



# StyleLite Acrylic Capped ABS Sheet (SHAB) Specification

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## Overview

This specification pertains to StyleLite extruded high gloss and velvet (matte) sheet designed for mechanical or manual lamination to wood composite panel substrates for interior vertical surfaces in residential and non-residential applications such as kitchens, cabinetry, retail store fixtures, furniture and other millwork types.

Technical Specification Table		
Property	Specification	Test Method
Length	0" to + 3/8" (0 to + 9mm)	Steel Tape
Width	0" to + 1/4" (0 to + 6mm)	
Diagonal difference	< 1/8" (< 3mm)	
Total thickness	0.039" +/- 5% (1.0 mm +/- 5%)	Micrometer
Acrylic cap thickness	0.002" to 0.003" (50 to 80 Microns)	
Surface gloss level	Gloss at > 90% measured at 60 degrees Velvet at maximum 20% measured at 60 degrees	Gloss Meter
Dyne level (back)	50 target, compare to master sample	Dyne Test Kit
Cutting process	No fine chips or residue of any kind between sheets Edge finish must be straight and cleanly cut No chipping or cracking	Visual
Flatness	No waviness or rippling	Visual
Solid colors	Delta E <1.0 reflected, compared to approved master sample	Spectrophotometer
Metallic colors	Delta E <1.5 reflected, compared to approved master sample	
Printed decors	Compare color to master sample	Calibrated Light Box
	Compare print design and definition to master sample	
Surface hardness	Gloss 4H within 24 hours of peel coat removal and artificial curing of acrylic layer. 5 days via air curing.	Pencil Test
	Velvet 5H within 24 hours of peel coat removal and artificial curing of acrylic layer. 5 days via air curing.	
Surface imperfections for whole sheet	Compare to approved master sample	Visual assessment in moderate lighting viewed at 60 degrees angle from 24" (600mm)
Surface quality	No obvious die or flow lines No pin holes No face scratches No face repeat marks No bubbles No foreign matter of any kind	
Peel coat finish	No wrinkles, bubbles or lifting at the edges Sound adhesion across face area No excessive stretching during application	Visual
Peel coat specification	Clear, tack as per approved master sample No adhesive residue. Directional arrows on both sides for metallic colors	
Packaging	250 sheets per crate, use only fumigated wood suitable for global export 4 way pallet base to crate with heavy duty strapping Crate design must ensure all top loads do not compress sheets Crate design must be stackable to 5 crates high	Work instruction & QA inspection
Batch traceability	Face side peel coat printed with sheet code, color and batch traceability to EGR approved standard	
Warranty	10 years interior use, no significant color change, loss of gloss or surface change	Visual
Accelerated weathering	< Delta E of 1 color change compared to approved master sample. No visual change to surface finish or gloss level	Calibrated Light Box QUV B, 2,000 hours