

**Wilsonart® METALAMINATES™**  
**(Product Type 408)**  
**Technical Data**

**1. Manufacturer**

Distributed by Wilsonart International  
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Temple, Texas 76503-6110  
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**2. Product Description**

Recommended Uses: Wilsonart METALAMINATES are designed for vertical interior applications where a special accent is required or a special mood is desired. The surface of Wilsonart METALAMINATES is that of fine finished metal. These materials are appropriate for vertical areas in hotel and office lobbies, theaters, retail facilities and restaurants, where its special eye-catching properties add a definite prestigious appeal. These materials also can add a bright touch when used in combination with high gloss solid color laminates, Wilsonart® Custom Edges or Wilsonart® Gibraltar® Solid Surfacing.

Product Composition: Wilsonart METALAMINATES are composed of a colored aluminum decorative layer pressed over kraft paper core sheets impregnated with phenolic resin. These sheets are bonded at pressures greater than 1000 pounds per square inch and temperatures approaching 300°F (149°C). The decorative aluminum sheet is either anodized or epoxy coated to resist tarnishing. Finished sheets are trimmed and the backs sanded to facilitate bonding.

Basic Limitations: Wilsonart METALAMINATES are intended for interior use only and are not recommended for application to plaster, concrete walls, or gypsum wallboard. It is not a structural material and must be bonded to a suitable substrate. *Some* Wilsonart® Metalaminates can be postformed or coldformed adding the decorative capability of a soft edge detail. Do not subject Wilsonart® Metalaminates to extremes in humidity, temperatures over 150°F (66°C) for sustained periods of time, or intense continuous direct sunlight.

Reflective value and metal color may vary dependent upon aluminum alloy and on type of lighting used. Fluorescent, incandescent and daylight produce slight color variations.

**Pattern, Size and Finish Availability:**

Note: All Wilsonart METALAMINATES are supplied with a protective peel coat to prevent surface damage.

<b>Patterns</b>	<b>Name</b>	<b>Surface Finish</b>	<b>Thickness</b>	<b>Stock Sizes</b>
L6415	Polished Gold	Anodized	0.035"	4' x 8'
L6417	Polished Natural	Anodized	0.035"	4' x 8'
L6419	Brushed Iron	Epoxy	0.032"	4' x 8'
L6427	Aluma	Anodized	0.032"	4' x 8' & 10'
L6428	Pearl	Anodized	0.032"	4' x 8' & 10'
L6429	Brushed Natural	Anodized	0.032"	4' x 8' & 10'
L6430	Brushed Gold	Anodized	0.032"	4' x 8' & 10'

Patterns	Colors	Surface Finish	Thickness	Stock Sizes
L6431	Tungsten	Anodized	0.032"	4' x 8'
L6432	Copper Dust	Anodized	0.032"	4' x 8'
L6433	Gold Dust	Anodized	0.032"	4' x 8'
L6434	Iron	Anodized	0.032"	4' x 8'
L6435	Ore	Anodized	0.032"	4' x 8'

**Sheet Dimensions:**

Sheet Width	24" (+0 - 1/8") 48" (-0 + 1/4")	609.6 mm (+0 - 3.2 mm) 1219.2 mm (-0 + 6.4 mm)
Sheet Lengths	96" (-0 + 1/2")	2438mm (-0 + 12.7 mm)
	120" (-0 + 1/2") (*)	3048mm (-0 + 12.7 mm)
Sheet Thickness	Nominal 0.032"	0.8 mm
	*Nominal 0.035" (L6415 & L6417)	0.9 mm
Weight PSF	0.035" Polished*	0.327#psf
	0.032" Brushed, Matte & Aluma	0.245#psf

(\*) 10' lengths available in patterns L6427, L6428, L6429 & L6430 only.

**Decorative Strips: 1 3/4" x 96" (44.4 mm x 2438.4 mm)**

Strip Width	1-3/4"	44.4 mm
Strip Length	96"	2438.4 mm
Strip Thickness	Nominal 0.032"	0.8 mm
	*Nominal 0.035"	0.9 mm

### 3. Technical Data

**Codes and Certifications:** Currently there are no National Electrical Manufacturers Association (NEMA) standards for decorative metal surfacing.

The GREENGUARD Environmental Institute™ has awarded its **GREENGUARD® Indoor Air Quality Certification** to Wilsonart Laminate. All Wilsonart Laminate product types were tested under the stringent GREENGUARD Standards for low-emitting products. All GREENGUARD Indoor Air Quality Certified® products ensure minimal impact on the indoor environment. For a copy of the certificate, visit [www.greenguard.org](http://www.greenguard.org).

**Fire Test Data:**

Wilsonart® METALAMINATES™ have been tested in accordance with ASTM-E84, Steiner Tunnel Test. Test results are:

**Class 1 or A Rating**

Pattern	Flame Spread Index	Smoke Developed Index
L6415 Polished Gold L6417 Polished Natural L6427 Aluma L6428 Pearl L6429 Brushed Natural L6530 Brushed Gold	L6431 Tungsten L6432 Copper Dust L6433 Gold Dust L6434 Iron L6435 Ore	≤25 ≤0

**Class II or B Rating**

Pattern	Flame Spread Index	Smoke Developed Index
L6419 Brushed Iron	≤75	15

### **Model Code Designations used to determine flame spread classification**

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

(Reference: Architectural Woodwork Quality Standard, 8<sup>th</sup> Edition, Version 1.0 - 2003)

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

#### **4. Installation: Fabrication and Assembly Recommendations**

Please follow the recommended fabrication steps for METALAMINATES outlined in the Wilsonart METALAMINATES Fabrication Manual, BRO406.

Some points to keep in mind when using Wilsonart METALAMINATES include:

- 1. It is recommended that a laminate file or 220-grit sandpaper and wood block be used to remove burrs or metal curl back after cutting.**
2. Use on vertical surfaces only. **Horizontal work surfaces are not recommended.**
3. The protective film should be removed as soon as the application is complete. If the film is left in place after fabrication, exposure to direct sunlight for a prolonged period may cause a paste residue and difficulty in removing the protective film.
4. For postforming temperatures and radius limitations, refer to the **Wilsonart METALAMINATES Fabrication Manual, BRO406. We do not recommend postforming patterns L6415, Polished Gold, and L6417, Polished Natural. When postformed, the anodized aluminum is subject to surface crazing with subsequent surface oxidization.**
5. Take care to ensure an appropriate moisture balance between the metallic laminate, the substrate and the phenolic backer prior to fabrication. The panel components (metallic, substrate and phenolic backer) should be conditioned in the same environment for 48 hours before fabrication. For best results, the room where fabrication takes place, as well as all materials, should be preconditioned to 65°F (18°C) or above. The ideal climate is 75°F (24°C) at 50% relative humidity.

Materials: Desirable substrate materials include ¾" 45 lb. medium-density particleboard. Any substrate material should have a density of at least 45 pounds per cubic foot.

Typically backer sheets are applied to panels to ensure balance. Wilsonart Backer Type 203 is recommended. Apply it first to the substrate and then apply the face material. Edges can be applied before or after the backer and decorative sheet.

Proper adhesive selection is critical to achieving a correct bond for all Wilsonart METALAMINATES. Rigid-set, permanent-type adhesives, such as white glue (PVAc), and contact adhesives are recommended. Wilsonart® Adhesives (specifically WA 600, WA 800, WA 950, WA H20, WA 3000, and WA 3100), are available from your Wilsonart product distributor and meet the majority of bonding conditions.

Methods: **Fabrication of components should only be performed according to approved methods as detailed in the Wilsonart METALAMINATES Fabrication Manual, BRO406.**

Assembled pieces should meet specifications of KCMA (Kitchen Cabinet Manufacturers Association), ANSI-A161.2-1998, and "Architectural Woodwork Quality Standards, Guide Specifications and Quality Certification Program" guidelines of the Architectural Woodwork Institute where applicable.

**Note:** METALAMINATES conduct electricity. To prevent electrical shock and shorting do not make electrical contact with METALAMINATES.

## 5. Maintenance

It is recommended that metallic laminate surfaces be cleaned with 409® Glass & Surface Cleaner and warm water with a mild soap such as those used for hands or dishes. Household cleaners, non-ammoniated detergents, or glass cleaners may be used. Stubborn stains may be removed with a thin, clean oil and a dry cloth. After washing, always wipe the surface completely dry with a soft, clean cloth. **Do NOT use cleaners that contain abrasives, acids or alkalis, as they will mar the surface. Ammoniated detergents or petroleum-based cleaners should not be used to clean METALAMINATES surfaces.**

**Do NOT clean metal face with solvents, paint thinner or adhesive remover.** Refer to BRO406, Decorative Metals Fabrication Manual, for adhesive removal recommendations.

## 6. Warranty

Wilsonart International, Inc. warrants that, under normal use and service, the material and workmanship of its Wilsonart® Decorative Metals and METALAMINATES™ shall conform to the applicable supplier or industry standards set out below, or to the standards set forth on the applicable technical data sheets for a period of one (1) year from the date of sale to the first consumer purchaser. Dealers and distributors are provided with the technical data sheets which contain specific standards of performance for the products. In the event that a Decorative Metal or METALAMINATES product does not perform as warranted, the first consumer purchaser's sole remedy shall be limited to repair or replacement of all or any part of the product which is defective, at the manufacturer's sole discretion. In no instance shall the replacement cost exceed the original purchase price paid by the consumer purchaser for the Decorative Metals or METALAMINATES product. This warranty applies only to product:

1. In its original installation; and
2. Purchased by the first consumer purchaser.

This warranty is not transferable, **does not cover horizontal applications** and expires upon resale or transfer by the purchaser.

This warranty shall not apply to defects or damage arising from any of the following:

1. Accidents, abrasion, physical impact, abuse or misuse;
2. Exposure to extreme temperature, corrosive atmospheres or precipitants;
3. Improper fabrication, installation or maintenance; or
4. Any damage due to delivery or after delivery of the product to the purchaser.
5. Horizontal applications.

NO OTHER WARRANTIES, EXPRESS OR IMPLIED, ARE MADE, INCLUDING MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. UNDER NO CIRCUMSTANCES SHALL WILSONART INTERNATIONAL, INC. BE LIABLE FOR ANY LOSS OR DAMAGE ARISING FROM THE PURCHASE, USE OR INABILITY TO USE THIS PRODUCT, OR FOR ANY SPECIAL, INDIRECT, INCIDENTAL OR CONSEQUENTIAL DAMAGES. NO FABRICATOR, INSTALLER, DEALER, AGENT OR EMPLOYEE OF WILSONART INTERNATIONAL, INC. HAS THE AUTHORITY TO MODIFY THE OBLIGATIONS OR LIMITATIONS OF THIS WARRANTY.

This warranty gives you specific legal rights, and you may also have other rights which vary from state to state; therefore, some of the limitations stated above may not apply to you. It is to your benefit to save your documentation upon purchase of a product.

Supplier or Industry Standards for Decorative Metals and METALAMINATES for visual surface defects are as follows:

1. Visual Surface Defects – means spots, indents, stains, scratches, orange peel and/or sheet flatness. These defects must not be easily detected when inspected using established viewing conditions.
2. Established viewing conditions shall be from a distance of 6.6 feet with an indirect illumination intensity of 400 lux. The viewing area is 4 square feet.
3. Visual surface defects are measured according to T.A.P.P.I. T-564 sp-96, Transparent Chart for the Estimation of Defect Size. A visual defect means spots, indents, etc. that are 0.8mm(2) or more within 4 square feet, or 2 defects each having an area of 0.4mm(2) or more within 4 square feet. Further the visual defect should be at least 12” apart.

## 6. Technical Services

For samples, literature, questions or technical assistance, please contact our toll-free Hotline at (800) 433-3222, Monday through Friday, 7 am –7 pm, CST, or [www.wilsonartlamine.com](http://www.wilsonartlamine.com).

### Specification Form:

Surface shall be Wilsonart® METALAMINATES™, distributed by Wilsonart International, Temple, Texas 76503-6110.	
Type: 408	
Surface	
Pattern Number:	_____
Pattern Name:	_____
Decorative Strips	
Pattern Number	_____
Pattern Name	_____
Adhesive	
Name:	_____
Grade/Type:	_____
Manufacturer:	_____
Fabrication shall comply with Architectural Woodwork Quality Standards Guide.	

MetalaminatesTD (TD0406)  
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