

# ECONOKORE® SPECIFICATIONS

## PRODUCT CHARACTERISTICS

Econokore combines our unique base layer manufacturing process with a 2-ply product design for a flexible and stable base layer that allows for easy attachment of high-pressure laminates, veneers, metals and many other semirigid materials. When using Econokore the decorative surfacing material is applied after the base material has been formed into the desired shape achieving a maximum 10" radius.

## CORE MATERIAL OPTIONS

**Standard Material:** MDF

## FACE MATERIAL OPTIONS

**Standard Material:** High-Density Fiberboard

**Standard Option:** Poplar Plywood

## DECORATIVE SURFACING MATERIALS

High-Pressure Laminates (vertical, post formable, standard)

Veneers

Metal

Paintable

Other Similar Materials

## BENDING RADIUS

**Maximum Achievable Radius:** 10"-12" (Outside Dimension) when using 3/8" Econokore.

**Note:** While a smaller radius may be obtainable, it is best to test before proceeding.

## ADHESIVE OPTIONS

1. Any contact cement recommended for use with laminates or veneers should be acceptable with the use of a J-roller.

**Note:** DO NOT USE RIGID SETTING ADHESIVES such as PVAC, hot melt glue, epoxy, etc. These adhesive systems may cause ridge lines and face fractures.

2. PVA glue is acceptable for attaching decorative surfacing material provided it can be used after Econokore formation.

**Note:** It is best to test on a small sample to determine how the materials will work together before proceeding.

3. When forming a free-standing part, PVA glues and wood glues are acceptable

## SPLICING

Econokore cannot be spliced. For a spliceable material, see Kerfkore.

## DECORATIVE SURFACE APPLICATION PROCESS

The decorative surface should be applied to Econokore after the desired shape has been formed.

## LAMINATING PRESSURE

### Contact Adhesive

Apply contact adhesive to both materials.

Use LIGHT TO MODERATE pressure when bonding the decorative surfacing material to Econokore. Use firm hand pressure or moderate pressure with a J-roller.

### PVA Glue

PVA glue is not recommended because the decorative surface is not meant to be applied before bending.

Note: Due to variations in adhesives and decorative surfacing materials, a test strip should be used to determine the correct amount of pressure and adhesive to achieve the desired results.

Note: Adhesives can be sprayed, brushed, or rolled on. A medium coat of adhesive is suggested. Generally, less adhesive is better than too much.

## RIGID CURVED PARTS

Make freestanding parts (i.e. doors) by gluing a backing sheet to the rib side while it's bent into the desired curve.

Note: Using a PVA glue or wood glue to attach backing sheet will provide a rigid glue bond

Tip: For consistency use a vacuum forming process for an extremely uniform part. Great when consistent repeatability is required.

## EDGE BANDING

The rigid part can be edge banded using contact or PVA glue.

## TEMPERATURE CONDITIONING

Important: Always acclimate Econokore to the same environment as the decorative surface materials that are being used. Two to three days are recommended for conditioning. Use the guidelines recommended by the face material manufacturer.

## HANDLING

Lifting: Requires two people.

Moving: Pick up in a manner to avoid pinching fingers between the grooves.

Important: Do Not over flex the material or bend it past the recommended radius when handling.

## STORAGE

Store flat with the face material side facing up.

To allow for air circulation, keep in a dry area and away from direct contact with the floor.

## RATINGS AND TEST DATA

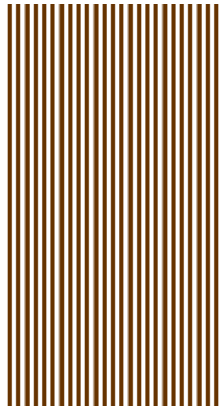
Econokore has approximately the same impact resistance as similar core materials that have not been kerfed.

## FLAME SPREAD TEST

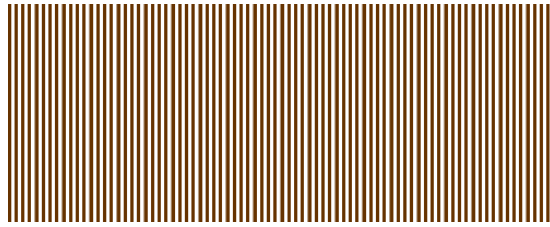
Call 912-264-6496 for additional information.

**BEND TYPE (Rib Direction)**

Note: Product identified as 48" x 96" will bend like a column, 96" x 48" will bend like a barrel



48" x 96"  
Column Bend



96" x 48"  
Barrel Bend

**ECONOKORE CLASSIFICATION AND DIMENSIONS**

Item #	Face Material	Core Material	Nominal Panel Size	Thickness	Weight/Square Foot
EK25FB	HD Fiberboard	MDF	48" x 96"	1/4"	1.0lbs.
EK25FBX	HD Fiberboard	MDF	96" x 48"	1/4"	1.0lbs.
EK38FB	HD Fiberboard	MDF	48" x 96"	3/8"	1.4lbs.
EK38FBX	HD Fiberboard	MDF	96" x 48"	3/8"	1.4lbs.

Additional technical information available at: [www.kerfkore.com](http://www.kerfkore.com).