Abet Digital Guidelines

ABET LAMINATI®

How Does Abet Digital Work?

1

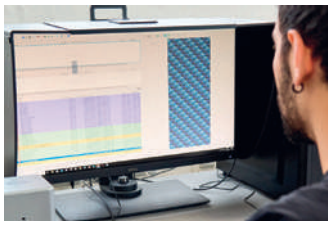
Creating the graphic file

Design the image file using the provided template and following the specifications outlined in this manual.

2

Sending the file via Abet Digital Upload

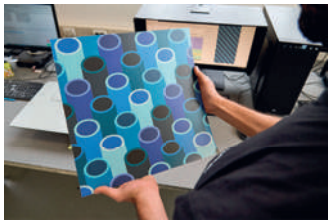
Access the Abet Laminati website, click on Abet Digital Upload, fill in the form, and use the personal link received via email to upload your files.



3

Preliminary analysis

The technical team checks the files and confirms their compliance.



4

Prototype sample

A 40x40 cm full-scale sample is produced to assess colour rendering, finish, and all required characteristics (lead time: approximately 2 weeks).

5

Validation

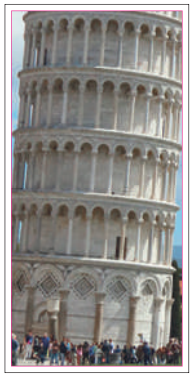
Customer approval of the sample.

6

Production

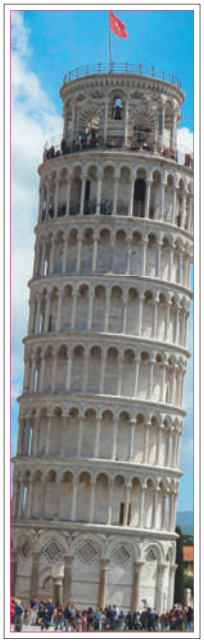
Printing of decorative sheets, lamination, and final inspection of the panels.

Sizes



2440x1220 mm
Print Area
2420x1190 mm

3050x1300 mm
Print Area
3000x1280 mm



4200x1300 mm
Print Area
4150x1280 mm

4200x1610 mm
Print Area
4150x1580 mm

4200x1860 mm
Print Area
4150x1840 mm

Available sizes

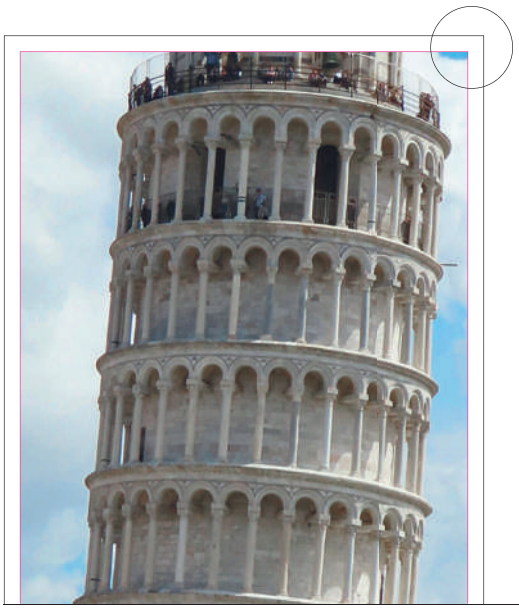
Size	Dimensions (mm)	Print Area (mm)
24	2440x1220	2420x1190
30	3050x1300	3000x1280
42	4200x1300	4150x1280
46	4200x1610	4150x1580
48	4200x1860	4150x1840

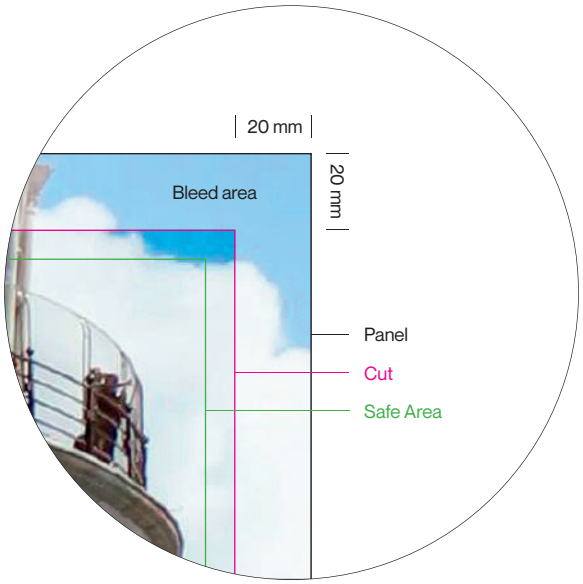
For more details

Refer to the technical specifications on page 17 or contact your local Abet Laminati representative.

Thicknesses

Bleed and safe area





Bleed area
Each side of the panel must include a 20 mm bleed. This is a printed area that is trimmed to achieve the final format and is therefore excluded from quality control, as it is not usable. Its purpose is to ensure correct alignment during cutting, sectioning, and assembly of panels that form a single final image.

Why use a bleed area?
During lamination, the printed image may vary in size by up to ±0.15% in length and ±0.4% in width compared to the sides of the supplied print file.

Safe Area
To ensure readability and integrity of graphic elements, it is recommended to maintain an internal margin of at least 4 mm from the cutting edges (printable area). Texts, logos, and important content should be placed within this “safe area” to avoid the risk of being partially trimmed during processing.

	Keep texts and logos at least 4 mm from the cutting edge.
	Use fonts ≥ 6 pt; embed fonts or convert them to outlines.
	Use pure black (K 100%), avoiding composite blacks in CMYK.
	Avoid lines thinner than 0.125 pt and edge-aligned frames, which may appear faint or uneven after cutting.
	Include 20 mm bleed on each side.

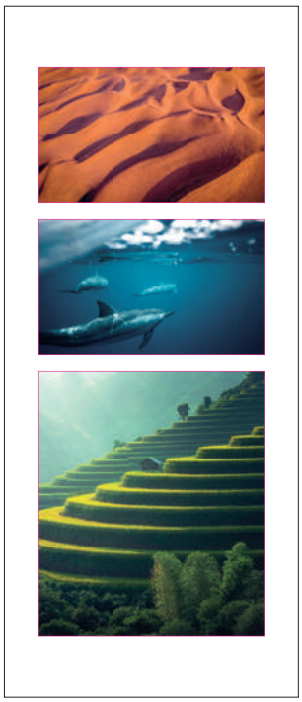
Note

The actual printable area is slightly smaller than the nominal panel dimensions due to required margins for processing and cutting. This should be considered when designing graphics that require precise edge alignment. Correct dimensions are listed in the table on page 4.

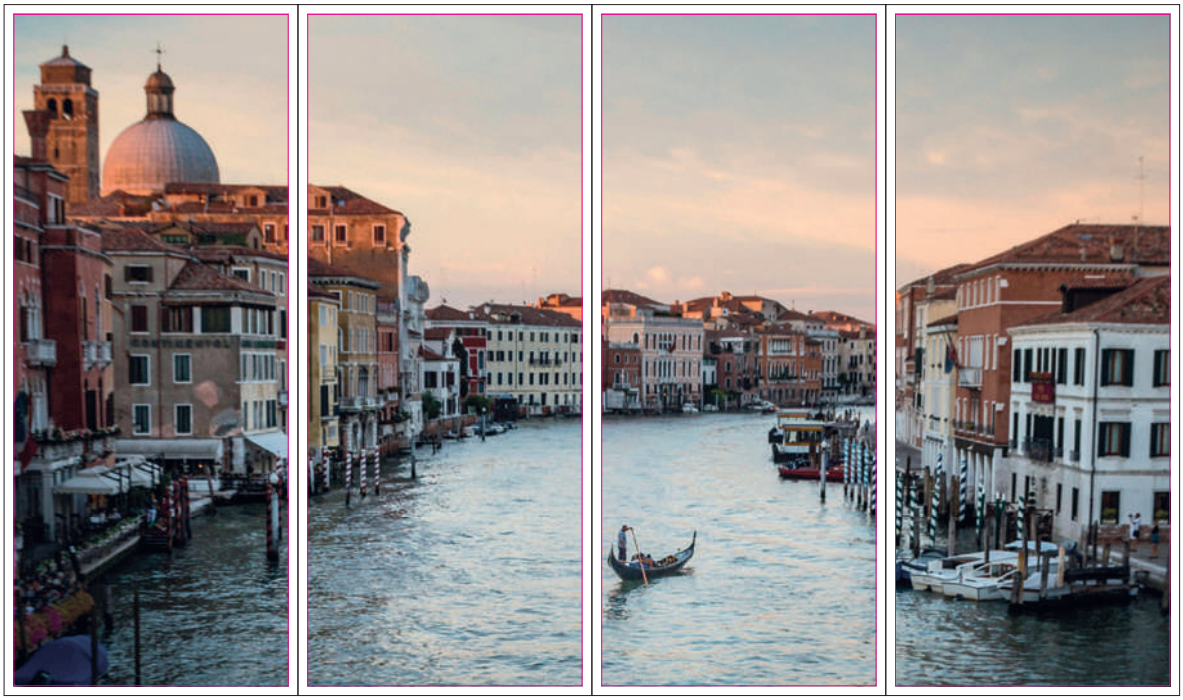
Layout

Single image
Full Panel

Single image
Positioned within a panel



Multi-image
Multiple images on one panel



Multi-panel image
One image split across multiple panels

Single image

Includes a 20 mm bleed area

Cutting area

Multi-image

Multi-image panels allow optimal use of panel format by placing multiple graphic files. When the project does not require a full panel (e.g., for tables or furniture), image files can be prepared in their final usage dimensions, always including the necessary 20 mm bleed for cutting.

To create a multi-image panel, files must be adapted to the overall panel format, leaving a minimum margin of 10 mm between images. Each file must be clearly identifiable, with its name placed in the bleed area.

Includes a 20 mm bleed area

Overlap area: 20 mm

Cutting area

Project Name

To simplify file management, please add the project name at the top of each layout.

Multi-panel image

Panel 1 Panel 2 Panel 3

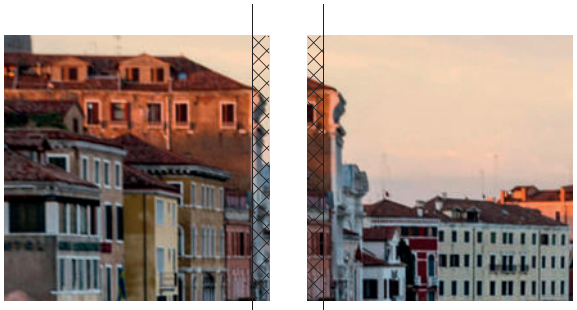
Thanks to its expertise and file processing based on customer preferences, Abet Laminati can manage the division of images intended for large panel installations. This allows complementary images to be printed across multiple panels, each provided with crop marks and precise reference indicators. These elements facilitate processing, correct alignment, and final assembly of HPL panels, ensuring visual continuity and precision in graphic reproduction on large surfaces.

This service also ensures compatibility with panel technical specifications and minimises assembly errors, optimising production time and quality.

Multi-panel image

Panel 1

Panel 2

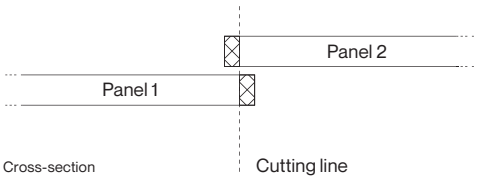


Final result

Includes a 20 mm bleed area

Overlap area: 20 mm

Cutting area

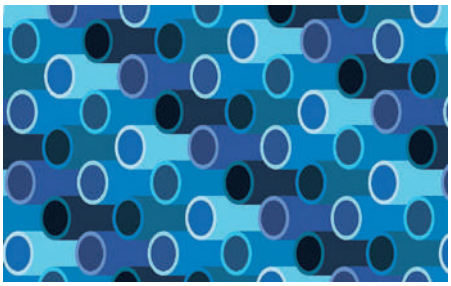


Facade example

Osiedle Polonica, residential complex in Gdańsk, Poland

Graphic file preparation

Accepted formats



Photos – Pixel-based	Illustrations – Vector-based	Compositions
.tif .eps .psd .jpeg	.pdf .eps .ai	.pdf

Unaccepted formats:
.dwg, .gif, .bmp, .doc, .ppt, .dmg, .raw, .png

Bitmap images (pixel data)
Digital photographic images are composed of pixels and are generally created in RGB colour space, suitable for screen display. Our professional printing systems operate in CMYK, the standard for print production

We therefore recommend **converting files to CMYK** before submission. If in doubt, our technical team is available to support you in preparing the files optimally to achieve the best possible print result.

- For TIFF files, use LZW compression. PSD or TIFF files must not contain hidden layers or adjustment layers (merge all layers into one before sending).
- Use the **FOGRA 39 colour profile**. The optimal resolution for bitmap images is **300 dpi**; the minimum accepted is 150 dpi at 1:1 scale.
- Do not artificially increase resolution or apply excessive sharpening masks.

Vector images (vector data)
Vector graphics are not composed of pixels and can be scaled without loss of quality.

- Use the **FOGRA 39 colour profile**.
- Create files at **1:1** (or 1:10) scale in the final print dimensions.
- Keep files compact (low file size and reduced number of objects/anchor points).
- Embedded images must be converted to the same colour profile as the vector file.
- Save files in PDF or AI format.
- Do not use transparency.

Image usage rights
The customer is responsible for the files and, if requested, must be able to prove they have acquired the rights to use the provided images.

Image resolution

The **optimal resolution** for bitmap images is **300 dpi**; the minimum accepted is 150 dpi at 1:1 scale.

Below these values, the quality is insufficient to guarantee a satisfactory result.

Non-compliant
Image resolution
< 150 dpi at 1:1 scale

Ideal
Image resolution
300 dpi at 1:1 scale

Colourimetry

Abet Laminati takes the utmost care to respect colour references. However, due to the technical constraints of digital printing (inks, substrates, lamination processes) and the use of the CMYK colour model, a perfect match with the colour target cannot be guaranteed. The CMYK reproducible gamut is limited: some colours, especially highly saturated or fluorescent ones, may not be achievable.

Moreover, colour perception may vary depending on the panel finish (glossy, matte, embossed, etc.). This aspect should also be considered during the design phase.

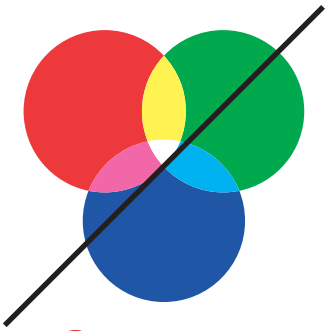
Accepted colour targets (to be provided before the sample phase):

- Pantone, NCS, RAL references;
- Printed sample (e.g. sticker, PVC, etc.);
- Inkjet print on matte paper.

If needed, reference samples can be sent to Abet Laminati, clearly indicating the project name.

CMYK

RGB



Non-compliant

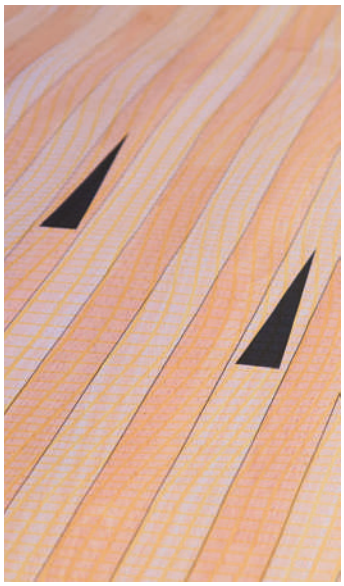
Glow Effect

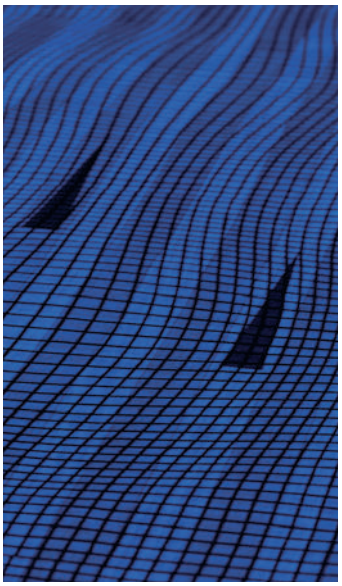
The Glow effect enriches the project with a transparent ink visible only under UV light. It is ideal for introducing hidden details, surprising visual effects, or additional layers of visual interpretation.

How to prepare the file
Create a dedicated layer above the Artwork layer and name it “UV”.

Assign all shapes and texts the spot colour “UV” with value (C=0, M=0, Y=100, K=0)

Set all paths in the “UV” layer to overprint.





Cutting paths

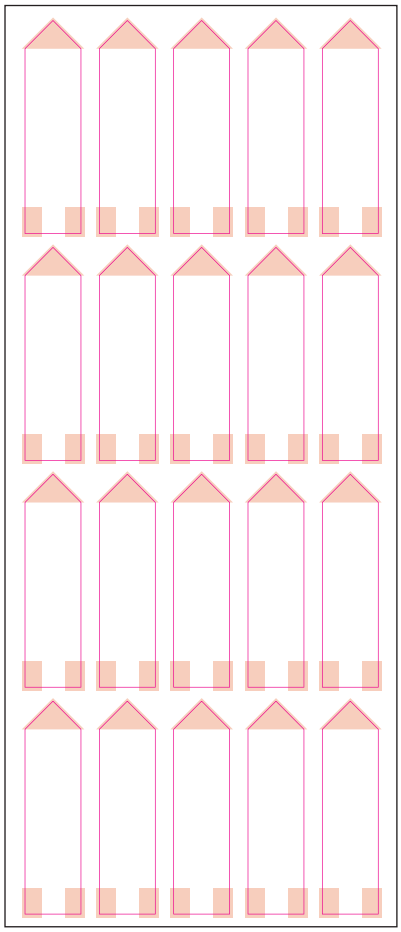
To correctly produce the panels, cutting paths must also be provided. These define the shapes to be cut (e.g. road signs or shaped elements)

Paths must be placed in a separate layer named “Cut”, above the “Artwork” layer. Apply the spot colour “Cut” (0, 100, 0, 0) to all paths and enable the overprint option.

Geometric drawings

In the digital printing and production process, orthogonality and linearity of geometric drawings may vary up to 2.5 mm per linear metre in both directions. This is an intrinsic characteristic of the product: slight expansion or contraction of the substrate during lamination may cause a square to appear visually narrower or wider, or long lines to not be perfectly straight.

Such variations do not compromise the overall aesthetic quality and fall within the tolerances expected for high-pressure decorative laminates.



Example of panel
with paths (e.g. CAI arrow signs)

Sample

The sample is a laminate panel produced using a portion of the graphic file at a 1:1 scale, created prior to the final order.

It serves as a preview of the final result of the printing and lamination in the requested finish and is a key step to ensure the correct quality of the project and its approval by the client.

The sample is available free of charge in a 40×40 cm format, produced at 1:1 scale from the final validated files.

Standard production time is up to 2 weeks from file validation. The sample remains valid for 3 years. Abet retains a copy of each validated sample.

Final use: an essential requirement

It is essential that the customer clearly specifies the final use of the project (e.g. indoor or outdoor, vertical or horizontal, etc.). This information is necessary to correctly produce the sample, as it affects the choice of materials, finishes, and the visual outcome of the product.

Note

Due to the characteristics of digital printing and the lamination process, absolute colour matching cannot always be guaranteed. In case of specific issues, the project manager will inform the customer directly.

Finishes

Digital printing allows free choice among various finishes, from matte to gloss, smooth to textured.

Gloss finish is particularly suitable for applications requiring maximum colour fidelity, as it ensures better colour rendering and more accurate definition of gradients.

Standard

fin.
Sei

fin.
Lucida

fin.
Morbida

Other Touch

fin.
Holz

fin.
Nutshell

fin.
Bark

fin.
Climb

fin.
Papier

fin.
Geo

fin.
Millerighe

fin.
Mandarin

fin.
Millerighe 2

Check all available finishes on the website:
abetlaminati.com/finiture

Refer to the production combination reference table for standard finishes/formats.

Interior

High Grade Standard (HGS) High Grade Postforming (HGP) from 0,6 to 1,8 mm					
		Formato/Size			
Fin.	**Cod.**	**24**	**30**	**42**	**46**
Lucida	1	•	•	•	•
Millerighe	5	•	•	•	
Sei	6	•	•	•	•
Morbida	8	•	•	•	•
Grana 2	9	•	•	•	•
Satin	32		•		
Longline	35		•		
Grainwood	45	•	•		
Holz	55		•		
Climb	56	•	•	•	•
Zodia 3	62		•	•	•
Root	82	•	•	•	•
Papier	84	•	•	•	•
Polaris	85		•	•	•
Polaris Co	CO		•	•	
Dharma	90		•	•	
Aquarama	91		•	•	
Ostuni	92		•		•
Geo	94		•	•	•
Sei Due	/	•	•	•	•
66	B	•	•		
Bark	BA		•	•	•
Nutshell	C	•	•	•	•
Mandarin	E	•	•	•	•
Millerighe 2	R	•	•	•	
Zodia	S		•	•	•
Cross	RT	•	•	•	•
Velwood	VW	•	•	•	•
Microline	W	•	•	•	

Compact Grade Standard ≥ 2,00 mm						
		Formato / Size				
Fin.	**Cod.**	**22**	**24**	**30**	**42**	**46**
Lucida	1	•	•	•	•	•
Millerighe	5			•	•	
Sei	6	•	•	•	•	•
Morbida	8	•	•	•	•	•
Grana 2	9		•	•	•	•
Grainwood	45		•	•		
Climb	56		•	•	•	•
Zodia 3	62			•	•	•
Root	82		•	•	•	•
Papier	84	•	•	•	•	•
Polaris	85			•	•	•
Polaris Co	CO			•	•	
Dharma	90			•	•	
Aquarama	91			•	•	
Ostuni	92			•		•
Geo	94			•	•	•
Sei Due	/		•	•	•	•
66	B		•	•		
Bark	BA			•	•	•
Nutshell	C		•	•	•	
Mandarin	E		•	•	•	•
Millerighe 2	R		•	•	•	
Zodia	S			•	•	•
Cross	RT		•	•	•	•
Velwood	VW		•	•	•	•
Microline	W		•	•	•	

Exterior

Material Exterior Grade ≥ 2,00 mm				
		Formato/Size		
Fin.	**Cod.**	**30**	**42**	**46**
Sei	6	•	•	•
Sei Due	/	•	•	•
Climb	56	•	•	•

Always confirm with your local Abet Laminati representative.

Core

Abet Laminati offers various core options to suit every project, from traditional to coloured cores, allowing a high degree of aesthetic and functional customisation.

The sustainable choice is **Re-Abet**, a core made from 100% post-consumer recycled kraft paper, combining technical quality with environmental responsibility.

Full-Colour
Full-Colour is Abet's laminate with a coloured core matching the surface décor, ideal for applications with exposed edges and for ensuring aesthetic consistency. Resistant to impact, scratches, water, and steam, it is hygienic, antistatic, and easy to clean.
Perfect for kitchen tops, tables, doors, partitions, and furniture, it combines the warmth and beauty of natural materials with the practicality of laminate in terms of maintenance and installation.

made with recycled kraft paper

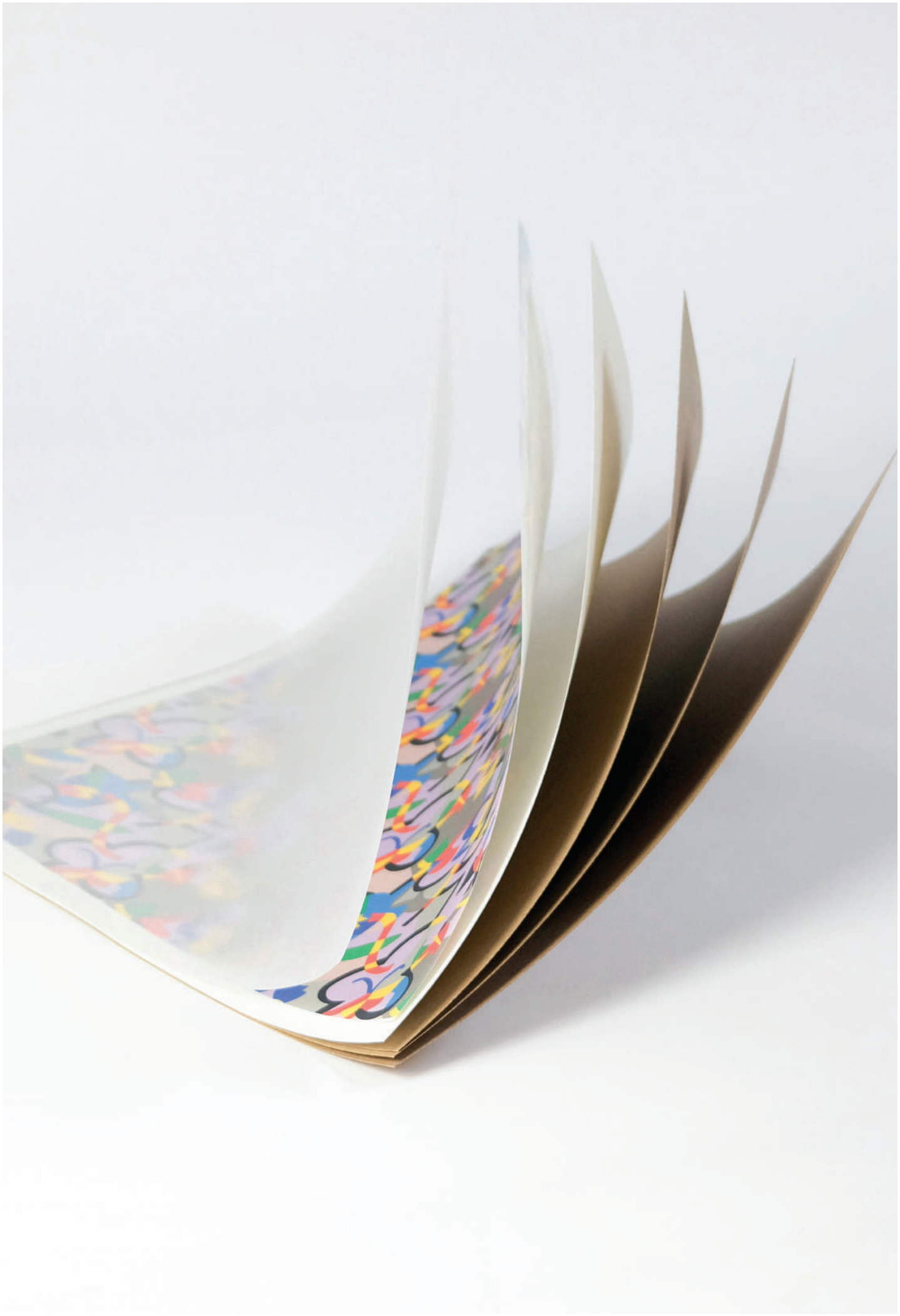
Re–Abet

ABET LAMINATI®

Technical specifications

Products	Sizes(mm)	Thicknesses (mm)	Core
Print HPL	**24** 2440x1220 **30** 3050x1300 **42** 4200x1300 **46** 4200x1610	1 1,2 1,5 1,8	Re-Abet Brown Black Full-Colour*
Stratificato HPL	**24** 2440x1220 **30** 3050x1300 **42** 4200x1300 **46** 4200x1610	2 2,5 3 4 5 6 8 10 12 13 14	Re-Abet Brown Black Full-Colour*
MEG	**30** 3050x1300 **42** 4200x1300 **46** 4200x1610	6 8 10 12	Brown
MEG-H	**30** 3050x1300 **42** 4200x1300	2 3 4 6 8 10 12 14	Re-Abet Brown Black
Magnetico	**30** 3050x1300	1	Brown Black
Diafos	**30** 3050x1300	1,6	Diafos

* For producibility of Full-Colour core variants, please contact our sales team.



Check List

Abet Digital

Customise any
laminate surface.

	Size
1	Export your file at 1:1 or 1:10 scale – Accepted formats: PDF, TIFF, PSD, AI, or EPS.
	Additional information
2	Vector paths must be at least **0.125 pt**. Fonts must be embedded in the PDF or converted to outlines. Minimum font size for guaranteed print legibility is **6 pt**.
	Colour
3	Files must be in **CMYK** (cyan, magenta, yellow, black) with **FOGRA 39** colour profile, or in **greyscale**. Use pure black (K 100%) and avoid composite blacks. Images in RGB or with PANTONE colours will be automatically converted using a standard separation profile.
	Glow effect
4	"Add a layer named "UV" above the "Artwork" layer and assign the spot colour "UV" (0,0,100,0) to all shapes and texts intended for UV Glow printing. All paths in the UV layer must be set to overprint."
	Cutting paths
5	Add a layer named "Cut" above the "Artwork" layer. Assign the **spot colour "Cut"** (0,100,0,0) to all paths and set them to overprint.
	Resolution
6	Optimal resolution for bitmap images is **300 dpi**. Minimum accepted resolution is 150 dpi at 1:1 scale.
	Image Compression
7	Files must be compressed without loss (e.g. TIFF with LZW compression).
	Margins and bleed
8	"Maintain a minimum distance of **4 mm** from the cutting line (printable area) for text and important content. Add **20 mm bleed** on all sides."
	File Upload
9	Go to the Abet Laminati website and click the Abet Digital Upload button in the top bar. Fill in the form and use the **personal link received via email to upload your files**.

YOU'LL FIND IT ON THE
ABET DIGITAL UPLOAD PAGE

**DOWNLOAD
THE TEMPLATE**

IT CONTAINS ALL
THE CORRECT SETTINGS!

Need Help?
If you have any doubts or needs, our technical support team is always available to assist you in file preparation and project management.

Sustainability

Abet Laminati has always operated with full respect for environmental protection and continues to invest in policies aimed at reducing environmental impact throughout the entire product lifecycle.

Choosing an Abet laminate means choosing a durable product, capable of withstanding wear and performing well in any context. Abet laminates maintain their characteristics over time, which is why we believe that producing high-quality, long-lasting products is a key contribution to sustainability. A wide range of products, extensive availability of Made in Italy décors, and high-quality raw materials: this is Abet Laminati's recipe for a timeless product.

FSC® / PEFC
Abet Laminati has obtained both voluntary "Chain of Custody" certifications under FSC® C119591 and PEFC 18-32-19 schemes. FSC® or PEFC certified products are available upon request.

ISO 9001 / ISO 14001
Abet Laminati is certified for Quality and Environmental Management Systems according to UNI EN ISO 9001:2015 and UNI EN ISO 14001:2015 standards.

Environmental Product Declaration
Abet Laminati has published EPDs (Environmental Product Declarations) for Print HPL Thin and Print HPL Compact.

Biosourcé
Product label according to NF EN 16575 standard, defining HPL as containing 66% biomass of biological origin.

Indoor Advantage™ Gold
This certification ensures that building material products support a healthy indoor environment by meeting strict VOC emission limits for indoor air quality (IAQ).

To obtain certification, products must be tested by independent laboratories in accordance with CDPH/EHLB Standard Method 01350 V1-2 for concerning VOC emissions.

For more information,
please refer to the GoGreen brochure
on the Abet Laminati website.

Abet Laminati S.p.A.
società a socio unico

viale Industria 21
12042 Bra (CN)
Italia

+39 0172 419111
info@abetlaminati.com
abetlaminati.com