



**Eggers Industries**

# GOOD BETTER BEST

## CLARIFYING THE CONFUSING

When choosing a face material for products going into a high-traffic and/or high-maintenance facility there are several factors to consider. Will the face material withstand the demands of the environment? What will they look like? Are there environmental benefits available?

### GOOD

#### LOW PRESSURE DECORATIVE LAMINATE

- Low Pressure Decorative Laminate (LPDL) is made from Melamine paper that is saturated and compressed under low pressure and then bonded to particleboard or MDF.
- Some LPDL doors are built without hardwood stiles and rails and are simply Melamine bonded to core. They may also have wood dowels placed in the hinge pockets for reinforcement.
- Not recognized by AWI 8th Edition, Section 1300.
- Wear Resistance equals 400–500 cycles.
- Thickness equals .005"–.007"

### BETTER

#### HIGH PRESSURE DECORATIVE LAMINATE

- High Pressure Decorative Laminate (HPDL) is constructed with multiple plies of phenolic resin-coated kraft papers covered with a high-grade decorative paper layer that is compressed under high pressure and heat for an extended period of time and finished with a melamine coating.
- Metal protective hardware is often needed to match the durability of a vinyl-clad door.
- Lead times can vary greatly due to the numerous suppliers.
- FSC® certified or FSC controlled HPDL is now required on FSC certified projects.
- Wear Resistance equals 700–1,000 cycles.
- Thickness equals .048"

### BEST

#### VINYL-CLAD

- Vinyl-Clad doors are made with IPC® Rigid Sheet face material and are built to withstand the most demanding environments.
- Non-PVC, G2 BioBlend® face options are also available which meet the rigorous standards and criteria for chemical emissions prescribed by the GreenGuard Environmental Institute.
- Removable or fixed edge construction.
- Removable rounded edge design minimizes damage, is also available in stainless steel and can be replaced anytime, anywhere and by anyone.
- Scratch and stain resistant and does not support fungal or bacterial growth.
- Available in over 90 solid colors and 22 wood grain patterns.
- Wear Resistance equals 6,000 cycles.
- Thickness: .040" for the Palladium® Door® with Inpro's IPC® Rigid Sheet material





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### **GOOD**

LOW PRESSURE  
DECORATIVE  
LAMINATE



### **BETTER**

HIGH PRESSURE  
DECORATIVE  
LAMINATE



### **BEST**

VINYL-CLAD  
REMOVABLE  
EDGE



### **BENCHMARK**

WOOD VENEER

## **WDMA TM 15-11**

### **VERTICAL EDGE IMPACT TEST**

These constructions have been tested according to the WDMA TM 15-11 Vertical Edge Impact Test. A test method developed for determining the vertical edge impact resistance of backing for veneered wood door stiles. Although this test method was not designed specifically for edge impact resistance, it serves as an excellent method for comparing these three materials.

It gives us the ability to deliver a repeatable impact to the corner of a small sample of material. The results of this test provide a means to predict the relative ability of different materials to resist impact type damage in real-life applications.

### **DATA—REMOVABLE EDGE:**

**NR and 20-minute**

Screw Withdrawal . . . . . 1,135 lbs.

Hinge-load . . . . . 1,037 lbs.

**45-60-minute**

Screw Withdrawal . . . . . 863 lbs.

Hinge-load . . . . . 813 lbs.

*Both have passed a Cycle Slam of 1,000,000 cycles*

### **WDMA Test Methods Used:**

Hinge-Loading . . . . . (TM 8-90, 1990)

Screwholding . . . . . (TM 10-90, 1990)

*WDMA Extra Heavy Duty performance requires screwholding and hinge-loading of 550 lbs.*



**Eggers Industries**

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**Flush Doors,  
Palladium® Doors**

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