

HPL TABLE TOP – TECHNICAL SPECIFICATION

1. Material Composition

- Surface Layer: Decorative paper + melamine resin
- Core Layers: Kraft paper + phenolic resin (compressed)
- Manufacturing: High pressure + high temperature pressing

2. Standard Sizes

Parameter Typical Range
 Width 600 mm – 1830 mm Length 600 mm – 3660 mm
 Shape Round / Square / Rectangular / Custom ✓ Common sheet size: 1220 × 2440 mm (4×8 ft)

3. Thickness Options

Type Thickness
 Thin laminate (sheet) 0.5 – 1.2 mm Compact HPL (solid core) 2 – 25 mm
 Table top recommended
 10 – 25 mm ✓ Typical coffee table top: 8–12 mm or 12 mm+

4. Physical Properties

Property Value Density 1350 – 1460 kg/m³
 Thermal conductivity ~0.23 W/mK Water absorption Very low (<0.5%) Weight (approx.) 8–17 kg/m² (depending on thickness)

5. Mechanical Properties

Property Value
 Flexural strength ≥100 MPa Impact resistance High (≥90 J) Screw holding strength ≥5000 N Modulus of elasticity ≥10,000 MPa

6. Performance Characteristics

- ✓ Waterproof & moisture resistant
- ✓ Heat resistant (cigarette burn resistant)
- ✓ Fire retardant (FR grade available)
- ✓ Chemical & stain resistant
- ✓ Scratch & abrasion resistant
- ✓ Hygienic & non-porous

7. Surface & Finish Options

- Finish: Matte / Glossy / Textured
- Colors: Solid, wood grain, marble, custom
- Edge: Flat / bevel / rounded
- Pattern: Printed or engraved

8. Types of HPL Table Tops

Type Specification Standard HPL Indoor use Compact HPL Solid core, heavy-duty Exterior HPL UV resistant, weatherproof ✓ Outdoor grade includes UV protection layer

9. Tolerances (as per EN 438)

Thickness Range Tolerance
 2–3 mm ±0.20 mm 5–8 mm ±0.40 mm 10–12 mm ±0.50 mm 16–20 mm ±0.70 mm

10. Recommended Specification (For Coffee Table)

- Thickness: 12 mm compact HPL
- Density: ~1400 kg/m³
- Finish: Matte or textured
- Edge: Rounded (for safety)
- Grade: Indoor / Outdoor (based on usage)

Summary

An HPL table top is a **high-density, engineered panel** with:
 •Strong core (phenolic resin)
 •Durable decorative surface
 •Excellent resistance to **water, heat, scratches, and impact**
 That's why it's widely used in:
 •Coffee tables
 •Dining tables
 •Office furniture
 •Outdoor furniture

HPL TABLE TOP PAKING



BOX PAKING AVAILABLE

TECHNICAL DATA SHEET



HPL EXTERIOR COMPACT LAMINATE

S. No.	Properties	Test Method	Unit Of Measurement	Attributes Of Performance	Results (as Per En 438-4)
A	Surface Quality			En-438 Laminate Classification	
B	Surface Quality	EN 438-2.4	mm ² /m ² mm/m ²	Spots, dirt and similar surface defects Fibres, hairs, and scratches	≤ 1 ≤ 10
C	Dimensional Properties	EN-438-2-5	mm	5.0 ≤ t < 8.0mm: ±0.40 mm	5.0 ≤ t < 8.0mm: ±0.18 mm
D	Thickness			8 ≤ t < 12mm: ± 0.5 mm	8 ≤ t < 12mm: ± 0.24 mm
				12 ≤ t < 16mm: ±0.6 mm	12 ≤ t < 16mm: ±0.28 mm
				16 ≤ t < 20mm: ± 0.7mm	16 ≤ t < 20mm: ± 0.32mm
				25.0 ≤ t: According to agreement Customer/Producer	25.0 ≤ t: According to agreement Customer/Producer
E	Size	EN 438-2.6	mm	Length and Width +10/-0	+05/-0
F	Straightness of edges.	EN 438-2.7	mm /m	Straightness of edges ≤1.5	≤1
G	Squareness	EN 438-2.8	mm /m	Squareness ≤ 1.5	≤1
H	Flatness (measured on full size sheet)	EN 438-2.9	mm /m	For 1.80 ≤ t < 6.00mm: 8 For 6 ≤ t < 10.00 mm: 5 10 ≤ t: 3	5 3 2
I	Physical Properties	EN 438-2.10	Revolutions	Wear Resistance - Initial Point	Unicolours - ≥ 200 Printed Decor - ≥ 160 unicolors - ≥ 450 Printed Decor - ≥ 410
J	Resistance to Surface Wear			Wear Resistance - Wear Value	
				Mass increase - T ≥ 5 mm Thickness increase - T ≥ 5 mm	
				Appearance - Gloss Finish Appearance - Other Finishes	
			% % Rating Rating		≤ 1 ≤ 1.5 ≥ 4 ≥ 5
K	Resistance to Water vapour	EN 438-2.14	Rating Rating	Appearance - Gloss Finish Appearance - Other Finishes	≥ 4 ≥ 5
L	Resistance to Dry Heat @ 180 C	EN 438-2.16	Rating Rating	Appearance - Gloss Finish Appearance - Other Finishes	≥ 4 ≥ 5
M	Dimensional Stability at elevated temperature	EN 438-2.17	longitudinal % Transversal % longitudinal % Transversal %	Cumulative Dimensional Change 2 ≤ T < 5 mm Cumulative Dimensional Change T < 5 mm	≤ 0.40 ≤ 0.80 ≤ 0.30 ≤ 0.60
N	Resistance to impact by large diameter ball	EN 438-2.21	min. min.	Indent dia. 10mm 2 ≤ 6 mm - 1800mm indent dia. 10mm T ≥ 6mm - 1800 mm	6 4
O	Resistance to Crazeing	EN 438-2.24	Rating	Appearance	≥ 4
P	Resistance to Scratching	EN 438-2.25	Rating Rating	Appearance -Smooth Finishes Appearance - textured Finishes	≥ 2.5 ≥ 3.5
Q	Resistance to Staining	EN 438-2.26	Rating Rating	Appearance -Group 1 & 2 Appearance - Group 3	≥ 5 ≥ 4
R	Light Fatness	EN 438-2.27	Grey Scale Rating	Contrast	4 to 5
S	Resistance to Cigarette Burns	EN 438-2.30	Rating	Appearance	≥ 3
T	Flexural modulus	EN -ISO - 178 2003	Mpa	Stess ≥ 9000	9000-11500
U	Flexural Strength	EN -ISO - 178 -2003	Mpa	Stess ≥ 80	80-100
V	Tensile Strength	EN -ISO - 572-2 -1996	Mpa	Stess ≥ 60	60-90
W	Density	EN -ISO 1183-1:2004	gm/cm ³	Density 1.35 - 1.45	1.4 ± 0.05
X	Fire Performances	EN 135 01	Rating	Test as per EN 13823 and EN ISO 11925-2 (Small -Burner Test)	D - s2,d0
Y	Fire Reaction Classification			Classification - T ≥ 6 mm Classification - 3 ≤ T < 6 mm Classification - 6 ≤ T < 13 mm	
	Fire Reaction Classification		Rating		B - s2,d0 B - s1,d0
Z	Other properties Release Of Formaldehyde	EN 438-7.4.11.1	Rating	Clasification	E1

