ARTISTIC FINISHES

v. 2 7.20

Enduracor™ Digital Print Technical Specifications

Enduracor™ takes on an improved look with our new digital print technology with our same great waterproof core. This exciting new technology gets even closer to an exact match of the floor, while still allowing us to produce orders with no minimum quantities. We can do all this with industry leading lead times which means no inventory and no waste.

The Print Process - Traditional Gravure vs. Digital Inkjet Printing

Flooring historically has been printed using a Gravure process. At our facility we use a digital print process, which can have different effects when compared side by side to the flooring, so what are the biggest differences in how flooring vs. moldings are printed?

Process	Gravure Printing (Flooring)	Digital Inkjet Printing (Moldings)
Print	Steel cylinders used to engrave onto flat paper	Inkjet heads used to spray onto contoured parts
Inks	5 or more inks that can be specifically mixed to the floor color	CMYK – Cyan, Magenta, Yellow and Black dots overlap to build the wood grain image
Run Sizes	Very large runs	Very small runs (1 piece if needed)

Disclaimer: *Because the printing process is different than the flooring print process, it is important to know that in certain cases it can lead to perceived variances in the color under different light sources. This is called* ***metamerism****. Metamerism can often be described when two material samples produced under different types of printing match when viewed under one light source but not under another. We recommend that you use warm home lighting (Halogen Lamp A, 2700K) to view our moldings next to the floor. We can get our colors very close to the actual floor, but we cannot produce an exact color match in all lighting sources.*

Third Party Testing

Our Digital Print Technologies have been thoroughly tested for long term success in any flooring application.

Under the **ASTM G155 UV/Light Ray Test** format, we tested for sunlight exposure effects over a five-year total time and clear coat degradation. We compared side by side our samples to four leading flooring manufacturers samples.
We found:

- No to minimal color change measured
- No delamination or indication of any surface clear coat degradation
- Rating: Passed with Excellent performance rating
- Completed: 12/2019

Under the **ASTM D2584 Delamination Test** format, we tested our 340 stairnose profile for delamination under extreme water emersion to heat cycles. The samples were put into a pressure vessel with water and a vacuum of 84.4 kPa was maintained for 30 minutes. Then immediate additional pressures of 75 PSI was applied for an additional 30 mins. Once completed samples were removed and placed in a 170-degree oven for 4 hours. This process went on for 3 cycles.
We found:

- No signs of delamination between the core and the wrap
- Rating: Passed with Excellent performance rating
- Completed: 12/2018

Under the **ASTM D4060-19 Taber Test format**, we tested four (4) samples at 1,000 cycles with a 1,000 gram weight.
We found:

- Samples had an average weight loss of 14.25% or 70 milligrams.
- Rating: Strong wear index
- Completed: 6/2020