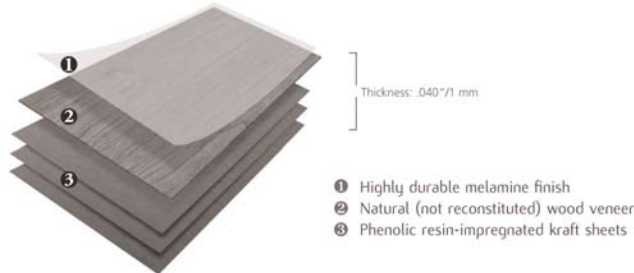


How to install Veneer-Art® high-performance wood veneer

■ PRODUCT COMPOSITION



Veneer-Art® is manufactured with natural, not reconstituted wood veneers that are impregnated with a protective melamine resin and fused with phenolic resin-impregnated kraft sheets. The result is a pre-finished, ready-to-fabricate veneer that features a maintenance-free, scratch-resistant surface.

Due to the inherent properties of real wood and the varying number of sheets that are cut from any given log, variations in color and grain will appear from one Veneer-Art sheet to another. This is a normal occurrence, and not a defect. A natural maturing and mellowing of color may also occur with age.

With its highly durable melamine finish, Veneer-Art high-performance wood veneer is ideally suited for use on both horizontal and vertical interior surfaces. Veneer-Art has been used in commercial and institutional environments for architectural doors, elevator cabs, wall paneling, store fixtures and transaction counters, custom furniture, cabinets and casegoods, table tops, bathroom partitions, and much more; as well as in cruise ships. **Veneer-Art is not recommended for exterior use.**

■ REFERENCE SAMPLE

When placing an order for Veneer-Art®, please supply a reference sample so that Lamin-Art can attempt to match the requested color as closely as possible. Each shipment of Veneer-Art will also contain a reference sample of the material supplied.

■ STORAGE/HANDLING

Fabricators are advised to exercise care when handling and storing Veneer-Art® due to the organic nature of its constituent wood veneer. When handling, care should be taken to avoid cracking of the resin. The best way to carry panels is with two persons with the decorative face on the concave side.

Veneer-Art sheets should be stored flat and face-to-face with a caul board placed on top to preserve the material. Lamin-Art® recommends storing the panels in an atmospherically stabilized room to avoid extreme fluctuations of moisture.

■ CONDITIONING

Because they are made of real wood, Veneer-Art® sheets are sensitive to ambient conditions and slightly more subject to warping than conventional high-pressure decorative laminates. Prior to gluing, they need to be perfectly conditioned. If they are glued when moist there is a risk of cracking due to shrinking of the wood, particularly in winter when relative humidity is very low. The best method of conditioning is to store the substrates and panels for a period of 8 to 10 days in the same room, with atmospheric conditions as close as possible to those of the installation site, while providing for air circulation around the sheets. This is especially important in the case of overheated rooms without humidity control.

Ideal conditions are:

Temperature: 64°F to 72°F (18°C to 22°C)

Relative humidity: 50 to 60%

There is a risk of cracking due to shrinkage of the wood if a panel with too high of a moisture content is installed, while too dry a panel may expand resulting in warping or blisters on the surface.

Conditioning is effective only if air circulation is possible between the sheets during storage. When substrates are to be faced on both sides, it is advisable to stack panels and substrates in the same sequence as their eventual construction in order to achieve hygrometric balance. A dry atmosphere is preferable to high humidity.

■ SUBSTRATES

Veneer-Art® can be applied to many types of base material as long as the surface is perfectly flat, thoroughly clean, and free of saw dust and/or wood chips. Recommended substrates include 45lb. density particleboard, medium-density fiberboard (MDF), high-density fiberboard (HDF), or any substrate that meets ANSI 208.1 or 208.2 standards. Gluing to a metal surface requires careful preparation of the surface with particular attention paid to thorough degreasing with a strong solvent. Panel assemblies should be laminated with a suitable backer sheet to minimize warpage.

■ ADHESIVES

The surface to be glued must be sound, thoroughly dry, clean and free of dust, wood chips, and oil.

Given the real wood constituents of the product, we recommend using a **rigid bond adhesive** in conjunction with a **hot or cold press** to fabricate Veneer-Art (hot-melt, PVA, resorcinol, or urea type adhesives).

When gluing with a hot press, do not exceed 140°F (60°C). Above that temperature, there is a risk of creating harmful tension that could affect adhesion.

Contact adhesives should be restricted to small surface areas only when a laminating press is not available (such as an on-site installation). Contact adhesive should be kept at an ambient temperature between 64°F and 72°F (18°C and 22°C) with a 40 to 60% relative humidity rating. Always follow the adhesive manufacturer's directions, ensure excellent glue coverage of both surfaces to be bonded, and apply at least 50-75 pounds of pressure per square inch.

In all cases, always consult the adhesive manufacturer's directions.

■ FABRICATION

Sawing, milling, drilling and other machining can be done with all tools that are typically used in the fabrication of high-pressure laminate. All inside corners of the cutouts must be radiused as large as possible (3/16" minimum) to avoid stress cracking. All edges of Veneer-Art® must be sealed by the application of a clear varnish. This is done to prevent moisture penetration, ensure better aging of the wood, and prevent oxidation.

■ MAINTENANCE

Glue stains should be removed as quickly as possible. Although vinyl glue stains are water-soluble and may be easily removed, other adhesives, if given time to harden, will be difficult to remove without damaging the Veneer-Art® surface.

Veneer-Art should be cleaned with a damp cloth and ordinary soap or household cleaner. Stubborn stains may require organic solvents such as alcohol, acetone, lacquer thinner or paint solvents. These solvents will not harm the Veneer-Art surface, but are flammable and will attack standard contact adhesives at the glue line edges.

■ WARRANTY

Lamin-Art® expressly warrants that its Veneer-Art® sheets are free of defects in material and workmanship, they are of merchantable quality and conform within accepted tolerances of applicable manufacturing specifications. Inasmuch as Lamin-Art has no control over the end products fabricated with the materials sold, no warranty or guarantee is expressed or implied other than those set forth above.

Failure to comply with any of the terms, conditions or recommendations explained herewith will render this warranty null and void.