

- Formwood Paper-Backed, NBL, and Duraback Application Guidelines

APPLICATION GUIDELINES

FOR FORMWOOD® PAPER-BACKED, NBL®, AND DURABACK™ SHEET VENEER PRODUCTS

Preparation

Materials should be properly conditioned before they are used. The standard recommendation is that both the veneer and substrate should be stored in the same environment for 5 days to ensure their moisture content is in equilibrium. Extreme temperature/humidity fluctuations will affect both the veneer and substrate. High humidity levels will cause veneer to expand/buckle, while extremely dry conditions will cause veneer to shrink. Both the veneer and substrate should be free of paint, grease, dirt, dust, oil, or any other foreign matter. Substrate surfaces must be sanded with 80 grit sandpaper and entire area dusted clean. Good bonds depend upon smooth, clean, dry surfaces.

Glues/Adhesives

Solvent based adhesives work best with veneer products. Water based products should be avoided when possible. The adhesive should be applied uniformly to both the substrate and veneer. 100% glue coverage is recommended. This is especially critical to the edges and areas where veneer sheets butt together. Any areas void of glue adhesive can bubble. If the substrate is porous and absorbs adhesive, a second coat is required. The veneer back should be coated also. ***Follow the glue manufacturer's recommendation on open time before bonding the veneer to the substrate.***

Keep in mind the open time is affected by humidity and temperature. Adhesives which contain higher solid contents perform better. Adhesives should always be stirred or agitated before use. This is particularly necessary with large containers. ***See manufacturer's recommendations.***

The **Only** Exception to the non-use of water-based glues is with our **DuraBack™ Resin-Backed** veneer, which is recommended for use with both water and solvent-based adhesives.

Potential Trouble Areas

1. Using water based products immediately raises moisture content and can cause delamination.
2. Too little, too much, or uneven distribution of glue can cause delamination.
3. Bonding before adhesive solvent has evaporated or after open time has expired can cause delamination.

Not recommended for use on sheet rock or drywall

Bonding

To ensure intimate contact necessary for an adequate bond, sufficient pressure should be applied over the entire area using as much pressure as possible without damaging the veneer. Platten presses and bag presses work very well. If these options are not available use a fiber knife or veneer scraper and start in the center of the veneer sheet working out. Always work in the same direction as the grain of the veneer. The edges should always be scraped twice. **A standard "J" roller is not recommended due to the low pressure exerted with them.**

Finishing

The adhesive should dry a minimum of 48 hours before finishing. High grade petroleum based urethanes and acrylic based lacquers reduce the risk of veneer checking. These finishes provide a good moisture barrier. Always seal the back of panels if raw or unsealed. **Follow the recommendations of the finish manufacturer.**

If you require more detailed information on Application, Fabrication and Installation items, please contact the National Electrical Manufacturers Association and request their Laminate Standards Publication LD 3-1995 at:

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