



ZEG

cohera

**Leather fiber decorative material
for furniture and interior design**

Stock collection cohera Interior,
cohera Pure & cohera Construct



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Disclaimer

The above information is exclusively non-binding. The purchaser/user is not released from his/her obligation to test our materials professionally on his/her own responsibility with regard to their suitability for the intended use under the respective object conditions. No warranty shall be assumed for the application case. Any liability resulting from this information shall be excluded to the extent legally permitted. Changes to the product may result from technical development. The latest edition of this information shall be valid in each individual case. Please note: Print production was performed in compliance with the latest standards; however, minor deviations may still occur depending on the material, surface and light situation. The colors shown in the illustrations in the brochure shall not be considered binding.

Salamander Premium Solutions - who are we?

History

As the worldwide oldest, largest and leading quality manufacturer of unique material experiences made from recycled leather cuts, Salamander has more than 100 years of company history to call upon, combining the tradition of leather craftsmanship with the present-day requirements on design, sustainability and innovation.

Quality

Our solutions are permanently monitored by external and in-house experts in order to consistently ensure our high sustainability and quality standards. We have our own in-house laboratory, a wide range of test equipment and qualified personnel with long-standing experience.

Claim

Salamander Premium Solutions has its roots in the shoe label Salamander, which was the first brand to industrialize shoe production and sell its products vertically integrated in its own stores. Direct customer contact was and still is the reason for the high quality standards on our materials.

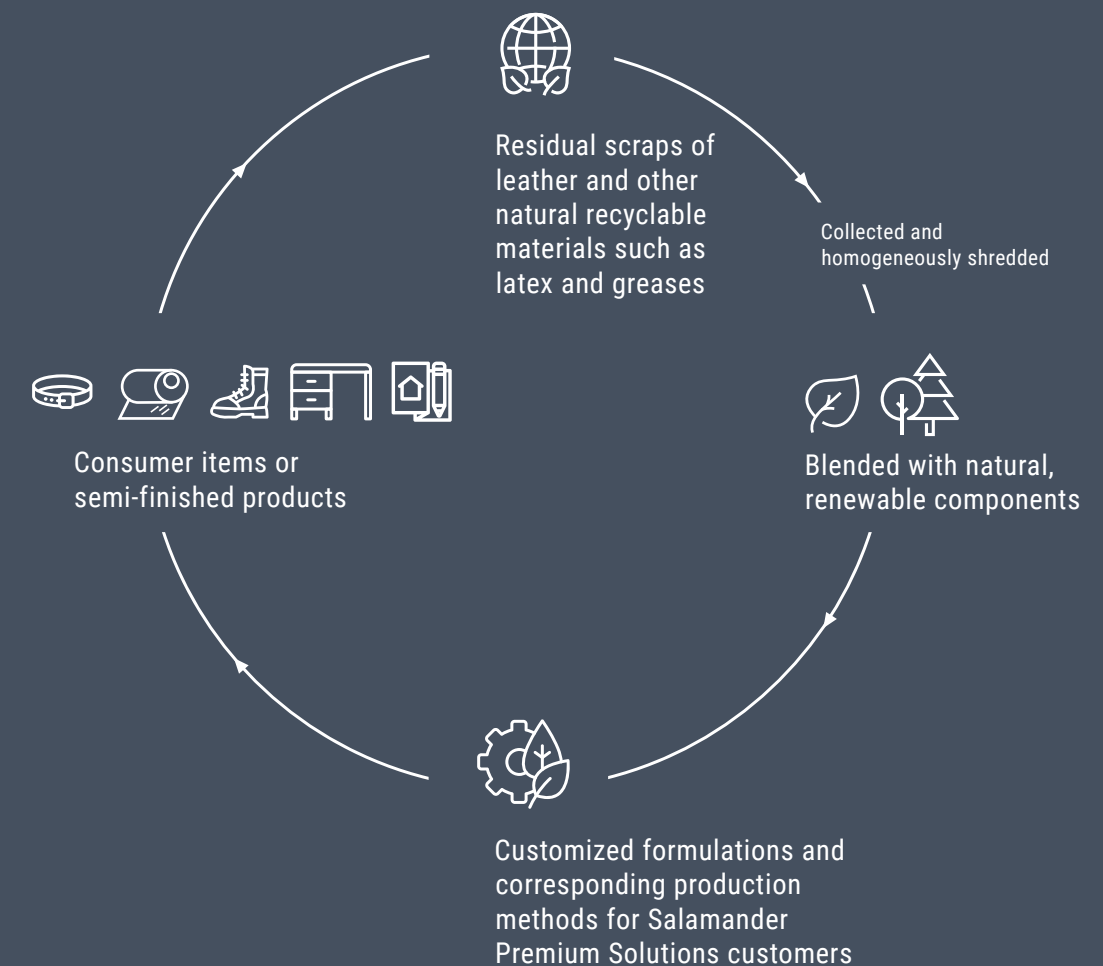
Certifications

All our material solutions are certified to the Oeko-Tex® Leather Standard. Furthermore, we voluntarily undertake to comply with the standards of the Eco-Management and Audit Scheme (EMAS) and guarantee pollutant-free materials.

Emotion

See. Feel. Smell. Our incentive is our wish to use renewable materials to create material experiences that set new standards. We help your product to achieve a unique appearance.

Salamander Recycling Process



THE COMPONENTS

Leather fibers form the basis for cohera. The material consists of approx. 60-75% recycled European real leather.

Natural rubber ensures the required elasticity of cohera and binds the leather fibers.

Natural greases and waxes nurture the leather fibers, keeping them soft and supple.

Color pigments enable the availability of cohera in many different color options.

The **water-based coating** sets quality standards as required by the automotive industry.

Material properties

cohera is a flexible decorative material for furniture, manufactured on the basis of high-quality leather fibers, and can be applied on commercially available base materials as a surface covering for furniture production or as wall paneling.

cohera - the name is made up of CO-ri-um (Latin for leather) and HERA, the Greek goddess of birth, and perfectly describes the (re)birth of leather.

cohera Pure is made of leather fibers and natural latex along with greases and natural tannins. Its natural, leathery soft surface is delivered in an untreated state. The technical data of the material and the surface finish are indicated in the data sheet.

cohera Interior consists of the base material and a robust coating. The surface is ready for use and does not require any additional treatment. Processing by means of sanding, varnishing, oiling, waxing or treatment with care sprays and leather grease etc. is not intended.



cohera Decor materials are certified to the Oeko-Tex® Leather Standard and are REACH compliant.

Care and storage

Care cohera Interior

Soapy water, applied with a soft cloth. The application of an impregnating agent is not recommended.

cohera has a ready-to-use PU surface, therefore oiling, sanding or varnishing is not necessary.

Storage

Storage between 5 and 40°C and a relative humidity of 50-65%.

Humidity and wetness

Too dry storage conditions may cause shrinkage. Too moist storage conditions may lead to an increase of all dimensions.

Unsuitable storage conditions such as those described above may cause unevenness and waves. Mold may occur if the material is stored in very damp conditions or if water penetrates the material. Protect cohera from direct sunlight.

Storage duration

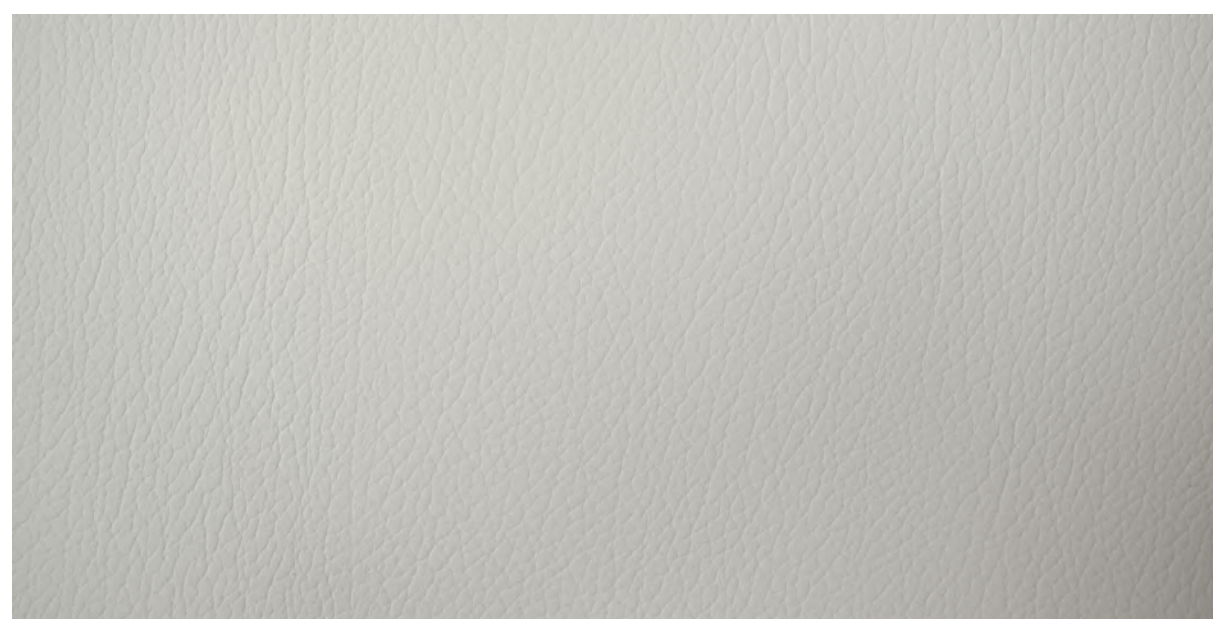
Bound leather achieves the best results when it is stored under the above conditions for up to six months. After six months, the properties may change depending on the storage conditions, so thorough tests should be performed prior to use.



Bison surface

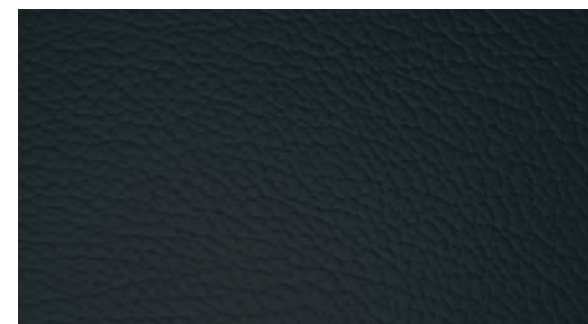
Technical data sheet cohera Interior, embossed, 1.0 mm

Parameter	Standard	Technical data
Composition		Leather content approx. 60% Binding agent natural latex approx. 20 % Pigments and auxiliary materials approx. 5% Finish approx. 15%
Weight		930 g/ m ² +/- 5 %
Size	Roll width/roll length	1.44 m width x 25 m (from 1 m in 0.5 m steps)
Fire protection class		Class 1 - normal flammability
Elongation kink resistance	DIN 53340	> 12,000
Tensile strength longitudinal/transverse	DIN EN ISO 3376	> 13 N/mm ²
Abrasion resistance	DIN EN ISO 11640	> 1,000
Light-fastness	DIN EN ISO 105-B02	Blue scale 4-5
Humidity	DIN EN 20 287	Approx. 10%
Chemical resistance		Sealed surface resistant to brief exposure to diluted alkalis, acids, oils, greases as well as food products such as red wine, mustard, ketchup, etc.
Availability		Ex stock ZEG
Certificates		Oeko-Tex Leather Standard EMAS REACH Quality ISO 9001

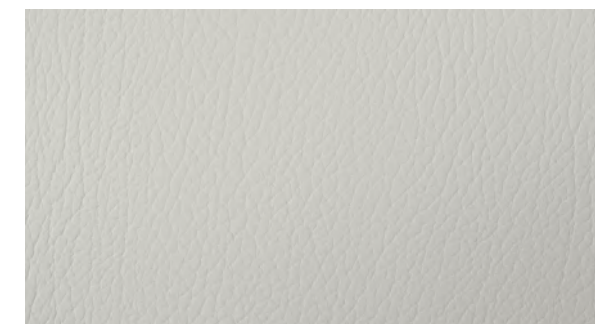


cohera Interior Bison Creme White | P00512031

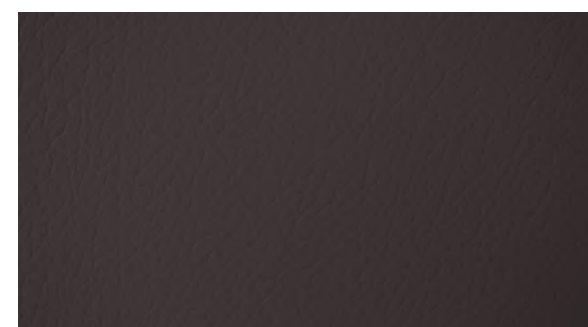
Bison surface



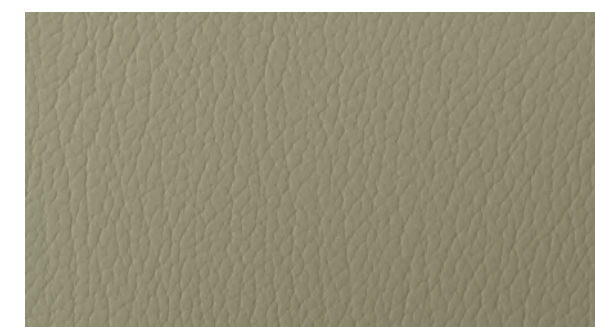
cohera Interior Bison Black | P00512035



cohera Interior Bison Creme White | P00512031



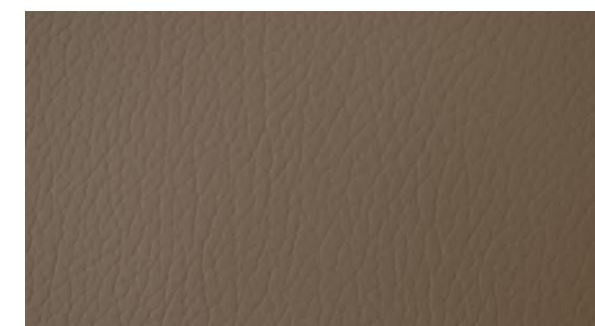
cohera Interior Bison Dark Brown | P00512034



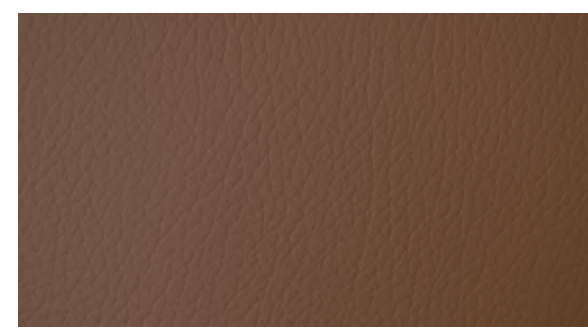
cohera Interior Bison Beige | P00512036



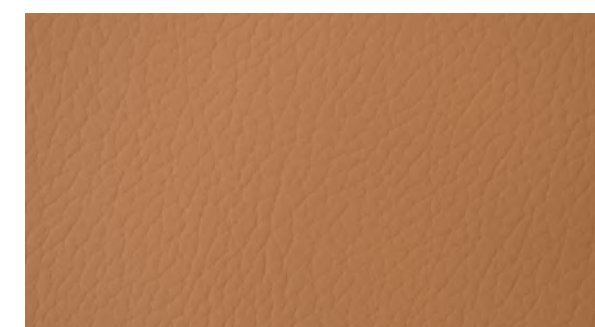
cohera Interior Bison Chocolate Brown | P00512033



cohera Interior Bison Mud | P00512037



cohera Interior Bison Cinnamon | P00512038

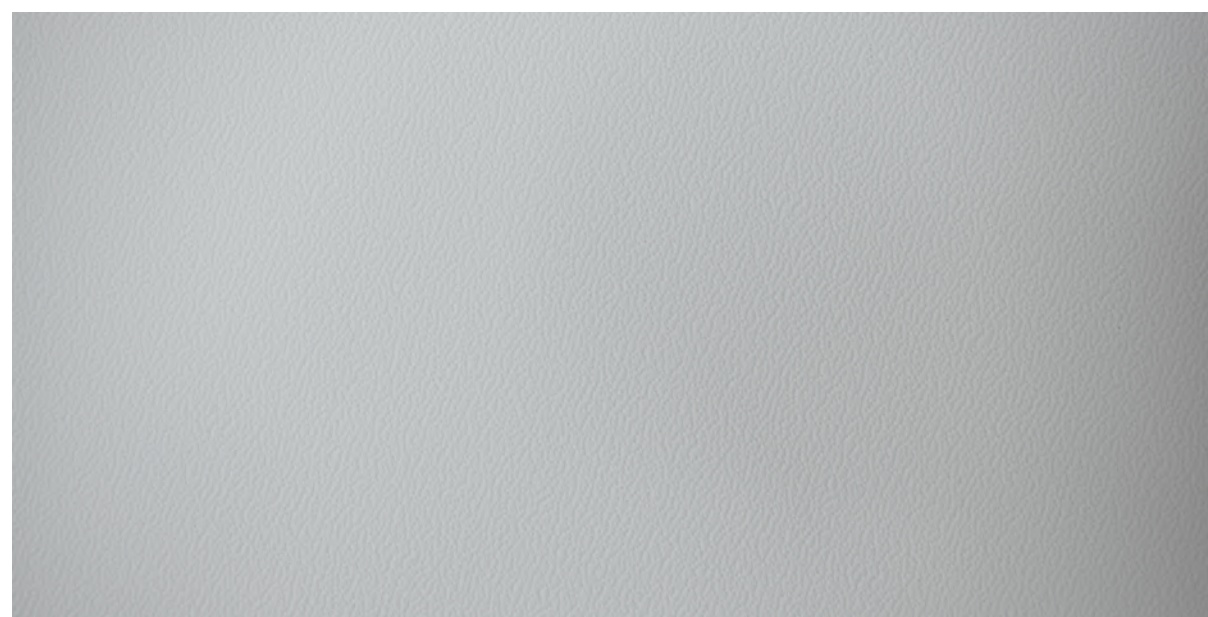


cohera Interior Bison Orange Brown | P00512032

Nappa surface

Technical data sheet cohera Interior, embossed, 1.0 mm

Parameter	Standard	Technical data
Composition		Leather content approx. 60% Binding agent natural latex approx. 20 % Pigments and auxiliary materials approx. 5% Finish approx. 15%
Weight		930 g/ m ² +/- 5 %
Size	Roll width/roll length	1.44 m width x 25 m (from 1 m in 0.5 m steps)
Fire protection class		Class 1 - normal flammability
Elongation kink resistance	DIN 53340	> 12,000
Tensile strength longitudinal/transverse	DIN EN ISO 3376	> 13 N/mm ²
Abrasion resistance	DIN EN ISO 11640	> 1,000
Light-fastness	DIN EN ISO 105-B02	Blue scale 4-5
Humidity	DIN EN 20 287	Approx. 10%
Chemical resistance		Sealed surface resistant to brief exposure to diluted alkalis, acids, oils, greases as well as food products such as red wine, mustard, ketchup, etc.
Availability		Ex stock ZEG
Certificates		Oeko-Tex Leather Standard EMAS REACH Quality ISO 9001

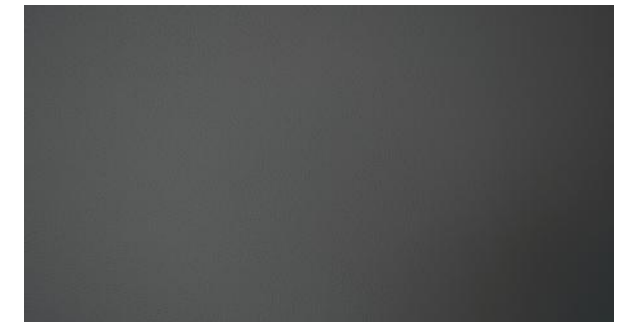


cohera Interior Nappa Pure White | P00712016

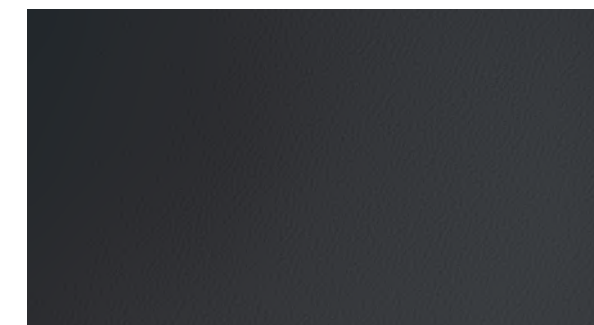
Nappa surface



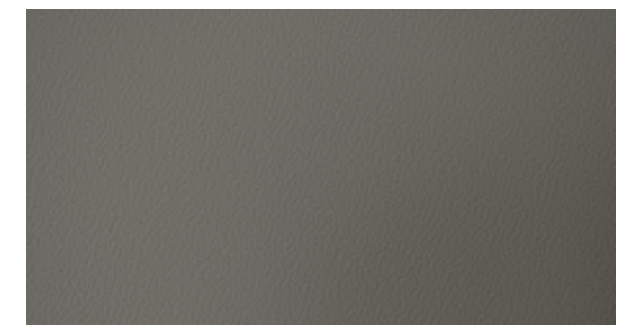
cohera Interior Nappa Graphite Black | P00612020



cohera Interior Nappa Basalt Grey | P00612022



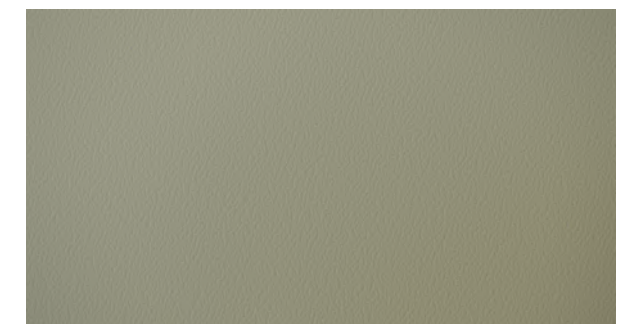
cohera Interior Nappa Night Blue | P00712017



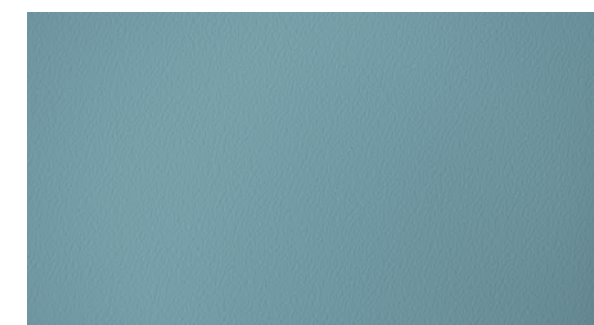
cohera Interior Nappa Light Grey | P00612021



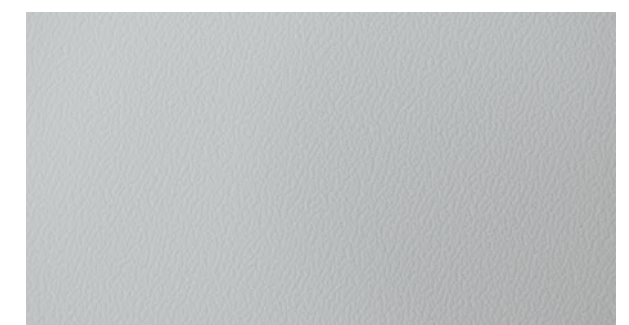
cohera Interior Nappa Dark Petrol | P00712018



cohera Interior Nappa Light Beige | P00712015



cohera Interior Nappa Light Blue | P00712019



cohera Interior Nappa Pure White | P00712016

Matt surface

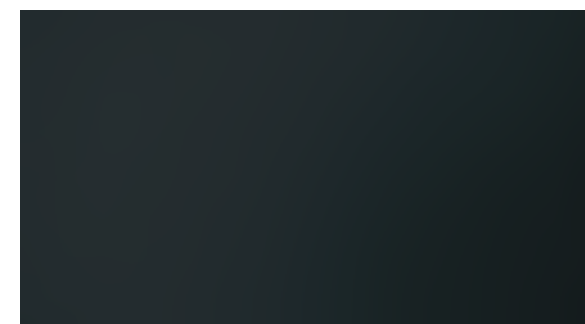
Technical data sheet Interior, matt, 1.0 mm

Parameter	Standard	Technical data
Composition		Leather content approx. 60% Binding agent natural latex approx. 20 % Pigments and auxiliary materials approx. 5% Finish approx. 15%
Weight		930 g/ m ² +/- 5 %
Size	Roll width/roll length	1.44 m width x 25 m (from 1 m in 0.5 m steps)
Fire protection class		Class 1 - normal flammability
Elongation kink resistance	DIN 53340	> 12,000
Tensile strength longitudinal/transverse	DIN EN ISO 3376	> 13 N/mm ²
Abrasion resistance	DIN EN ISO 11640	> 1,000
Light-fastness	DIN EN ISO 105-B02	Blue scale 4-5
Humidity	DIN EN 20 287	Approx. 10%
Chemical resistance		Sealed surface resistant to brief exposure to diluted alkalis, acids, oils, greases as well as food products such as red wine, mustard, ketchup, etc.
Availability		Ex stock ZEG
Certificates		Oeko-Tex Leather Standard EMAS REACH Quality ISO 9001



cohera Interior Matt Sand | P00612026

Matt surface



cohera Interior Matt Deep Black | P00612028



cohera Interior Matt Warm White | P00612023



cohera Interior Matt Graphite Grey | P00612029



cohera Interior Matt Sand | P00612026



cohera Interior Matt Grey | P00612027



cohera Interior Matt Beige Brown | P00612024



cohera Interior Matt Brilliant White | P00612025

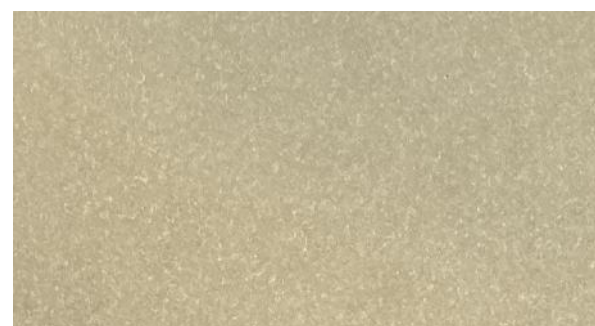


cohera Interior Matt Red Brown | P00512030

cohera Pure

Technical data sheet cohera Pure, 1.0 mm

Parameter	Standard	Technical data
Composition		Leather content approx. 75% Binding agent natural latex approx. 20 %. Pigments and auxiliary materials approx. 5%
Weight		865 g/ m ² +/- 5 %
Size	Roll width/roll length	1.44 m width x 25 m (from 1 m in 0.5 m steps)
Fire protection class		Class 1 - normal flammability
Elongation kink resistance	DIN 53340	> 12,000
Tensile strength longitudinal/transverse	DIN EN ISO 3376	> 13 N/mm ²
Abrasion resistance	DIN EN ISO 11640	> 1,000
Light-fastness	EN ISO 105-B02	Blue scale 1-2
Humidity	DIN EN 20 287	Approx. 10%
Chemical resistance		Unsealed surface not resistant to alkalis, acids, oils, greases as well as food products such as red wine, mustard, ketchup, etc.
Availability		Ex stock ZEG
Certificates		Oeko-Tex Leather Standard EMAS REACH Quality ISO 9001



cohera Pure | natural P00512039



cohera Pure | black P00412040

cohera Pure can be used as a pure material. The unsealed material lives from the resulting leather patina and is a natural material in terms of appearance, smell and feel. The cohera Pure finish can be renewed by sanding.

cohera Construct

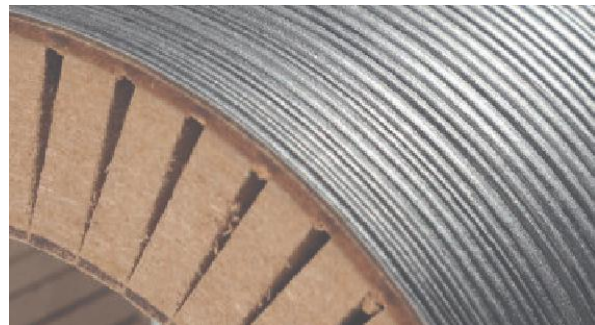
Technical data sheet cohera Construct, 1.6 mm

Parameter	Standard	Technical data
Composition		Leather content approx. 75% Binding agent natural latex approx. 20 %. Pigments and auxiliary materials approx. 5%
Weight		1400 g/ m ² +/- 5 %
Size	Roll width/roll length	1.44 m width x 25 m (from 1 m in 0.5 m steps)
Fire protection class	CAL TB 117 E Part 1	Class 1 - normal flammability
Elongation kink resistance	DIN 53340	> 12,000
Tensile strength longitudinal/transverse	DIN EN ISO 3376	> 13 N/mm ²
Abrasion resistance	DIN EN ISO 11640	> 1,000
Light-fastness	EN ISO 105-B02	Blue scale 1-2
Humidity	DIN EN 20 287	Approx. 10%
Chemical resistance		Unsealed surface not resistant to alkalis, acids, oils, greases as well as food products such as red wine, mustard, ketchup, etc.
Availability		Ex stock ZEG
Certificates		Oeko-Tex Leather Standard EMAS REACH Quality ISO 9001



cohera Construct | P00412041

cohera Construct



Flex Form Plus panel construction

cohera Construct is a flexible and mechanically highly stress-resistant construction material. It can be used as a middle layer in the production of flexible molded components between a decorative material on the visible side and a wood-base material on the back.

NOTE: The patent for the construction principle "Flex Form Plus Panel" is held by the company Georg Ackermann GmbH and may only be manufactured using cohera Construct. By purchasing cohera Construct through ZEG, the processor acquires the right to manufacture and communicate within the scope of the quantity of material used.

cohera Construct is made of leather fibers and natural rubber. Its optimized flexibility enables easy forming. The high tensile strength, resistance to glue penetration, high deformation resistance and excellent bonding properties make cohera Construct the ideal construction material for the patented construction principle. cohera Construct is a recycled material made primarily from natural leather. The reproducibility of the visual appearance is technologically possible to a large extent, but slight visual deviations are always to be expected when the natural resource leather is used.



Flex Form Plus panel construction

The following basic processing steps must be implemented:

- A. The material should always overlap to ensure a full-surface finish in the event that the decorative or backing material should slip.
- B. Glue should be applied evenly with a glue roller, by spraying or by the HotCoat method in order to ensure optimum adhesion and prevent excess glue.
- C. cohera Construct can simply be rolled onto the surface after glue application and pressed on by hand. Air inclusions/bubbles are to be smoothed out.
- D. Bonding can be performed in membrane, spindle and panel presses without heat application (not above 35°C). The setting time of the adhesive must be taken into consideration here. After pressing, an acclimatization period of 12 - 24 hours is recommended.
- E. After ventilation, any excess cohera Construct can be removed quickly and easily with a suitable knife.
- F. In order to achieve the desired formability, slots must be cut into the the full thickness of the MDF base panel down to the surface of the cohera Construct. Care must be taken to not mill or cut into the leather layer.
- G. It is recommended to make slots in the MDF panel only in the area of the planned curvature of the bent part of the panel.
- H. The width of the remaining webs/lamellae depends on the radius of the shape that the molded part is to assume and on the panel thickness of the MDF and the coating material used.
- I. It is warmly recommended to produce a test piece if sufficient experience with the manufacture of the construction has not yet been gained.

NOTE: Salamander and ZEG generally do not accept any liability for defective function and aesthetics in the manufacture of the construction principle, as the precision of the manufacture, the use of an appropriate decorative material as the top layer, the correct choice of adhesive, pressing time, press mold and the selection of the panel material decisively influence the quality of the design.



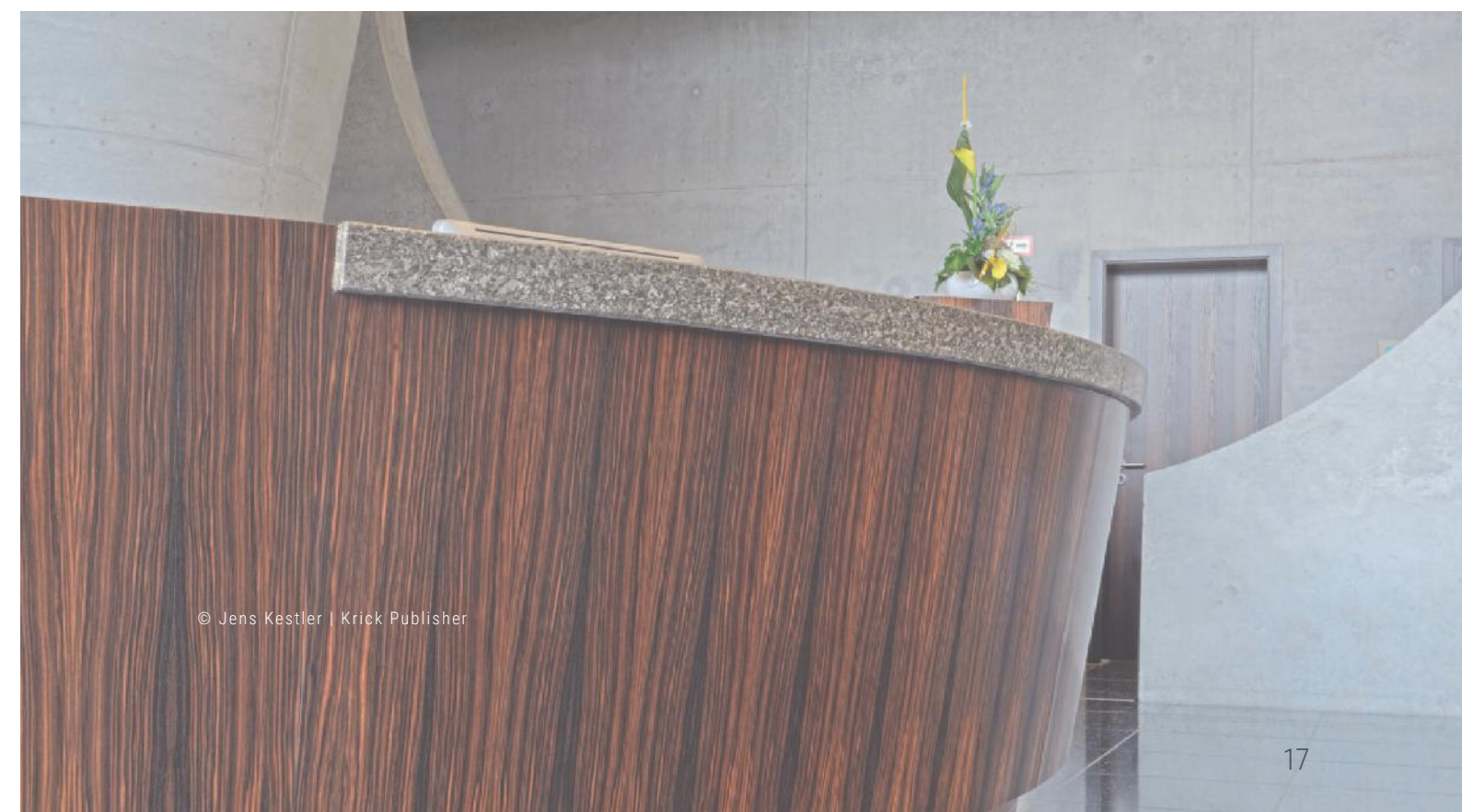
Radial slot cutting in the MDF base material



Veneered panel, funnel-shaped component



Slots solely in the area of the curvature stabilize the component



© Jens Kestler | Krick Publisher

Processing information

Pressing

Cold, up to max. 35°C with white glue, on untreated wood materials with pure cohera surface coating on a panel or membrane press; on melamine-coated wood materials we recommend GLUKON® spray, contact adhesive premium plus and premium sea (shipping).

A soft additive protects the surface and enables 3D formations (to us, soft additives for 3D formations are, for example, polystyrene, packaging foam, industrial felt or similar in a thickness corresponding to the recesses/thicknesses of the 3D mold).

We recommend minimum radii of 1 mm.
Matching ABS edgings available.

Cutting

cohera can be cut manually, punched or processed with CNC machines, and water jet cutting is also possible. Laser cutting is not recommended due to the development of odors and burning of the cutting edge.

Avoid creases, for example when placing onto machines.

Sanding (only cohera Pure)

cohera Pure can be sanded either manually or by machine with a grain size of 100-240, depending on the desired effect.



Edge processing

cohera Interior is to be processed circumferentially by means of folding technique from the (upper) surface round the edge to the (lower) surface.

With cohera Interior, doubled panel thicknesses (tabletops, doors, etc.) and body structures can be produced using folding technique. As usual, single mitered components are joined together in a 45° angle construction. The special feature in the use of cohera Interior is that it can be manufactured continuously without interruption around the mitered structure.

The following processing must be implemented here:

- A. Individual parts which are to be mitered together are manufactured as individual elements.
- B. cohera Interior is made in sheet form and in the appropriate size, and moistened with an appropriate adhesive/glue. The information provided in the chapter entitled - Surface bonding - 1) A - G must be observed for the bonding procedure.
- C. The individual parts are joined together at the mitered edges on the moistened cohera Interior.
- D. In order to prevent the individual parts from slipping, adhesive tape can be tacked at points over the open miters.
- E. Pressing takes place flat in a panel or membrane press. The instructions of the adhesive manufacturer must be observed.
- F. After the adhesive has set and the workpiece has ventilated (12 - 24 h), the miter joints and, if applicable, mating surfaces can be moistened with adhesive.
- G. cohera Interior material in corner areas (outside the miter joints) must be cut with a sharp knife. **It should be observed that cutting must take place in the direction of the miter surface to avoid open edges. For this purpose, a test piece is warmly recommended when the construction is manufactured for the first time.**
- H. The construction is bonded by folding the miter joints moistened with glue and a corresponding additional pressing process. cohera Interior pulls itself around the miter edges and acts as an integral hinge similar to the adhesive tape in miter gluing.
- I. To connect the panel elements in body constructions, the use of wrapping foil, tension belts or soft additives is recommended. Adhesive tape is only partially recommended, as leather fibers can be expected to tear out of the surface, especially in the case of cohera Interior Pure.
- J. Glue residues should be removed with water as quickly as possible.
- K. It is recommended to create a sample bond if only little or no experience with the folding technique has been gained.

Classic edge processing

cohera Interior is to be used as a cover material for flat components with wooden, plastic or aluminum edges. This can take place manually or by machine.

cohera Interior can also be used as an edge trim. It is possible to glue appropriate strips manually to the edge as in the case of solid wood bonding agents.

Edge profiles

As described in the chapters on edge processing and surface forming, cohera Interior can be pressed into shape as a flexible decorative material in an easy technical process. This enables a wide range of design options for profiling, especially for panel edges. Curves, simple hollow profiles, chamfered edges, etc. can be produced with cohera Interior in an easy technical process. In addition to the previous processing instructions in the chapters on surface and edge processing, it must be observed that cohera Interior can assume minimum radii and is flexible to a limited extent. The production of test parts is recommended.

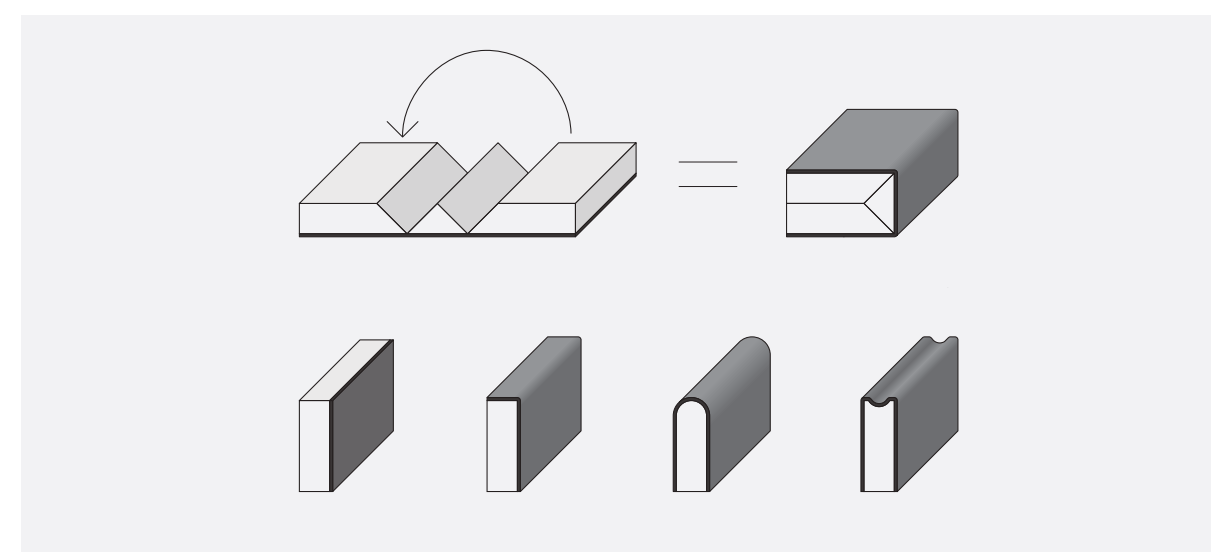
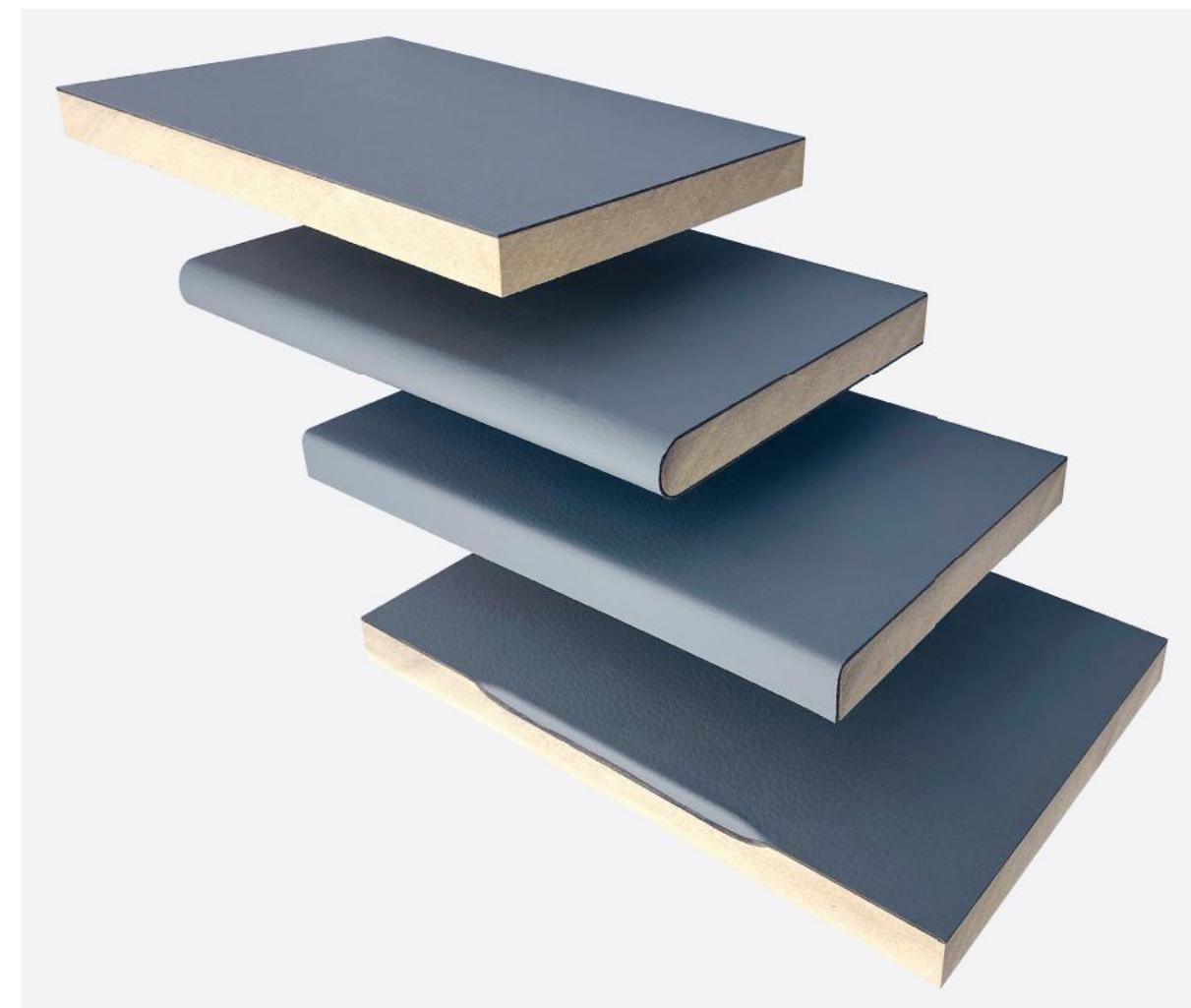
Tools

Manual and machine processing

No special machines and tools are required to process cohera Interior. After the bonding process of the base and surface material has been completed and a setting period for acclimatization purposes has been allowed for, further processing of the workpiece can be performed without any particular restrictions. In general, standard processing such as sawing, planing, drilling, milling or cutting is possible with cohera Interior. The use of sharp tools is of particular importance.

We recommend the general manufacture of test pieces prior to the start of series production or manufacture of the final individual component in order to gain basic experience with cohera Interior.

Processing information



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Panels +
edges



Doors +
construction fittings



Outdoor wood



Floor +
wall + ceiling



Sawn timber +
wooden construction



Chemistry



Machines +
tools