

Kerfkore

A revolutionary **bendable** substrate material that can be laminated flat and then cold formed into virtually any shape.

Kerfkore is the best choice for doing fast and accurate radius work.

Kerfkore provides for smooth and symmetrical inside and outside radii up to 3 1/2"

Kerfkore is a bendable substrate material that allows horizontal or vertical grade laminates, metals, 2-ply and phenolic backed veneers to be laminated flat and then formed into virtually any shape without stress cracks, delaminating or telegraphing.

Kerfkore is a nominal 4'x8' panel size and is available in 1/4", 1/2", 5/8" and 3/4" thicknesses. The core materials include

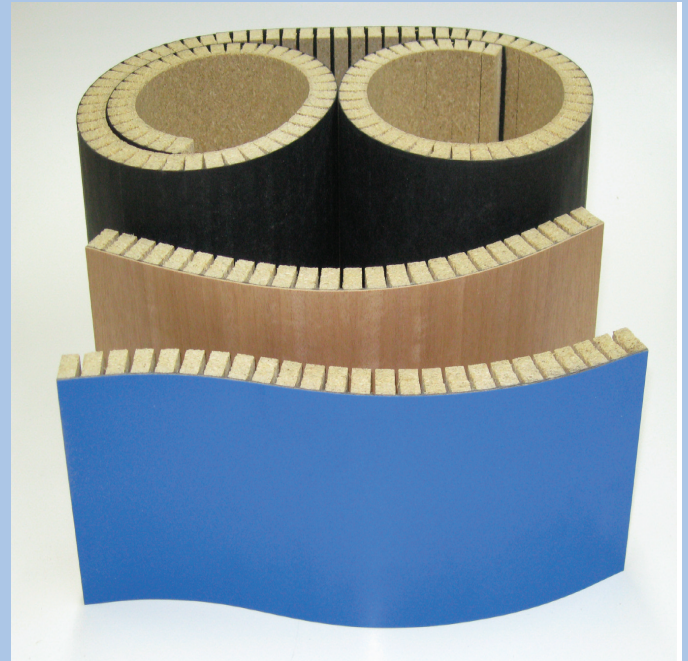


Photo courtesy of: CBR Woodworking

particleboard, MDF, plywood, FR and NAF (no added formaldehyde). The face paper is a black latex impregnated paper and the product is also available with an optional brown phenolic paper backer.

Because of **Kerfkore's** unique construction, excess material can be used on other projects virtually eliminating scrap and saving money.

Kerfkore saves time and improves quality by laminating flat and machining flat prior to bending. It is dimensionally stable and holds its shape when formed with a series of horizontal ribs.

Kerfkore is ideal for production environments where repetitive products are manufactured.

Kerfkore was designed for architectural millwork, furniture, store fixtures, marine and motor coach industries plus applications as vast as one's imagination.

KERFKORE SPECIFICATIONS

PRODUCT DESCRIPTION

Kerfkore is a very flexible product that can be formed into curves and radii as required. **Kerfkore** consists of a core of kerfed particleboard with a flexible latex impregnated paper face and is available in a nominal size of 4' x 8'.

Kerfkore is also available with an optional rigid backing sheet. This two-sided semi-rigid product uses a phenolic impregnated paper backing sheet to keep the material stiff. Once the paper between the kerfs on the back is removed the product will act and perform as desired. This construction is identified with a KK prefix in the item number.

PRODUCT CHARACTERISTICS

Kerfkore allows for the flat lamination of semi-rigid face materials that can then be bent and formed into the needed shape. Materials such as high pressure laminates (vertical, post formable, standard), two-ply veneer, phenolic backed veneer, metal, and other similar material works extremely well with **Kerfkore**. The ability to laminate flat offers the advantages of ease of positioning face material, uniform laminating pressure, labor savings and improved quality. Easy splicing method for additional width or length is simply accomplished by aligning the core material and then applying the face material. After lamination **Kerfkore** can be made rigid by laminating another piece of material to the open side while the part is formed to shape. This is easily accomplished using a vacuum press or other forming method. The use of a PVA adhesive for this lamination is preferred as this will provide a very strong bond. After forming, edge banding can be applied to the open kerfed edges to provide a finished product. Please refer to our website www.kerfkore.com for complete fabrications steps and demonstrations.

CORE OPTIONS

Kerfkore comes standard with a high quality particleboard core. Other core materials are available as required. These options include fiberboard, luan plywood, poplar plywood, FR particleboard, NAF green particleboard and other different core materials.

BENDING CAPABILITIES

The bending radius obtainable using **Kerfkore** is directly related to the material that is applied to **Kerfkore**. Normally a vertical grade laminate or a phenolic-backed veneer will allow an outside radius of 3 1/2" to be obtained on 3/4" Kerfkore. A smaller radius is possible when using 1/4" and 1/2" **Kerfkore**. It is best to pre-test any materials before proceeding.

ADHESIVES

The black latex face paper will accept any contact cement recommended for use with decorative laminates. Use of PVA glue is also acceptable provided it will result in a somewhat flexible glue line. It is recommended to do a test on a small sample to determine compatibility.

LAMINATING PRESSURE

Kerfkore is designed to work with contact adhesive when attaching your face materials. Firm hand pressure or medium pressure with a J-roller works well. The use of a pinch roller is

not required but can be used provided moderate pressure is used. The use of a PVA adhesive with a cold press is also acceptable. When using this method only 30-35 PSI is needed. Applying too high of pressure can cause the glue to reduce the flexibility of the black paper and could affect the bending of the product. Note: Due to possible broad variations in both adhesives and laminates, it is always recommended that a test strip be made to determine the amount of pressure and adhesive coat necessary to achieve the desired results.

TEMPERATURE CONDITIONING

Kerfkore should be acclimated to the same temperature as the decorative face material being applied to it. If available, use the guidelines recommended by the face material manufacturer.

STORAGE

All products should be stored flat with the face material side facing up. Keep in a dry area and away from direct contact with the floor to allow for air circulation.

HANDLING

Kerfkore panels can be rolled into a coil for ease of handling. Keep the black paper face side out when rolling and be careful to keep fingers clear to prevent pinching. The two-sided **Kerfkore** panels may bend towards the black face side during handling. This will not affect the use of the product as the small surface puckers that occur are over the kerfed area between the ribs and will not telegraph through when laminating.

RATINGS AND TEST DATA

Flame Spread Testing Results: **Standard Kerfkore** KK50PB with 48lb. density, 1/2" thick particleboard core has been tested in accordance with ASTM-E84 tunnel test with a general purpose laminate adhered to the surface with a solvent based contact cement. The results of this test were Class B.

KERFKORE CLASSIFICATION AND DIMENSIONS

Item #	Core Material	Panel Size	Nominal Thickness	Actual Thickness	Wt/SF
SK25PB	Particleboard	48" x 96"	1/4"	0.27	1.3 lbs.
SK50PB	Particleboard	49" x 97"	1/2"	0.52	2.0 lbs.
SK62PB	Particleboard	49" x 97"	5/8"	0.65	2.5 lbs.
SK75PB	Particleboard	49" x 97"	3/4"	0.77	3.0 lbs.
SK50LP	Luan Plywood	48" x 96"	1/2"	0.49	1.6 lbs.
SK62LP	Luan Plywood	48" x 96"	5/8"	0.61	1.9 lbs.
SK75LP	Luan Plywood	48" x 96"	3/4"	0.73	2.1 lbs.
SK50PP	Poplar Plywood	48" x 96"	1/2"	0.49	1.1 lbs.
SK62PP	Poplar Plywood	48" x 96"	5/8"	0.61	1.4 lbs.
SK75PP	Poplar Plywood	48" x 96"	3/4"	0.73	1.6 lbs.
SK50FF	NAF Particleboard	49" x 97"	1/2"	0.52	2.0 lbs.
SK62FF	NAF Particleboard	49" x 97"	5/8"	0.65	2.5 lbs.
SK75FF	NAF Particleboard	49" x 97"	3/4"	0.77	3.0 lbs.
KK25PB	Particleboard	48" x 96"	1/4"	0.29	1.3 lbs.
KK50PB	Particleboard	49" x 97"	1/2"	0.54	2.0 lbs.
KK62PB	Particleboard	49" x 97"	5/8"	0.67	2.5 lbs.
KK75PB	Particleboard	49" x 97"	3/4"	0.79	3.0 lbs.

KK item number identifies added phenolic backer for two-sided product