

INSTALLATION AND FABRICATION GUIDE

Applications

Wilsonart[®] RE-COVER™ laminate is designed to be used in interior applications. The product must be bonded to a suitable substrate, such as particleboard, medium density fiberboard, plywood with one A face, previously bonded high pressure decorative laminate, or low pressure laminate (melamine board). Wilsonart RE-COVER laminate may be installed on flat surfaces in both vertical and horizontal applications.

Basic Limitations

Wilsonart RE-COVER laminate is not recommended for direct application to plaster, concrete walls, gypsum wallboard, polypropylene, polyethylene, polystyrene, or powder coated surfaces. Do not subject Wilsonart RE-COVER laminate to extremes in humidity, temperatures higher than 150°F for substantial periods of time, or intense, continuous, direct sunlight. Do not apply Wilsonart RE-COVER laminate if the surface temperature of the laminate or the substrate is below 50°F.

Shipping and Storage:

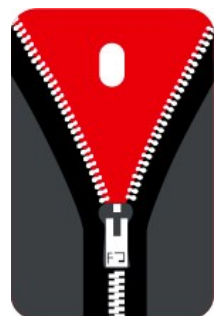
Wilsonart RE-COVER laminate may be shipped flat or rolled in a box. When shipped in a box, Wilsonart RE-COVER laminate must have the adhesive rolled to the outside (decorative side in). When Wilsonart RE-COVER laminate is shipped flat, it must have the adhesive side facing down (decorative side up). For long term storage, Wilsonart RE-COVER laminate should be stored flat (horizontally) with the adhesive side facing down (decorative side up).

It is important to properly acclimate both the Wilsonart RE-COVER laminate and the substrate prior to bonding. Condition both the laminate and the substrate in the same environment for 48 hours before fabrication. If rolled, unroll the Wilsonart RE-COVER laminate for the 48 hour acclimation period. Recommended conditioning and acclimation is 75°F and 50% relative humidity.

If you are bonding over an existing substrate that is damaged, the surface may require repair to prevent an uneven appearance of the finished assembly. The Wilsonart technical services team recommends these products for repairing damaged high pressure decorative laminate or wood substrate: J-B Weld[®] WoodWeld, Elmer's[®] Carpenter's[®] Wood Filler, and Bondo[®] All-Purpose Putty. Be sure to read and follow the manufacturer's precautions and directions for use. Sand and clean all repaired areas before applying the Wilsonart RE-COVER laminate.

Approved substrates must be used. They should be clean and free of residue. If bonding to an existing decorative surface, make sure it is adequately cleaned and dried before bonding. Suitable cleaning products include: Wilsonart[®] 110, Wilsonart[®] 121, Wilsonart[®] 130, Wilsonart[®] 131, Wilsonart[®] 131A, acetone, isopropyl alcohol, denatured alcohol, or Windex[®] with ammonia. DO NOT use a cleaner that will leave an oily residue. Allow proper dry time for all approved cleaners. Be sure to read and follow the manufacturer's precautions and directions for use.

To precut Wilsonart RE-COVER laminate prior to bonding, we recommend using carbide tipped saw blades, router bits and laminate slitters. Cutting blades and router bits should be kept sharp and clean. Blades must cut into non-decorative side of laminate (adhesive side). When cutting on a table saw, place laminate face down (adhesive side up) to ensure a clean cut.



INSTALLATION AND FABRICATION GUIDE continued

If you are using multiple sheets of Wilsonart RE-COVER laminate to cover an area, leave a gap between sheets to allow for proper laminate movement. A minimum gap of 1/16" is required between sheets of Wilsonart RE-COVER laminate used in non-environmentally controlled areas. A minimum gap of 1/32" is required between sheets of Wilsonart RE-COVER laminate in environmentally controlled areas.

Wilsonart RE-COVER laminate is not repositionable. Any attempts to reposition the laminate will result in inadequate bonding.

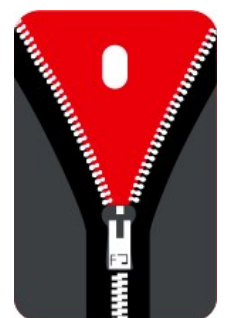
Prior to installation, and before removing the peel sheet that covers the adhesive, dry fit the Wilsonart RE-COVER laminate to the substrate. Once you have indexed the laminate, remove 1"-2" of the peel sheet on one end and lightly tack it in place. Begin removing the peel sheet, making sure the opposite end is still properly aligned. Work your way down the entire length of the laminate sheet until the peel sheet is completely removed and the Wilsonart RE-COVER laminate is flat on the surface. Apply uniform bonding pressure (30-40 psi minimum) over the entire bonded surface using a mechanical pinch roller (recommended) or a 3" wide J-roller. We do not recommend using a wooden block or other hand roller. If the Wilsonart RE-COVER laminate has been positioned incorrectly, it may be removed using a heat gun to soften the adhesive, then pulling the laminate away from the substrate. Once a sheet is removed, it cannot be reapplied. Replace it with a new sheet of Wilsonart RE-COVER laminate.

Extruded edge banding can be handled using any one of the following options:

- 1) Leave extruded edge banding in place, and apply RE-COVER to top surface. This will leave the brown line of the laminate exposed
- 2) Remove extruded type edge banding and replace with laminate edge banding using manufacturer's recommendations. Apply RE-COVER to top surface area.
- 3) Remove extruded edge banding, apply RE-COVER to top surface, and replace edging with the same type of extruded edge banding using manufacturer's recommendations.

A radius may be accomplished by using 735 material only. Using 735 material will allow for a minimum radius of 7 inches.

Once bonded, you can begin machining the Wilsonart RE-COVER assembly immediately. *High tool speed and low feed speed* are recommended for best results. Prior to routing edges, a razor may be used to score the adhesive side of the laminate to prevent the adhesive layer from rolling up during the process. To avoid stress cracking, do not use square-cut inside corners. All inside corners should have a minimum of 1/8" radius. Drill oversized holes for screws or bolts. Screws or bolts should be slightly countersunk into the face side of a laminate clad substrate.



Thanks from the Wilsonart Team for using Wilsonart[®] RE-COVER[™] Laminate. If you have any questions, please call us toll-free at 800-433-3222.