

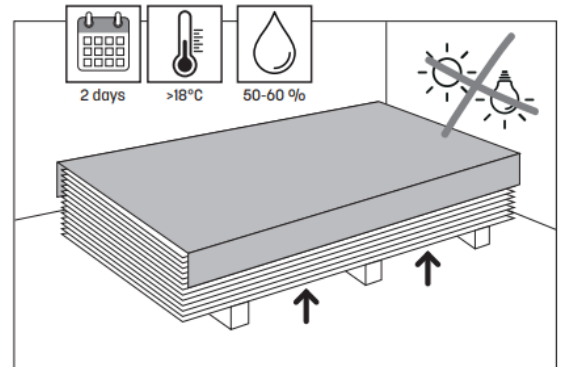
GLUING INSTRUCTIONS

Shinnoki laminate is a jointed sheet of veneer pressed onto a paper which was impregnated with a phenolic resin. This product is ideal for laminating the most common wooden substrates and for (re)decorating doors. It is not recommended to glue Decolam on solid wood. Shinnoki laminate is slightly bendable and can therefore be used to decorate large arches. Postforming is not possible. Maximum radius = 50mm.



STORAGE

It is advisable to keep Shinnoki laminate in a dry place with a constant temperature of at least 18°C and maintain a constant relative humidity between 50% and 60%. The products should be acclimatized for 2 days before processing. We recommend to store Shinnoki laminate horizontally, face-to-face. Avoid direct contact with the floor. The top layer of Shinnoki laminate is real wood veneer, which is likely to discolour over time. Therefore, always store Shinnoki laminate in a dark place or cover the sheets so that they are not exposed to light. Occasionally, Shinnoki laminate is delivered in a cardboard package (parcel service). We recommend that you remove the sheets as quickly as possible from this package and store them flat as described previously. Thus, problems with the processing of the laminates are avoided. Be aware of the sharp edges when manipulating Shinnoki laminate and always carry the sheets with 2 people. Wear gloves to avoid cutting injuries.



APPLICATION

Always apply Shinnoki laminate on both sides of the core you wish to ensure a good stability. It is possible to use another type of backing that matches the characteristics of Shinnoki laminate. Whenever processed, any responsibility of the manufacturer expires. Under all circumstances, it is recommended to test the adhesion and stability before proceeding to full production. Before you start processing, please remove the protection foil first.

GLUING

Shinnoki laminate, glue, substrates and finishing products should be stored in the same area or at least at the same temperature and humidity for at least 48 hours. The recommended temperature is at least 18°C and the relative humidity is between 50% and 60%. If these parameters are not respected, this can lead to ridges between the Shinnoki laminate and the substrate. Shinnoki laminate can be manually glued with contact glue or in a press (hot - max 70°C or cold). Always pay carefully attention to the instructions of the glue manufacturer. When using a spray-gun it is recommended to spray several thin layers instead of 1 thick layer onto both the Shinnoki laminate and the substrate, with the necessary waiting time between the different layers. If the gluing is done by a press (hot - max 70°C or cold), then it is recommended to use a PVAC-glue. Before applying the glue, ensure that all surfaces are free of grease, dust and other dirt. The surface can be cleaned efficiently by denaturated ethyl alcohol. For contact glue it is important that the glue is applied on both surfaces. If using a glue spatula, apply the glue on one surface at right angles to the other. (Fig 1)

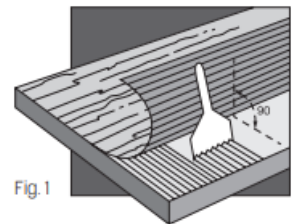


Fig. 1

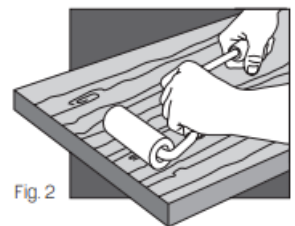


Fig. 2

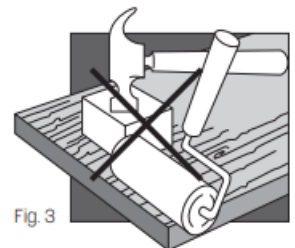


Fig. 3

PRESSING

Start to press from the middle of the board (never begin from the sides). Once the two surfaces are making contact they can be properly pressed by using a roller with two grips. Use body weight for maximum pressure. (Fig 2) Never use a hammer and block or rollers with only one grip! (Fig 3)

When using a press, the pressure must be between 2 and 5 kg/cm² to ensure correct bonding.