



Koehler
PAPER

DECOR PAPER

— PERFORMING EFFICIENCY —



DECOR PAPER

— PERFORMING EFFICIENCY —

Our Quality Promise

Our decor paper is walked all over every day — and loves it.

Experience outstanding surface quality, high product availability and our first-class service for yourself.



Contents

Koehler Paper	4
Koehler Decor Paper	5
What is Decor Paper?	6
Our Range:	
Print Base Paper	8
Unicolor Paper	10
Finish Foil Base Paper	12
Edge Banding Base Paper	14
Further Processing	16
Sustainability at Koehler	18



Koehler Decor Paper

Koehler spruces up your products with premium decor paper.

Koehler Paper

Koehler Paper is part of the Koehler Group, a company with a history spanning more than 215 years and now in its 8th generation. With around 2500 employees worldwide, we produce more than 500,000 tons of specialty papers and cardboards for the global market at five sites in Germany and three further sites in the USA. Along with the core business of paper manufacturing, the Koehler Group has established another key business area in Koehler Renewable Energy, which plans and operates renewable energy generation plants. With a turnover of around 1.3 billion euros, Koehler Group is one of the few independent German family-owned companies in the paper industry.



Koehler Decor Paper

Decor paper from Koehler is used in many areas of modern interior design. Whether used for laminate flooring, stylish kitchen worktops, attractive furniture and kitchen fronts, or weather resistant outdoor applications, our paper provides the perfect base for high-quality end products. Especially for the decorative coating of wood-based materials, these special papers are impregnated and pressed with thermosetting resins either in printed form or uni-colored. Our product portfolio includes LPL, HPL and finish foil base paper in uni-color or print base paper quality, as well as edge banding base paper which completes the range of high-quality products from Koehler Decor Paper. We use the latest technology to produce a wide range of colors, weights and individually optimized application properties for perfect surfaces.

Service Is Our Top Priority

We supply companies in the furniture industry such as printers, impregnators and manufacturers of wood-based panels. Offering a first-class service is our top priority. Our sales team from Koehler Decor Paper keeps close personal contact with our customers. Our Technical Customer Service team also provides expert advice for the selection and optimal processing of our decor paper.

What Is Decor Paper?

Koehler Decor Paper is absorbingly impressive.

The outstanding absorbency for impregnation guarantees optimal further processing at all times.

Decor paper is a specialty paper used to create quality finishes on wooden substrates. This unicolor paper is either used as it is or printed with a range of designs. It is used for furniture and kitchen surfaces as well as laminate flooring.

Koehler Decor Paper is made using high-quality pulp from sustainable forestry and controlled sources. Its excellent properties including outstanding absorbency, make it ideal for impregnation and further processing. We also provide filler materials for our decor paper if they are to be used to cover dark backing materials such as particle board or core paper. These white and colored pigments are extremely light-resistant and also resilient to chemicals.

Decor paper is made in a wide range of colors and weights. The surface can be satin-finished or machine-glazed. Other outstanding properties are the high porosity, wet strength, lightfastness and color consistency.



Stone or not stone – that is the question. Our sophisticated decor paper can be used to create remarkably realistic surfaces.





- » Easy to print on
- » Dimensional stability
- » High color consistency
- » Ideal for impregnation
- » Wide range of colors and weights
- » Suitable for synchronous pore applications



Print Base Paper

Print base paper has a satin finish and is ideally suited for printing and impregnation; it also boasts outstanding dimensional stability and a high level of color consistency. Our extensive selection of print base paper is available in a wide range of colors and weights for LPL and HPL applications.

LPL stands for “Low Pressure Laminate” and means that the impregnated decor paper is applied to the wooden substrates with low pressure. HPL or “High Pressure Laminate” is made by pressing together multiple layers under high pressure.

Print base paper in a wide range of colors, including white, cream, beige, brown, gray and black is further processed by the rotogravure printing specialists and used to produce laminate flooring, kitchen worktops, furniture and kitchen fronts, as well as other interior applications. Print base paper from Koehler is available in standard weights from 50 to 140 g/m².



Unicolor Paper

Unicolor decor paper from Koehler boasts outstanding penetration and impregnation properties and therefore meets the requirements of high-speed impregnation machines. Unicolor paper is single-colored, dyed decor paper for LPL and HPL applications. They are machine-glazed or have a light satin finish.

We make paper in a wide range of shades of white, cream, beige, brown, gray and black. Unicolor paper is used in furniture, kitchen, and office production, but also for laminated boards for the DIY sector. It is also used in interior construction. We make unicolor paper in a range of standard weights from 50 to 140 g/m².

- » Outstanding penetration properties
- » Ideal for impregnation
- » Wide range of colors and weights
- » Good running properties

Finish Foil Base Paper

These so-called “post-impregnates” are suitable for a wide range of applications, whether single-colored or with a printed finish. Base paper for foil production is manufactured with a satin finish, usually painted and laid onto chipboard or MDF board using dispersion adhesives.

Post-impregnates are better suited for printing and higher quality than the familiar pre-impregnates, meaning they offer big benefits to processors. Our finish foil base paper is particularly characterized by a homogeneous surface.

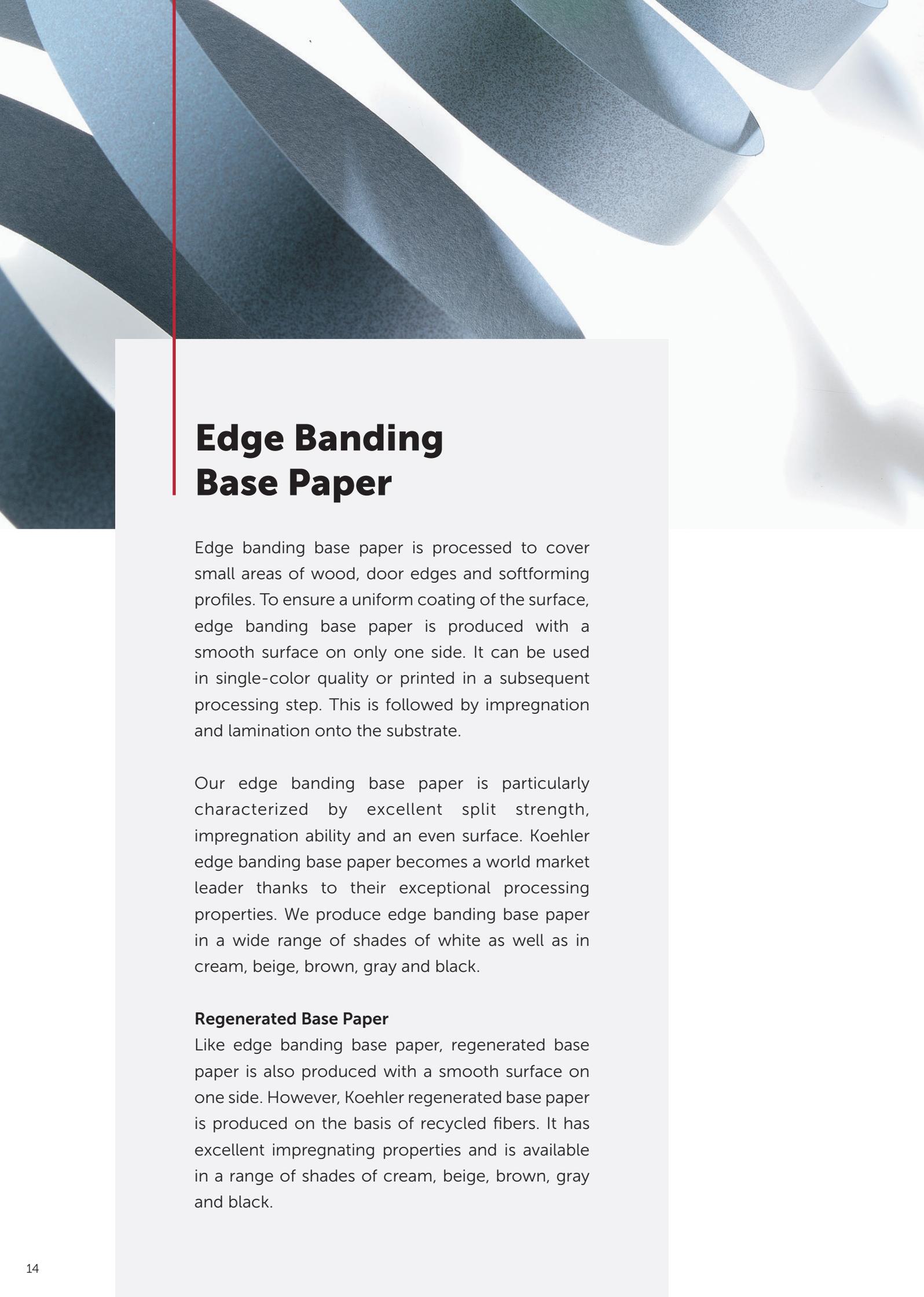
Available in a wide range of shades of white, cream, beige, brown, gray and black, this paper is increasingly used in the caravan sector, but also processed into living room, bedroom and youth furniture. Base paper for foil production is also used for foil covered profiles, doors, frames, or skirting boards. We offer base paper for foil production in a range of standard weights from 50 to 140 g/m².



- » Homogeneous surface
- » High split strength in the end product
- » Excellent impregnability
- » Easy to print on
- » Ideally suited for further processing
- » Outstanding running properties



You can count on us — after all, every gram counts in a motor home. Koehler decor paper can help you achieve maximum comfort while keeping weight to a minimum.



Edge Banding Base Paper

Edge banding base paper is processed to cover small areas of wood, door edges and softforming profiles. To ensure a uniform coating of the surface, edge banding base paper is produced with a smooth surface on only one side. It can be used in single-color quality or printed in a subsequent processing step. This is followed by impregnation and lamination onto the substrate.

Our edge banding base paper is particularly characterized by excellent split strength, impregnation ability and an even surface. Koehler edge banding base paper becomes a world market leader thanks to their exceptional processing properties. We produce edge banding base paper in a wide range of shades of white as well as in cream, beige, brown, gray and black.

Regenerated Base Paper

Like edge banding base paper, regenerated base paper is also produced with a smooth surface on one side. However, Koehler regenerated base paper is produced on the basis of recycled fibers. It has excellent impregnating properties and is available in a range of shades of cream, beige, brown, gray and black.



- » Even surface
- » Outstanding split strength in the end product
- » Ideal for impregnation
- » Very high volume



Further Processing

Creating high emotions for rotogravure printing.

We see decor paper as a highly emotional product, which always impresses with its consistent product quality over a wide range of production periods.

Printing Process

Decor paper is mainly printed using the rotogravure printing. In this process, ink is applied to the paper by an engraved printing cylinder. Koehler decor paper can also be used in a digital printing process. The interplay between the paper color and various printing inks means the decorative design options are almost unlimited. These range from wood and stone patterns all the way to fantasy designs.

Impregnation

In order to apply decor paper to wooden materials, the paper is soaked in melamine, urea, or acrylate resin, depending on the application. Because this paper is highly absorbent and penetrable, it is able to soak up so much resin that a closed surface is created to a high quality standard.

Our decor paper is highly resistant to moisture, which allows it to pass smoothly through the impregnation line.



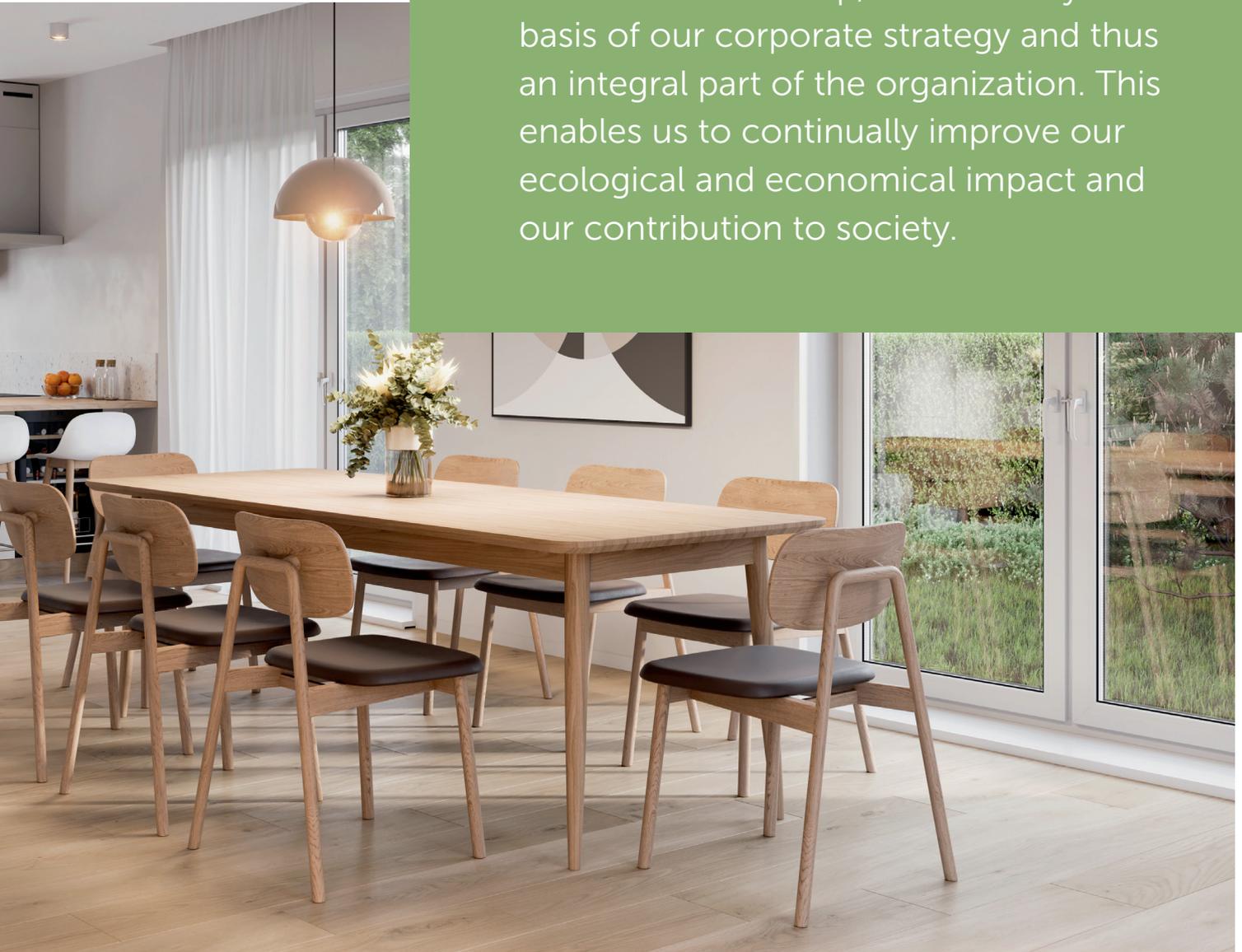
Coating Process

Decor paper is joined to wooden boards using the latest pressing and laminating systems. The high temperatures and the corresponding pressure in the presses cause the thermosetting resin to harden. In this process, the decor paper is pressed onto the wood-based material using structured press plates or other textured templates with an almost natural surface appearance. In the lamination process, this is done by using hot melt adhesives or ureabased/PVAc glues.

Sustainability

Progress through Sustainability

In the Koehler Group, sustainability is the basis of our corporate strategy and thus an integral part of the organization. This enables us to continually improve our ecological and economical impact and our contribution to society.



Sustainability Is Not a Trend but a Necessity

The environmentally sustainable and resource-efficient production of products is part of our corporate philosophy. We see environmental protection as equally important to other corporate goals. Furthermore, the Koehler Group believes it has a responsibility to make its contribution to achieving the UN Sustainable Development Goals (SDGs). We are fundamentally guided by these 17 UN goals and use them to identify certain priorities to help shape our vision and our behavior in a responsible way toward a sustainable future.



Successful, Future-Proof Products

- » One of our key goals is to develop bio-based, recyclable and/or biodegradable papers.
- » This means that, as well as improving our own performance, we can also provide our customers with powerful leverage for achieving their sustainability goals, too.



Renewable Raw Materials and Responsible Sources

- » As a company with global reach, we can help to drive sustainable development together with all actors along the value chain.
- » Our suppliers share our high standards in terms of ecological, social and ethical principles.
- » We are also continually improving transparency in our supply chains.



Resource Efficiency

- » Material, energy and resource efficiency are subject to continual improvement.
- » In addition, production waste is always a potential source of secondary materials, which we aim to recycle.
- » This helps us to facilitate circular rather than linear value creation.



Visionary Approach to Climate Protection

- » We have set ourselves the goal of generating more energy from our own renewable sources by 2030 than is required for our paper production operations.
- » We are driving the expansion of renewable energy production while also reducing our greenhouse gas emissions through energy efficiency.
- » In doing so, we are making a positive contribution toward climate protection and security of supply in the long term.



People as the Key to Success

- » The people who work for us are the key to our success.
- » The health and safety of our employees are top priorities for us.
- » We also invest in training and development programs and actively promote diversity.

Koehler Decor Paper — Adding a Coat of Success for a Bright Future

Interested?

Koehler Paper SE

Hauptstraße 2 · 77704 Oberkirch, Germany

Phone +49 7802 81-0

Fax +49 7802 81-4330

www.koehlerpaper.com

DECOR PAPER

— PERFORMING EFFICIENCY —