Your Space
Your Story™

DECOLAM
Flexible wood laminate

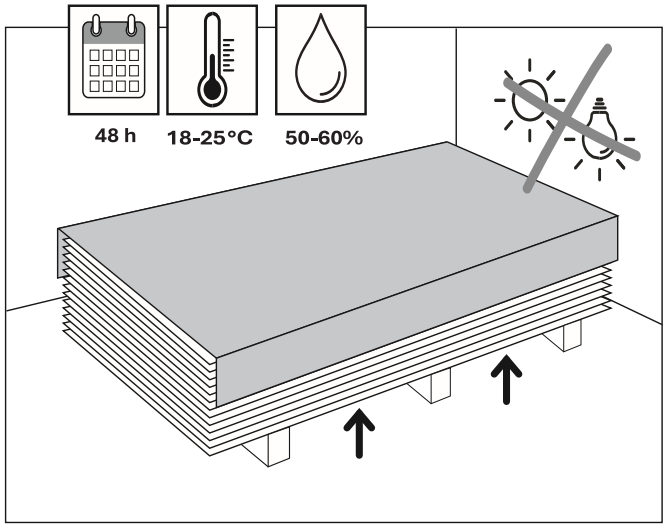
SHINNOKI® by NAV™

PROCESSING INSTRUCTIONS

Gluing Instructions
Decolam 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 Decoslam on solid wood. Decolam is slightly bendable and can therefore be used to decorate large arches. Postforming is not possible. Maximum radius = 150mm.

zero
ZERO ADDED UREA-FORMALDEHYDE

Storage
Decolam, adhesive, core, and finishing products should be brought into the same space or at least at the same temperature and humidity for at least 48 hours. The recommended temperature is a min. of 18°C and a max. of 25°C, with a relative humidity between 50% and 60%. We recommend storing Decolam horizontally, with the visible sides facing each other. Direct contact with the floor should be avoided. The top layer of Decolam is real wood veneer, which may discolor over time. Therefore, Decolam should be stored in a dark place and covered. Occasionally, Decolam is delivered in cardboard packaging (courier service). We recommend removing the Decolam from the packaging as soon as possible and storing it horizontally as described above. This helps to avoid problems with processing Decolam. Take care with the sharp corners when handling Decolam and always carry it with two. Wear gloves to prevent cuts. Failure to adhere to these parameters may result in adhesion problems between Decolam and the base substrate.



Application
Always apply Decolam on both sides of the core you wish to ennoble to ensure a good stability. It is possible to use another type of backing that matches the characteristics of Decolam. Whenever chosen, any responsibility of the manufacturer expires. Under all circumstances, it is recommended to test the adhesion and stability before proceeding to full production.

Gluing and Pressing
Before applying the glue, ensure that all surfaces are free of grease, dust and other dirt. The surface can be cleaned efficiently by denatured ethyl alcohol.

Decolam can be bonded to the substrate in various ways.

It is strongly recommended to use a PVAc adhesive for flat surfaces. This adhesive can be applied using a comb or roller. Only the substrate should be glued, with an application of 60 to 80 grams/m^2. Then, the Decolam is placed onto the substrate,and sufficient pressure should be applied. This can be done using a (homemade) press, or expedited using a hot press (max. 70°C). When using a press, the pressure should be between 2 and 5 kg/cm^2 to ensure proper bonding. If there is protective film on the Decolam, it is best to remove it first when using a hot press.

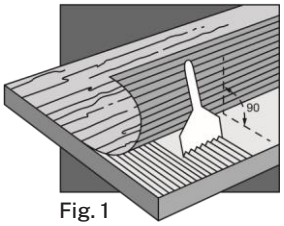
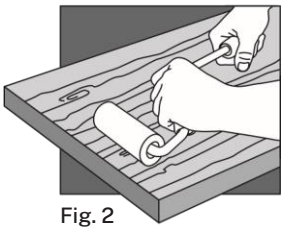
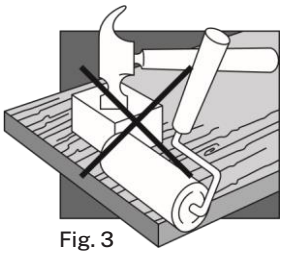


Fig. 1

Decolam can also be manually bonded using contact adhesive. This can be done with either spray contact adhesive or universal liquid contact adhesive. It is important that the contact adhesive is not water-based. Always follow the instructions of the adhesive manufacturer very closely. 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) When using a spray gun, it is recommended to apply several thin layers of adhesive to both the Decolam and the substrate instead of one thick layer, ensuring the necessary waiting time between the layers.


Fig. 2

When manually pressing with a roller, start from the middle of the sheet and press outward. Once the two bonded sides come into contact, they cannot be shifted relative to each other anymore. The rollers used should have two handles so that pressure can be applied with the full body weight. Never use a hammer or block, or rollers with only one handle!


Fig. 3

Finishing
It is recommended to finish Decolam with a solvent-based oil or varnish. It is advisable to wait for 2 days between gluing and finishing the Decolam to ensure that all solvents from the adhesive have evaporated. Ensure that the surface is well sanded before applying the finish. Always follow the instructions provided by the supplier of the stain/varnish/oil.