

FLEXGREEN SPECIFICATIONS

PRODUCT DESCRIPTION

FlexGreen is a flexible product designed for use in numerous kinds of radius projects. It consists of an FSC certified Eucalyptus fiber .080" hardboard face that contains no added urea formaldehyde. The core is certified to be 100% recovered and recycled particleboard and contains no added formaldehyde.

PRODUCT CHARACTERISTIC

FlexGreen is a flexible product that can be easily bent and attached to a ribbed frame by the use of glue, nails or staples. **FlexGreen** is designed to be attached to horizontal shaping ribs that will result in a smooth uniform radius. Horizontal ribs spaced about 16" to 24" apart will be needed as this equalizes the bending stresses and will produce a smooth finish surface.

Normal application involves the forming and attachment of **FlexGreen** to a rigid framed structure and then the application of a HPL, metal, PVC or a two-ply face grade veneer by the use of contact adhesive. Do not attach these face materials prior to bending. **FlexGreen** can have a thin face material applied while flat and then bent. The use of single-ply veneer or a paper-backed veneer is preferred for flat attachment using a wet glue application with a cold or hot press. This will provide a very stable veneered panel that can be bent and formed into the desired shape.

BENDING CAPABILITIES

The recommended bending radius obtainable using **FlexGreen** is 10 inches. While a smaller radius may be obtainable, it is best to do a test before proceeding. **FlexGreen** does allow for the flat lamination of a veneer with hot or cold press. After flat lamination a radius of 16-18 inches should be obtainable. A smaller radius may be obtainable depending on the size of the material but it is best to do a test before proceeding.

TEMPERATURE CONDITIONING

FlexGreen should be acclimated the same as the face materials that will be applied to it. If available, use the guidelines recommended by the face material manufacturer.

HANDLING

Care should be taken in handling all materials. The size and weight will usually require two people. When moving material, be careful to pick up in such a manner as to not pinch fingers between the ribs. Try to not over flex the material or bend it past the recommended radius when handling.

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.

ADHESIVES

Any contact cement recommended for use with decorative laminates or other face materials should be acceptable for face attachment. Please follow the adhesive manufacturer's directions to obtain the proper results. Use of other glues is also acceptable for attaching face material provided they can be used after the **FlexGreen** has been formed. As with any product, it is best to do a test on a small sample to determine how the materials will work together.

The kerfed core material can be formed and held in position with the use of most any adhesive and staples when necessary. The preferred method is to apply the glue to the areas being joined and then use staples or clamps to hold in place until the glue cures. The use of horizontal ribs for attachment is preferred, as this will provide the best support to allow the material to achieve the smoothest radius possible. Any vertical rails should be only used to locate the horizontal ribs and be set back about 1/8" from the face of the horizontal ribs. The only time a vertical rib should be used for attachment is when joining two sections of **FlexGreen** together vertically.

LAMINATING PRESSURE

When using contact adhesive, light to moderate pressure is adequate. Firm hand pressure or moderate pressure with a J-roller works well. When using a noncontact glue such as a PVA glue, make sure the glue is transferred to both materials and that adequate uniform pressure can be applied for the required amount of time. Do not apply too heavy of a glue spread as the extra moisture will require additional time to evaporate and cure.

Due to the stable hardboard face on **FlexGreen**, it is possible to laminate flat a single ply veneer or a paperback veneer directly to the hardboard by use of a cold press or hot press. This should be applied with a pressure of 100 psi. It is best to follow the glue manufacturer's recommendations as far as time and temperature requirements. When using this process, the resulting bending radius is approx. 16'-18'. It is always best to first perform a test on the process you plan to use prior to starting your project.

For additional technical information visit our website at: www.kerfkore.com.

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Item #	Nominal Panel Size	Actual Thickness	Wt./SF
FG75PB	48" x 96" x 3/4"	.720	2.4 lbs.
FG75PBX	96" x 48" x 3/4"	.720	2.4 lbs.
FG75PB/10	48" x 120" x 3/4"	.720	2.4 lbs.
FG75PBX/10	120" x 48" x 3/4"	.720	2.4 lbs.