
**High-pressure decorative laminates
(HPL, HPDL) — Sheets based on
thermosetting resins (usually called
laminates) —**

**Part 2:
Determination of properties**

*Stratifiés décoratifs haute pression (HPL, HPDL) — Plaques à base de
résines thermodurcissables (communément appelées stratifiés) —*

Partie 2: Détermination des caractéristiques

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation on the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see the following URL: www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 61, *Plastics*, Subcommittee SC 11, *Products*.

This seventh edition cancels and replaces the sixth edition (ISO 4586-2:2015) which has been technically revised.

The main changes compared to the previous edition are as follows:

- correction of errors due to typographical, formatting, and omission issues.

A list of all parts in the ISO 4586 series can be found on the ISO website.

Introduction

In an effort to harmonize ISO 4586 with other high-pressure decorative laminate standards, multiple methods may be published that demonstrate similar properties. In these instances, the same test method title is given and is annotated as either “Method A” or “Method B”. This is the case in the following tests: Edge squareness — 8/9, Dry heat — 17/18 Dimensional stability at elevated temperatures — 19/20, Dimensional stability at ambient temperature — 21/22, Staining — 30/31, Lightfastness — 32/33, Formability — 38/39, and Blistering — 40/41. In these instances, either method may be utilized in testing. Compliance to both methods is not required. While these tests are similar they are by no means identical and results of one method do not necessarily correspond to the results of the accompanying test. In these situations, it is intended that the documentation in specific parts of ISO 4586 for performance requirements be consulted. Each specific method has performance requirements particular to that method for individual grades of high-pressure decorative laminate.

This document has been harmonized with EN 438-2 whenever possible.

High-pressure decorative laminates (HPL, HPDL) — Sheets based on thermosetting resins (usually called laminates) —

Part 2: Determination of properties

1 Scope

This document specifies the methods of test for determination of the properties of high-pressure decorative laminates (HPL, HPDL) as defined in [Clause 3](#). These methods are primarily intended for testing the sheets specified from ISO 4586-3 to ISO 4586-8.

The precision of the test methods specified in [Clauses 5, 6, 7, 8, 9, 10, 13, 14, 16, 19, 20, 21, 22, 24, 25, 26, 39, and 40](#) is not known because interlaboratory data are not available. When interlaboratory data are obtained, precision statements will be added to the test methods at the following revision. As all the other test methods have an end point determination based on subjective judgement, it is not meaningful to make a statement of precision in these cases.

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.

ISO 62, *Plastics — Determination of water absorption*

ISO 105-A02, *Textiles — Tests for colour fastness — Part A02: Grey scale for assessing change in colour*

ISO 178, *Plastics — Determination of flexural properties*

ISO 291, *Plastics — Standard atmospheres for conditioning and testing*

ISO 1770, *Solid-stem general purpose thermometers*

ISO 3668, *Paints and varnishes — Visual comparison of colour of paints*

ISO 4892-1, *Plastics — Methods of exposure to laboratory light sources — Part 1: General guidance*

ISO 4892-2:2013, *Plastics — Methods of exposure to laboratory light sources — Part 2: Xenon-arc lamps*

ISO 4892-3, *Plastics — Methods of exposure to laboratory light sources — Part 3: Fluorescent UV lamps*

ISO 6506-1, *Metallic materials — Brinell hardness test — Part 1: Test method*

ISO 9352, *Plastics — Determination of resistance to wear by abrasive wheels*

ISO 9370, *Plastics — Instrumental determination of radiant exposure in weathering tests — General guidance and basic test method*

ISO 12945-2, *Textiles — Determination of fabric propensity to surface fuzzing and to pilling — Part 2: Modified Martindale method*

ISO 12947-1, *Textiles — Determination of the abrasion resistance of fabrics by the Martindale method — Part 1: Martindale abrasion testing apparatus*

EN 312, *Particleboards — Specifications*

EN 316, *Wood fibreboards — Definition, classification and symbols*

ASTM G155, *Standard Practice for Operating Xenon Arc Light Apparatus for Exposure of Non-Metallic Materials*

CIE publication no. 85: 1989, *Solar spectral irradiance*

3 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 <https://www.electropedia.org/>
- ISO Online browsing platform: available at <https://www.iso.org/obp>

3.1 high-pressure decorative laminate

HPL

HPDL

sheet consisting of layers of cellulosic fibrous material (normally paper) impregnated with thermosetting resins and bonded together by the *high-pressure process* (3.2)

Note 1 to entry: This is a general definition of high-pressure decorative laminate(s). More specific product definitions can be found from ISO 4586-3 to ISO 4586-8.3.2.

3.2 high-pressure process

simultaneous application of heat (temperature ≥ 120 °C) and high specific pressure (≥ 5 MPa), to provide flowing and subsequent curing of the thermosetting resins to obtain a homogeneous non-porous material with increased density ($\geq 1,35$ g/cm³), and with the required surface finish

3.3 rub

<microscratch resistance> one revolution of the two outer drives of the Martindale tester

3.4 cycle

<microscratch resistance> completion of all the translational movements tracing a *Lissajous figure* (3.5) comprising 16 *rubs* (3.3)

3.5 Lissajous figure

<microscratch resistance> figure created by movement which ranges changes from a circle gradually narrowing ellipses, until it becomes a straight line, from which progressively widening ellipses develop, in a diagonally opposite direction before the pattern is repeated

Note 1 to entry: This comprises 16 revolutions of the two outer drives and 15 revolutions of the inner drive of the Martindale tester.