

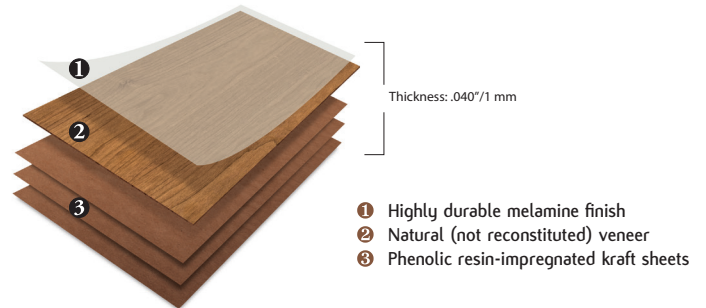
## HOW TO INSTALL

APRIL 2014

### PRODUCT COMPOSITION

Veneer-Art® is manufactured with natural, not reconstituted wood veneer that has a protective melamine resin wear layer 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.



### RECOMMENDED APPLICATIONS

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, as well as in cruise ships. **Veneer-Art is not recommended for direct application to plywood, steel, aluminum, fiber reinforced plastic, plaster, gypsum board or concrete. Do not use in areas exposed to temperatures in excess of 275°F (135°C) or high humidity. Veneer-Art is not recommended for exterior use. Once Veneer-Art sheets are properly conditioned, all open edges should be sealed with a clear varnish to prevent further response to changes in humidity and temperature.**

### CONDITIONING

Veneer-Art® panels may be sensitive to changes in temperature and humidity conditions. If adhered with excess moisture present, there is a risk of cracking and open seams due to shrinkage, particularly in winter conditions or when relative humidity is low. Prior to adhesive application to a suitable substrate, Veneer-Art panels should be carefully conditioned. (The recommended method of conditioning is to store panels and substrates together in the same room for a period of at least 72 hours with adequate air movement, under stable temperature and humidity conditions as close as possible to actual conditions at the installation site.) **Recommended conditioning for all panels is at approximately 75° F (24° C), with 45-55% relative humidity.**

### STORAGE AND HANDLING

Veneer-Art® sheets should be stored horizontally, back-to-back and face-to-face, with the top sheet turned face down and a caul board placed on top to preserve the material. Storing the panels in an atmospherically stabilized room is recommended to avoid extreme fluctuations of moisture.

Lamin-Art® recommends that full-sized sheets be carried by two people with the decorative facing upward whenever possible.

### INSTALLATION

All surfaces to be laminated should be inspected prior to installation to ensure that they are clean and free of surface defects and contamination. All defects should be corrected before application. Material, equipment, and workmanship should conform to industry-standard practices, conditions, procedures, and recommendations specified by National Electrical Manufacturers Association (NEMA) LD 3-2005 Annex A, Architectural Woodworking Institute (AWI) Quality Standards, and the American National Standards Institute (ANSI) 161.2-1979 standards. **It is critical that all edges of Veneer-Art® MUST be sealed using a clear varnish or other suitable sealer to prevent moisture penetration/absorption. For more detailed installation instructions, please refer to the Lamin-Art® "How to Install Veneer-Art" information sheet.**

#### SUBSTRATES

Veneer-Art® should be adhesively bonded to a substrate, or to a sheet substrate forming a new composite component which will be used in other assemblies. Suitable substrates may include but are not limited to particleboard (minimum density 45 pounds/cubic foot), medium-density fiberboard (MDF) or high density fiberboard (HDF). Materials with insufficient dimensional stability or internal bond strength such as plywood, steel, aluminum, fiber reinforced plastic, plaster, gypsum board, and similar materials are not recommended for use as substrates. Concrete is not a recommended substrate.

#### ADHESIVES

Surfaces to be adhered must be sound, thoroughly dry, clean, free of dust, wood chips, oil and other types of surface contamination.

When a laminating press is not available, such as an on-site installation, contact adhesives may be used, however this method should be restricted to small areas only. Ensure full adhesive coverage of both surfaces to be bonded and apply a pressure of at least 50-75 pounds per square inch until full bonding is achieved. Spot bonding should never be used. In all cases with all types of adhesives comply with the adhesive manufacturer's usage recommendations.

### BACKING SHEETS

To avoid warping of a panel assembly faced with Veneer-Art®, stresses resulting from thermal and hygroscopic forces on both sides of the assembly must be balanced. The best results are obtained when a backing sheet, with characteristics comparable to the face sheet, is laminated to it. Alternatively, balance may be achieved using an ordinary high pressure laminate of the same thickness on the back side of the assembly. Narrow panels for wall applications, held rigidly in place by a securing system can have just a face side if the back side is protected from excess humidity and covered with a suitable sealant such as paint, lacquer, or a vapor-retarding varnish.

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### FABRICATION TIPS

- All edges of Veneer-Art® must be sealed with a suitable sealer in order to prevent moisture penetration that could damage the veneer.
- Veneer-Art is not recommended for exterior use.
- Veneer-Art sheets should be stored flat and face-to-face with a caul board placed on top to preserve the material. Store panels in a room with stabilized temperature and humidity conditions and avoid extreme fluctuations of moisture.
- Panels and substrates should be conditioned prior to fabrication. The recommended method of conditioning is to store the panels and substrates together in the same room for a period of at least 8-10 days with adequate air movement, under stable temperature and humidity conditions as close as possible to actual conditions at the installation site.
- Surfaces to be adhered must be sound, thoroughly dry, clean, free of dust, wood chips, oil and other types of surface contamination.
- Thoroughly vacuum surfaces before applying adhesive.
- Because natural wood fiber is used in the product, fabrication or installation using a rigid bond adhesive in conjunction with a hot or cold press to fabricate Veneer-Art is recommended. These include hot-melt, polyvinyl acetate (PVA), resorcinol or urea type adhesives.

For complete fabrication and installation instructions for Veneer-Art High Performance Wood Veneer consult the Lamin-Art® Veneer-Art Installation Sheet.

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### 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.

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### FABRICATION

Sawing, milling, drilling and other machining can be done with the tools that are typically used in the fabrication of high-pressure laminates. 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 or other suitable type of sealant.** This is done to prevent moisture penetration, to ensure better aging of the wood, and to prevent oxidation.

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### MAINTENANCE

Veneer-Art® general purpose high-pressure decorative laminate may be cleaned with a damp cloth, warm water, and a mild soap or household cleaning products. Cleansers that contain abrasives, acids, or alkalis may damage the decorative surface and are not recommended. Stubborn stains may require the use of hypochlorite bleach followed by a clean water rinse.

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### WARRANTY

Lamin-Art®, Inc. expressly warrants that its products are free of defects in material and workmanship, are of merchantable quality, and meet or exceed performance standards for high-pressure decorative laminates as established by NEMA, LD 3-2005. Please note that some of our products contain special pearlized inks and do not meet NEMA standards for abrasion/scratch resistance in all finishes. 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, and is limited to the replacement cost of the material alone.

Questions? Call Customer Service at 800.323.7624.