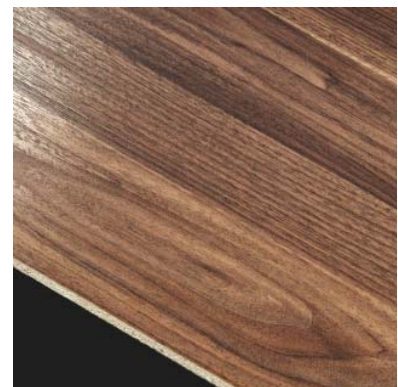


# IHD-Quality-Guideline

## for

### decor finish foils

Version: 02 (2021)



Editor: Institut für Holztechnologie Dresden  
gemeinnützige GmbH  
Zellescher Weg 24  
01217 Dresden  
Germany  
[www.ihd-dresden.de](http://www.ihd-dresden.de)



Leading manufacturers of decor finish foil have joined forces with the Institut für Holztechnologie Dresden gemeinnützige GmbH to form a “decor finish foils” work group for the purpose of drafting a uniform guideline for testing and defining the quality of their products regarding surface and environmental parameters.

Thereby, uniform, reproducible and differentiating test methods were to be derived by test-methodological investigations and verification in round-robin tests.

The objective of the investigations was to guarantee uniform declaration of product properties of decor finish foils (regardless of later application requirements) of all companies involved.

Decor finish foils are mainly used in the furniture industry, but also in the field of interior work (panels, strips, ...) for the decorative design of substrate materials made of chipboard or fibreboard.

Such decor finish foils are special papers, coloured or printed on, with a lacquer-coated surface. Thereby, the quality of the future decor finish foil is determined by the paper substrate, the printing process and the lacquer coating.

Figure 1 shows various ways of manufacturing decor finish foils.

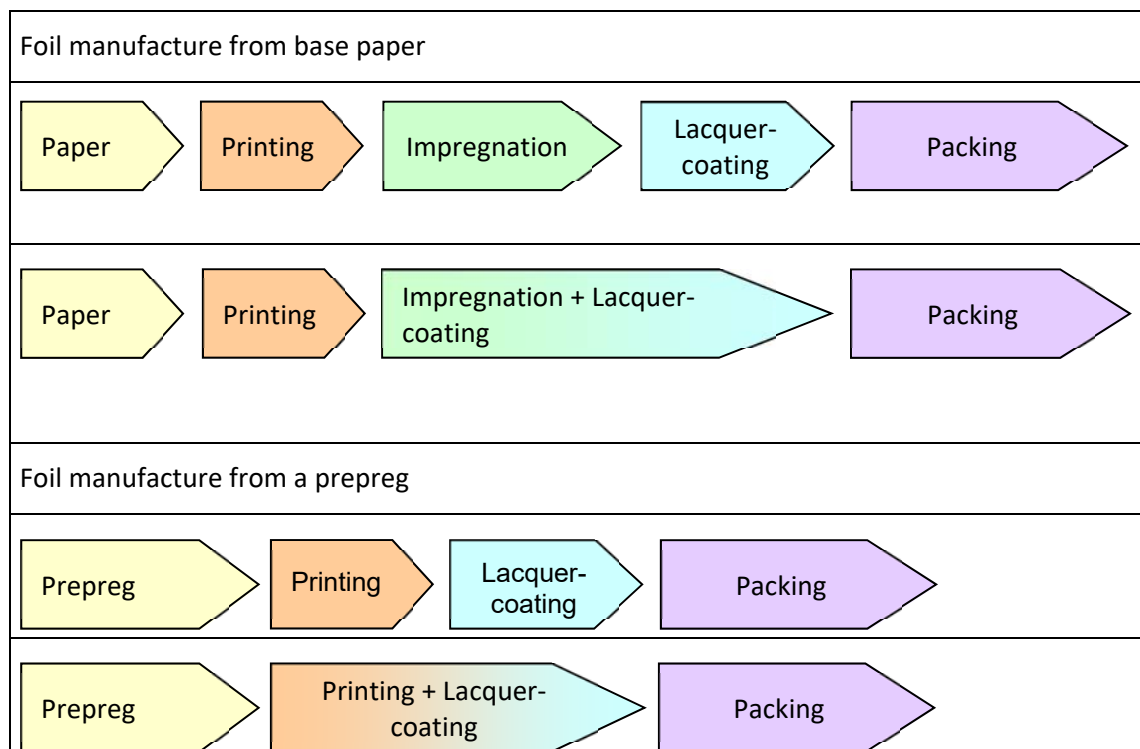


Figure 1: Possibilities of decor finish foil manufacture (Source: BauschLinnemann GmbH)

The processing firm is usually supplied with decor finish foils in reels and, by way of a separate layer of adhesive, glued to a substrate (generally a wood-based material) to form a final product.

## Specifications for the declaration of properties of decor finish foils

	Properties/Test Methods	Unit/ Category	Specification of the Property/ Result (Example)
1	<b>Thickness</b> acc. to IHD-W-454	µm	70
2	<b>Grammage</b> acc. to IHD-W-455	g/m <sup>2</sup>	80
3	<b>Surface gloss</b> acc. to IHD-W-456	Gloss unit with measuring geometry of 20°, 60° or 85°	34 (60°) 6 (85°) 90 (20°)
4	<b>Opacity</b> acc. to IHD-W-458 procedure 1: procedure 2:	grey-scale degree dE00 or dE CMC	3,5 2,2
5	<b>Surface tension</b> acc. to IHD-W-459	mN/m	34
6	<b>Chemical resistance</b> acc. to: DIN 68861 T1/ IHD-W-460	stress group 1C	fulfilled
	IKEA Standard IOS-MAT 0066/ IHD-W-460	stress group R2/ R4	fulfilled
	FIRA-Standard 6250 (horizontal stress)/ IHD-W-460	FIRA 6250 (horizontal)	fulfilled
7	<b>Abrasion resistance</b> acc. to IHD-W-461	class	3
8	<b>Scratch resistance</b> acc. to DIN EN 15186 Procedure B	N	0,3
9	<b>Adhesive tape resistance</b> acc. to IHD-W-463	assessment level / (time of exposure)	5 – 1 / (10 min, 24 h, 14 d)
10	<b>Light fastness</b> acc. to EN 15187	level	> 6; = 6 or < 6
11	<b>Micro-scratch resistance</b> acc. to CEN/TS 16611 procedure A and/or procedure B	gloss change scratch picture	23 % class 4
12	<b>Formaldehyde emission</b> acc. to EN 12460-3	mg /m <sup>2</sup> h (with or without conditioning)	0,65 mg /m <sup>2</sup> h with conditioning
13	<b>Migration behaviour</b> acc. to EN 71-3	limit values for heavy metals in mg/kg	requirements are fulfilled

Decor finish foils that have been tested by the independent and accredited test laboratory of the Institut für Holztechnologie Dresden gemeinnützige GmbH (IHD)

**Entwicklungs- und Prüflabor Holztechnologie GmbH**

Zellescher Weg 24  
01217 Dresden  
Germany  
[www.eph-dresden.de](http://www.eph-dresden.de)



in accordance with the provisions of this Quality-Guideline can be awarded a special test certificate and labelled with the quality seal as shown.



After having tested their own products by themselves in accordance with the IHD-Quality-Guideline for decor finish foils, the members of the work group label them with the jointly used and protected mark.



The IHD-Quality-Guideline and drafted test standards (in the form of IHD-Works Standards) are available free of charge as pdf-files on the Internet at

[www.Dekorfinishfolien.de](http://www.Dekorfinishfolien.de) (in German)

or

[www.decorfinishfoils.com](http://www.decorfinishfoils.com) (in English).

The following members of the work group “decor finish foils” at the IHD have joined in drafting this IHD-Quality-Guideline:

<p><b>DECOR DRUCK LEIPZIG GmbH</b> Sommerfelder Straße 77 04316 Leipzig <a href="http://www.decordruck.de">www.decordruck.de</a></p>	
<p><b>INTERPRINT GmbH</b> Westring 22 59759 Arnsberg <a href="http://www.interprint.com">www.interprint.com</a></p>	
<p><b>Impress Surface GmbH</b> Dorfstrasse 2 63741 Aschaffenburg <a href="http://www.impress.biz">www.impress.biz</a></p>	
<p><b>LIKORA GMBH</b> Siemensstrasse 2 32805 Horn-Bad Meinberg <a href="http://www.likora.de">www.likora.de</a></p>	
<p><b>Möbelfolien GmbH Biesenthal</b> Bahnhofstraße 150 16359 Biesenthal <a href="http://www.moebie.de">www.moebie.de</a></p>	
<p><b>Schattdecor AG</b> Walter-Schatt-Allee 1-3 83101 Thansau <a href="http://www.schattdecor.de">www.schattdecor.de</a></p>	
<p><b>SURTECO GmbH</b> Am Brühl 6 86647 Buttenwiesen <a href="http://www.surteco.com">www.surteco.com</a></p>	
<p><b>Institut für Holztechnologie gemeinnützige GmbH</b> Zellescher Weg 24 01217 Dresden <a href="http://www.ihd-dresden.de">www.ihd-dresden.de</a></p>	