



G-Form + Flat G-Form®

G-Form + Flat G-Form Technical Data (1) :

General :

Gentas G-Form laminates can be produced in 2 types :

1) Formed compact laminate according to the customer need (See attached technical information) – Done in Mengen Bolu.

2) Flat G – Form Laminate ready to be formed (See attached forming instructions).

Gentas G-Form laminates are produced according to EN 438 with a special core structure that enable the Unique characteristics

Of the formed and flat laminates together with the benefits of a compact laminate.

Thickness available :

3 , 4 , 6 , 8 , 10 , 12 mm

Size of formed laminates (G – Form Laminate) :

Max. 1400 x 2800 mm or according to customer specification (See Attached specification form)

Any other size upon request

Size of ready to be formed laminates (Flat G - Form laminate) :

Max. 1400 x 3000 mm or according to customer specification (See Attached specification form)

Any other size upon request

Decors :

All decors types (printed and plain color) from Gentas collection

Always identical on both sides

Core :

Black , Brown

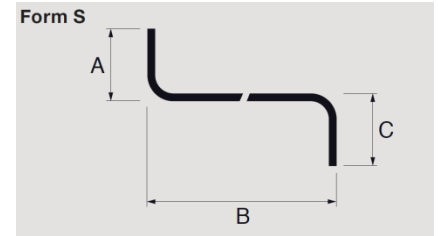
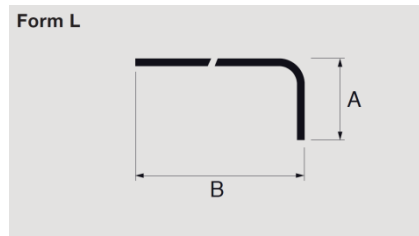
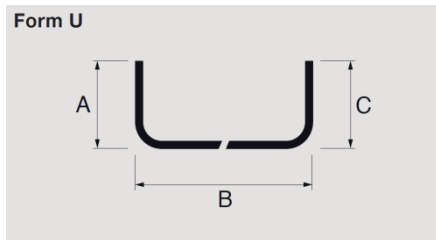
Colored Stripes – Upon request .

Surface Finish :

Vellur, Veneer, Quartz, Grain, Ceramic, Quartz, Wood 1, Italian Stone, Oluklu.

G-Form + Flat G-Form Technical data (1) :

Forming Shape :



Banding Radius (Inner in mm) :

3 , 4 , 6 mm : Minimum R15

8 , 10 , 12 mm : Minimum R20



G-Form + Flat G-Form®

G-Form + Flat G-Form Technical Data (2) :

Specification Form :

The following specification form has to be send to Gentas A.S. for Confirmation :

Number Of Laminates	Decor	Surface Finish	Thickness (mm)	Interior Banding Radius (mm)	Form Shape Type	Part	A	B	C	Remarks

Forming Instructions :

The following forming instructions refer to Flat G – Form laminate That can be molded according to the customer need.

All the characteristics of the formed laminate will meet the results as mentioned below . In order to form Gentas Flat G - Form the following equipment should be available :

Heating low pressure press :

- Pressure 5 – 15 Kg/cm2 Pressure on the laminate surface
- Heating capability : 155 - 160°C on the surface of the press opening.
- Protective Layer : See below recommendations.

Protective Layer :

Heat resistant protective layer for the press and the mold with temp. resistance up to 180°C (Usually Regular Kraft paper 180 gsm or any other protective film) . The protective layer will function as a cushion In order to protect the decorative surface against any surface damage that can be caused by the press or The mold Pressing / Molding surface.

Transportation Device :

Transportation system for moving the pressed laminates (the pressed laminates are in temp. 170 - 180°C after pressing)
From the press to the molding press.

Molding Press :

The molding press should fit the size , shape and thickness of the finished formed laminate. The quality of the molding press is crucial for the quality of the formed laminate . Any misuse in the press mold will lead To low

quality finished laminate (Cracked , Broken , Surface Contamination , un uniformity in the surface finish). Gentas A.S. recommend to consult a professional mold press company for the specific requirement of the mold press.

Mold press pressure : 15 – 20 Kg/cm².

Cooling / Heating system : No need.

Protective Cushion on Mold Press opening : See above recommendations.

Temperature measurement device :

Temperature Gun / Thermocouple .

Safety Device :

According to the local regulation (Goggles / gloves / Fire Protection etc.) .

G-Form + Flat G-Form Teknik Data Bilgileri : (3)

Forming Production stages :

1) Laminate acclimation : Climate the laminate for 24 Hour before Pressing and Molding in environment controlled area in the Following conditions : Temp. = 20 - 30°C ; %RH = 50 – 60%.

2) Press Preparation :

2.1 Heat the press to the needed temp. (155 - 160°C on the surface of the press opening) and check that the Temperature is

Constant in all the press area.

2.2 Check that the pressure in all press area is equal (15 – 20 Kg/cm²).

2.3 Propriety of the protective layer (Clean , no wrinkles).

3) Molding Press Preparation :

3.1 Check that the pressure in all molding press area is equal (15 – 20 Kg/cm²).

3.2 Propriety of the protective layer (Clean , no wrinkles).

3.3 Ensure that the temp. of the press mold is 25 - 30°C (in case the mold opening is too cold it will Affect the bending).

In case the Mold Press is too cold - heat it with pressed Protective Layer.

4) Pressing the Flat Laminate :

4.1 Insert the laminate into the press according to the following combination :



4.2 Close the press and heat under pressure according to the Thickness :

For every 1 mm of laminate heat under pressure for 35 – 40 seconds.

For example : for Laminate in nominal thickness of 9.5 mm the heating time under pressure should be 333 – 380 sec.

4.3 After pressing move the laminate into the molding press as soon as possible (in 30 – 50 seconds).



G-Form + Flat G-Form Technical Data (3) :

4.4 Close the molding press and maintain under pressure according to the thickness .

For every 1 mm of laminate maintain the pressure for 1.2 minutes.

For example : For Laminate in nominal thickness of 9.5 mm maintain the pressure for 11.4 Minutes.

4.5 After Molding Take the laminate out of the press and ensure cooling for 24 Hours in controlled area in the following.

Conditions : Temp. = 20 - 30°c ; %RH = 50 – 60% , before further processing.

4.6 After 24 hours process the laminate according to the need (Edges Cutting , Trimming etc.).

5) Safety : All Safety precautions should be taken in order to avoid any injury.

6) Recommendations :

6.1 All the above instruction should be tested before serial production in order to specify the conditions in order to achieve the

Needed laminate quality.

6.2 Other molding process can be used (roller press) upon the producer responsibility.

6.3 For any technical assistance please ask your sales person.

G-Form + Flat G-Form Technical Data (4) :

Characteristics	Test Method	Test Results
Density	ISO 1183 - 1	1.4 ± 0.5 gr/cm ³
Wear Resistance	EN 438-2 section 10 CGS	Initial Point ≥ 150 Rev. Wear Value ≥ 350 Rev.
Scratch Resistance	EN 438-2 section 25 CGS	Min. 3 N
Thickness	EN 438-2 section 5	3.0 ≤ t ≤ 4.0 mm : ± 0.50 mm 6.0 ≤ t ≤ 7.9 mm : ± 0.6 mm t ≥ 8.0 mm : According To Agreement customer / producer
Impact Resistance	EN 438-2 Big Ball section 21 CGS 3.0 ≤ t ≤ 5.9 mm t ≥ 6.0 mm	1400 mm height : no crack , 50 mm Max. 1800 mm height : no crack , 50 mm Max.
Resistance to Staining	EN 438-2 section 26 CGS Group 1+2 Group 3	Min. level 5 Min. level 4

G-Form + Flat G-Form Technical Data (4) :

Characteristics	Test Method	Test Results
Tensile Strength	EN ISO 527 – 2 CGS	Min. 60 MPa
Bending Strength	EN ISO 178 CGS	Min. 80 MPa
Rigidity	---	Up to 80°C in constant temperature
Flatness	EN 438-2 bölüm 9 CGS S Type Shape L Type Shape U Type Shape	Max. 2.2 mm / Running Meter Max. 1.2 mm / Running Meter Max. 2.2 mm / Running Meter