

# StyleLite<sup>®</sup> lamination methods.

StyleLite<sup>®</sup> can be integrated into many vertical surfaces for furniture and joinery applications.

## Applications

The following lamination procedure is suitable for cabinet doors, drawer fronts and general domestic and commercial furniture applications.

## Doors and panels

StyleLite laminated to MDF is for interior applications only. Maximum finished panel size of 2400mm x 1200mm (96" x 48") is recommended.

A StyleLite laminated panel may react to severe changes in humidity and temperature. A curvature of up to 1.5mm/1000mm (1/16"/40") may occur in some extreme environmental conditions. Excessive curvature can be minimized by avoiding long narrow panels and by ensuring adequate hinging and fixing support is provided.

## Specifications

StyleLite laminated panels must be suitably balanced on the reverse side. Adequate fixing should be provided at no greater than 400mm (16") centres. We recommend an air gap of 6mm (1/4") adjacent to ovens or other heat sources. Laminated panel mass using a 16mm (5/8") substrate is 13.5kg/m<sup>2</sup> (3lbs/ft<sup>2</sup>).

## Hinge Specifications

Up to 800mm (32")	2 Hinges
800mm to 1300mm (32" to 51")	3 Hinges
1300mm to 1800mm (51" to 71")	4 Hinges
1800mm to 2400mm (71" to 96")	5 Hinges

## Materials for pre cut lamination

**StyleLite** – all colours are suitable for lamination using this method.

**Substrate** – use select grade smooth sanded moisture resistant MDF 16mm (5/8") or thicker. For single sided applications MDF with melamine pressed to one side is suitable either flat sheet or maximum cup 12/3 (1/2"x1/8")

**Backing panel** – for single sided applications using unfinished MDF adhere 0.6mm (1/32") thick cabinet, or similar liner to rear surface of the substrate.

**Hand Lamination** – Water based EVA and liquid PUR'S are suitable. Apply with a roller or notched trowel to achieve even spread of adhesive.

**Automated Lamination** – PUR reactive hotmelt and water based EVA systems are suitable. Using an even, and light to moderate adhesive build, will achieve the optimum visual appearance.

**Pressing** – Ensure StyleLite and substrate are clean and free of dirt and debris before lamination. Light to moderate cold press only. Hot pressing StyleLite may induce excessive bow in the finished panel.

**Edge banding** – Use ABS or Acrylic edge banding only secured with EVA or PUR hot melt adhesives. StyleLite colour matched high gloss 25x1.0mm (1"x3/64") thick edge bands or contrast edge bands are available.



### CAUTION

Correct handling and safety procedures should be followed at all times.



### NOTE

Large scale lamination projects should be undertaken by specialist lamination providers.

## Processing Conditions

Lamination should only be completed from 15°C to 30°C (59°F to 86°F) ambient temperature. StyleLite, MDF and the liner should be stored under the same conditions to normalize for at least 12 hours prior to lamination. Laminated panels can be cut using typical woodworking techniques and machinery. Use only high speed very sharp carbide tools and blades at a moderate feed rate.

## Hand Lamination Process



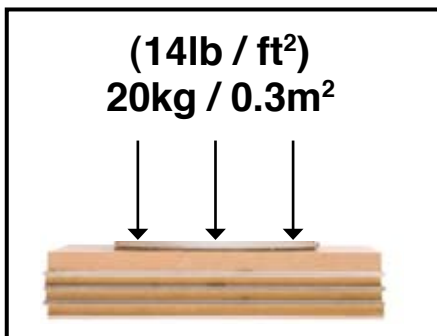
1. Using a suitable panel saw, cut StyleLite, MDF and backing panel slightly oversize.



2. Ensure panels are free from dust and debris. Mix adhesive as directed by the manufacturer.



3. Apply adhesive using roller or 2mm (3/32") notched trowel.



4. Laminate the 3 materials and press for a minimum of 4 hours with a moderate weight spread evenly across the panels. Overnight pressing is ideal.



5. Trim laminated panels to final size using a planner or router.

## Edge Banding StyleLite

### Edge Banding

Leave the protective film in place and apply edging in normal manner. Use mineral turpentine sparingly to clean off any excess adhesive. Take care when finishing the edge to avoid gouging the StyleLite surface.

For edging thicker panels StyleLite can be sawn into strips and used as edging either before or after lamination, depending on the finish appearance required.



#### WARNING

Do not use - PVC edge banding, solvent based adhesives or aggressive solvent based cleaners at any time.

Statements and recommendations provided by EGR, either written or verbal are based on our experience gained to date. Laminated panel performance may vary due to application methods, substrate variations and environmental conditions. Users should consult the adhesive and substrate suppliers technical data and complete their own tests to determine the suitability of our product for each application. Individual results may vary. No liability may be derived from these images or statements nor from our free technical advice.

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Patent Pending

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by **EGR**