 12572:2016)*

EN ISO 13894-1:2015, *High-pressure decorative laminates — Composite elements — Part 1: Test methods (ISO 13894-1:2000)*

CEN/TR 14823:2003, *Durability of wood and wood-based products — Quantitative determination of pentachlorophenol in wood — Gas chromatographic method*

### 3 Terms and definitions, symbols and abbreviations

#### 3.1 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- IEC Electropedia: available at <http://www.electropedia.org/>
- ISO Online browsing platform: available at <http://www.iso.org/obp>

##### 3.1.1

##### **high-pressure decorative laminate(s) (HPL)**

sheet(s) consisting of decorative surface layer(s) and core layers bonded together by a high pressure process

Note 1 to entry: Typical values for the high pressure process are: a temperature of  $\geq 120$  °C and a pressure of  $\geq 5$  MPa.

##### 3.1.2

##### **surface layer**

upper decorative layer consisting in one or more sheets of fibrous material (usually paper) impregnated with aminoplastic thermosetting resins (usually melamine based resins) or other curable resins or other decorative design surfaces which are not necessarily treated with thermosetting resin

Note 1 to entry: The surface layers can appear on one or both side(s) of the laminate(s). In case of one-sided laminates, the back of the sheet(s) may be made suitable for adhesive bonding to a substrate.

Note 2 to entry: Examples of decorative design surface are metal foils, wood-veneers or textiles.

##### 3.1.3

##### **core layer**

core layer consisting of fibrous materials (usually paper) impregnated with thermosetting resins (usually phenolic based resins) or other curable resins, eventually reinforced by metal layer(s) or metal mesh(es) and others which are not necessarily treated with thermosetting resin

##### 3.1.4

##### **compact laminate panel**

panel consisting of decorative surface layer(s) and core layers bonded together by a high pressure process with a thickness of 2 mm or greater

##### 3.1.5

##### **HPL composite panel**

panel produced by adhesively bonding an HPL to one or both sides of a substrate

##### 3.1.6

##### **substrate of the HPL composite panels**

board to which the HPL is bonded

Note 1 to entry: The substrate can be a wood based product (e.g. particleboard, plywood or fibreboard), a mineral board (e.g. calcium silicate), an expanded honeycomb, a metal sheet or plastic material, organic or inorganic fibre boards.

##### 3.1.7

##### **pearlescent compact laminate panel**

compact laminate panel, the surface layer of which consists of a pearlescent effect decorative paper, which is impregnated with aminoplastic thermosetting resins (usually melamine based resins)

**3.1.8****metal compact laminate panel**

compact laminate panel, the surface layer of which consists of a thin layer of metal

**3.1.9****wood veneer compact laminate panel**

compact laminate panel, the surface layer of which consists of a wood veneer, which is covered by a protective melamine layer

**3.1.10****coloured core layer compact laminate panel**

compact laminate panel, the core layer of which consists of coloured fibrous materials (usually paper) impregnated with aminoplastic thermosetting resins (usually melamine based resins) or fibrous materials (usually paper) impregnated with coloured aminoplastic thermosetting resins (usually melamine based resins)

**3.1.11****metal reinforced core layer compact laminate panel**

compact laminate panel, the core layer of which consists of metal layer(s) or mesh(es) and cellulosic fibrous layers (usually paper) impregnated with phenolic thermosetting resins or aminoplastic thermosetting resins (usually melamine based resins)

**3.1.12****exterior-grade compact laminate panel**

compact laminate panel for use under outdoor weather conditions such as direct sunlight rain and frost

**3.1 Symbols and abbreviations****3.2.1 Symbols**

For the purposes of this document the following symbol applies.

$t$  nominal thickness of the laminate

**3.2.2 Abbreviations**

For the purposes of this document, the following abbreviations apply.

ACF	Pearlescent compact laminate with improved fire retardance
ACS	Standard grade pearlescent compact laminate
BCS	Standard grade Coloured core layer compact laminate
CGF	Compact laminates with improved fire retardance
CGS	Standard grade compact laminates
EDF	Exterior-grade compact laminate with improved fire retardance, intended for severe outdoor conditions
EDS	Standard exterior-grade compact laminate, intended for severe outdoor conditions
EGF	Exterior-grade compact laminate with improved fire retardance, intended for moderate outdoor conditions
EGS	Standard exterior-grade compact laminate, intended for moderate outdoor conditions
FR	Flame Retardant
MCF	Metal compact laminate with improved fire retardance
MCS	Standard grade metal compact laminate

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