

WORKING WITH PolyBak LAMINATING BEST PRACTICES

by RICHWOOD

STANDARD PRESS SETTINGS

HOT PRESS SETTINGS

MILS OF ADHESIVE:	3 - 6 WET (PVA ADHESIVE)
PRESS TEMPERATURE RANGE:	190° - 230° F (88° - 110° C)
PRESSURE (PSI):	HPL: 35-45; VENEER: 60
PRESS TIME:	TYPICAL RANGE: :53 SEC - 3.5 MIN

Notes:

For best results, acclimate all materials to the same temperature before beginning the lamination process. Substrates over 100° F will rapidly shorten the open/closed assembly time. At this temperature, additional adhesive may be needed.

COLD PRESS SETTINGS

MILS OF ADHESIVE:	6 - 8 WET (PVA ADHESIVE)
ADHESIVE TEMPERATURE RANGE:	60° - 70° F & ACCLIMATED TO SUBSTRATE
PRESSURE (PSI):	HPL & INDUSTRIAL PRODUCTS: 35-45; SOFTBOARD: 40-50
PRESS TIME:	AVERAGE: 30 MIN

Notes:

For best results, acclimate all materials to the same temperature before beginning the lamination process. The information listed above is to be used as a general guideline for cold and hot press laminating. Various adhesive products require different settings and coverage. Contact your adhesive representative for product specific requirements.

CAN'T GET IT TO STICK?

- Do you have *uniform* coverage with the proper adhesive?
- Are your glue rollers unevenly worn?
- Was the amount of adhesive on the top and bottom of the board the same?
- Was your adhesive acclimated to the same temperature as the other materials used?
- Did you use the correct open and close assembly time?
- Did you use the correct press pressure?



STILL NEED HELP?

Contact our Sales Engineer - Rich Rivera
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