

ABSTRACT

TITLE: METHOD OF COATING MELAMINE RESIN ON LAMINATING PAPER

Decorative paper with a wear resistant decorative is made by limiting the flow of melamine resin through the decorative paper. A partially cured melamine resin impregnated overlay is placed over non impregnated decorative paper and cured at temperatures of about 230-310°F (110-155°C) and pressures of greater than about 300 psi (20 bar) and preferably about 750-1500 psi (51-102 bar) for causing melamine resin to flow from the overlay into the decorative paper and for substantially fully curing the melamine resin. Flow of the melamine resin is limited to about 10-20 and preferably about 12-17 percent by weight of the impregnated overlay. Flow of melamine resin in impregnated decorative paper is limited to about 1-3 and preferably about 1-2 percent by weight of the impregnated decorative paper.