

TECHNICAL DATA

Arborite® ColorEdge Laminate

Basic Type: CE5

1. Manufacturing facility location10501 NW H K Dodgen Loop
Temple TX
76504 USA**2. Product Description**

Arborite® ColorEdge Laminate is a High Pressure Decorative Laminate sheet available with a color-through core in a selection of patterns and finishes. The continuous color core of ColorEdge laminate provides any application with a solid one-piece effect.

Recommended Uses

Arborite® ColorEdge Laminate is suitable for interior applications such as fine quality contract furniture, fixtures, casework, and also for architectural application on interior doors, and divider systems.

General Purpose (HGS) Basic Type CE5 High Pressure Arborite® ColorEdge Laminate is designed for both horizontal and vertical applications where the surface must be functional, durable, high-quality, and resistant to scuff, scratch and stain.

Product Composition

Arborite® ColorEdge Laminate is a distinctive surfacing material composed of decorative papers impregnated with melamine resins and pressed over a white decor paper core impregnated with special thermosetting resins. These sheets are then bonded at pressures and temperatures similar to HPL. Finished sheets are trimmed, and the backs are sanded to facilitate bonding.

Basic Limitations

Arborite® ColorEdge Laminate is for interior use only and is not recommended for direct application to plaster, concrete walls, or gypsum wallboard. It is not a structural material and must be bonded to a suitable substrate.

Do not subject ColorEdge to extremes in humidity, temperatures higher than 275°F (135°C) for substantial periods of time, or intense, continuous, direct sunlight.

Patterns & Colors

Arborite® ColorEdge Laminate is available in a partial range of Arborite® solid colors, patterns, and finishes. CE5 product is decorative papers impregnated with melamine resins and pressed over a black or white core paper.

- S405 Black CA finish
- S405 Black GL finish
- S405 Black SR finish
- S585 Winter White CA finish
- S585 Winter White GL finish
- S585 Winter White SR finish
- P391 Ruched Chiffon GL finish

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Finishes

- **Cashmere (CA)** – a fine, matte texture with a slight sheen
Nominal Glossometer Reading = 10
- **Gloss (GL)** – a flat texture with a high sheen
Nominal Glossometer Reading = 110
- **Structured (SR)** – a highly embossed linear texture suitable for woodgrains, solids and linear patterns
Nominal Glossometer Reading = 10

3. Technical Data

Nominal Sheet Width

48"
1219mm

Nominal Sheet Length

96"	120"
2438mm	3048mm

Thickness and Weight

Type	Arborite Thickness	Weight Per Square Foot
CE5	0.048" ± 0.005" (1.22mm ± 0.13mm)	0.382 lbs.

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Physical Properties for product type CE5

Property	Typical Arborite Type CE5	ISO 4586-8 BTS
Thickness	0.048" ± 0.005" (1.22mm ± 0.13mm)	N/A
Appearance	No ABC defects	N/A
Cleanability (cycles)	10	20 (max.)
Stain Resistance Reagents 1-10 Reagents 11-15	No effect No effect	No effect Moderate effect
Boiling Water Resistance	No effect	Slight Effect (Gloss) No Effect (Other Finishes)
High Temperature Resistance	No effect	Slight Effect (Gloss) No Effect (Other Finishes)
Impact Resistance	>50" (1270mm)	N/A
Radiant Heat Resistance	150 seconds	≥ 150 sec.
Dimensional Stability Machine Direction Cross Direction	0.5% 0.8%	0.5% 0.9%
Surface Wear Resistance (cycles)	Exceeds 400	350 (min.)
Blistering	Not applicable	Not applicable

Typical Fire Test Data

ColorEdge high-pressure laminates are subject to Flame Spread and Smoke Developed standards in structures where codes establish such conditions. Test data to determine compliance with these codes are obtained by the Steiner Tunnel Test method of the American Society for Testing Materials (ASTM-E-84, Standard Test Method for Surface Burning Characteristics of Building Materials). Tests were conducted in accordance with test method and mounting procedure as described in paragraph X1.7.2 of the test method. This procedure is cataloged by Underwriters Laboratories, Inc. as UL 723.

Here is typical data for Arborite® ColorEdge laminates, averaged from two specific tests:

Typical Flame Spread and Smoke Developed Properties

Product Type	Test Condition	Flame Spread	Smoke Developed
Type CE5	Unbonded	40	135

Model Code Designations used to determine flame spread classification

Flame Spread Classification (Max. Rating)	International (IBC)	Life Safety (NFPA 101)
25	A	A
75	B	B
200	C	C

RE: Architectural Woodwork Quality Standard, 8th Edition, Version 1.0, - 2003

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All Model Codes regulate the generation of smoke by interior finish material. In all cases they specify a maximum smoke development rating of 450.

Codes and Certifications**General Standards**

The UL GREENGUARD Environmental Institute™ has awarded its UL GREENGUARD® Indoor Air Quality Certification to Arborite ColorEdge Laminates. All Arborite ColorEdge Laminate product types were tested under the stringent UL GREENGUARD Standards for low-emitting products. All UL GREENGUARD Indoor Air Quality Certified products ensure minimal impact on the indoor environment. For a copy of the certificate, visit www.greenguard.org.

Arborite® ColorEdge conforms to the voluntary standards of the American National Standards for thickness, performance properties and appearance. Arborite® ColorEdge meets or exceeds the International Standards Organization specifications as found in ISO 4586, titled “High-Pressure Decorative Laminate (HPDL) – Sheets Based on Thermosetting Resins – Part I: specifications.”

4. Installation, Fabrication, and Assembly Recommendations

Fabrication should follow approved methods. Assembled pieces should meet the specifications of KCMA (Kitchen Cabinetmakers Manufacturers Association), ANSI A-161.2-1998 (revised), and “Architectural Woodwork Quality Standards, Guide Specifications and Quality Certification Program” guidelines of the Architectural Woodwork Standards where applicable.

Arborite® ColorEdge Laminate must be bonded to a substrate of reliable quality, industrial 45# density particleboard, or medium density fiberboard (MDF) are recommended. High Pressure Laminate, plaster, concrete, gypsum boards, and plywood should not be considered and are not warranted suitable substrates. Arborite® ColorEdge Laminate may not be used as structural member.

ColorEdge has a color through core and does not have dark edges to conceal the glue line. Recommended adhesives are Wilsonart non-pigmented PVA’s or contact adhesives. Wilsonart offers a variety of non-pigmented PVA and contact adhesive options to meet the variety of bonding applications. All Wilsonart® Adhesives are available from the Wilsonart distributor. Be sure to follow adhesive manufacturer recommendations.

Utilization of a balancing sheet opposite of the ColorEdge material is required in most applications. For best results, use of ColorEdge on both sides of the panel will provide a well-balanced panel. For ideal application, the same type of adhesive, the same coverage on both sides and the ColorEdge sanding marks assembled in the same direction will provide a quality assembly Preferred balancing material: Arborite® ColorEdge Laminate, Type CE5

To avoid stress cracking, do not use square-cut inside corners. All inside corners shall have a minimum of 1/8” (3.175mm) radius and all edges should be routed smooth.

Drill oversized holes for screws or bolts. Screws or bolts should be slightly countersunk into the face side of a laminate-clad substrate.

Take care to ensure an appropriate acclimation between the laminate and the substrate prior to fabrication. The face and backing laminates and the substrate should be conditioned in the same environment for a minimum 48 hours, before fabrication.

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Recommended conditioning temperature is about 75°F (24°C).
Laminates should be conditioned at 45% to 55% relative humidity.

Type CE5 is recommended for flat surfaces only. Do not use in postforming equipment or applications.

Carbide-tipped saw and router blades should be used for cutting. High tool speed and low feed rate are advisable. Cutting blades should be kept sharp. Use of a hold-down to prevent any vibration is recommended.

5. [Warranty](#)

6. [Maintenance](#)

7. [Technical Services](#)

For samples, literature, questions or technical assistance, please email us at info@arborite.com or contact our toll-free number, 1-800-996-0366 Monday through Friday, 8:30 am – 5:00 pm, EST.

Specification Form

Surface shall be Arborite® ColorEdge

Types: CE5

Surface

Color Number: _____ Color Name: _____

Finish

Code: _____ Finish Name: _____

Adhesive

Name: _____ Grade/Type: _____

Brand: Wilsonart® Adhesive