

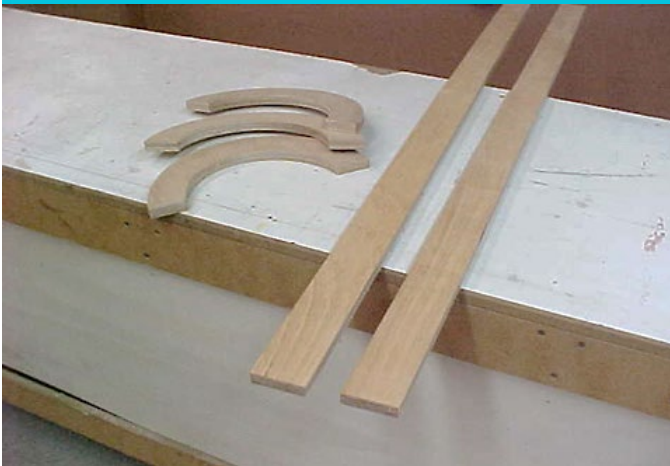
 **KERFKORE**
Flex Education Series
Flexboard®
Column Construction

Flexboard® Columns

For easier handling and fabrication, build half columns. The two half columns can be attached to form a whole column. The longer the column, the more difficult it is to bend. Clamping may be required to allow glue and staples to hold sufficiently. Flexboard is designed to bend to a 10" radius.

Step 1

Cut horizontal ribs as needed. Horizontal ribs should be placed every 15" to 18". Attach vertical rails the length of the column.



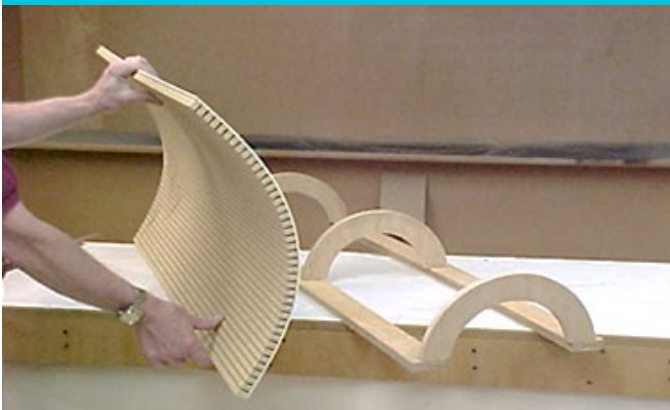
Step 2

Attach horizontal ribs using glue and staples.



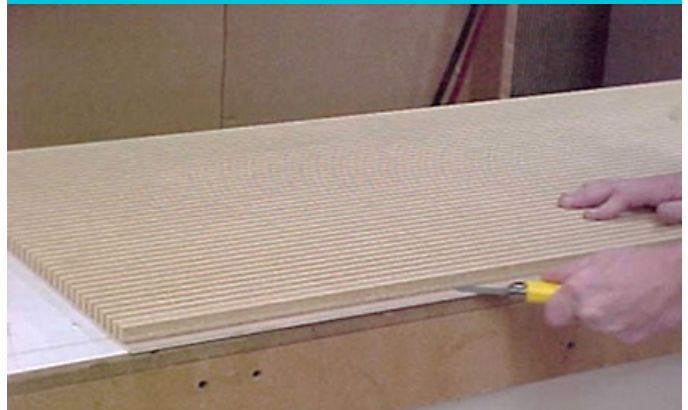
Step 3

Cut Flexboard to cover framework.



Step 4

Use a blade to remove one or two ribs. This will allow for a clean insert attachment to framework.



Step 5

What the panel should look like once ribs have been removed.



Step 6

Apply glue to the framework.

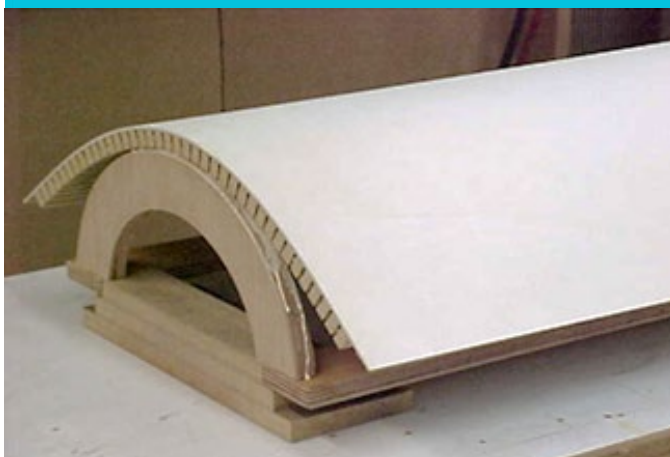


Note

When building a whole column, a spline or biscuit joint can be machined to assemble columns together.

Step 7

Position Flexboard over framework.
Optional: Use of rabbet or dado cuts in the back of the product to help with the location of the product to the framework.



Step 8

Attach by shooting a narrow crown staple through the face of the material into the support ribs.



Step 9

Apply glue to the remaining sides.



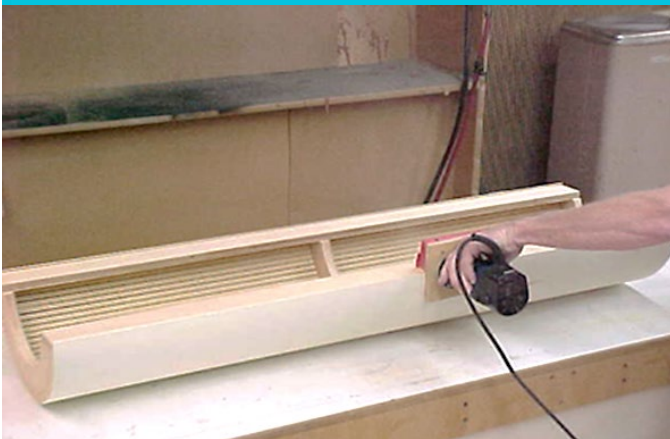
Step 10

Reinforce by shooting staples through the material face into framework. Tip: Clamp the part in place when shooting staples.



Step 11

Once the column is formed, remove excess face material.



Flexboard Laminating

Step 1

Apply contact adhesive to column face.



Step 2

Apply contact adhesive to face material.



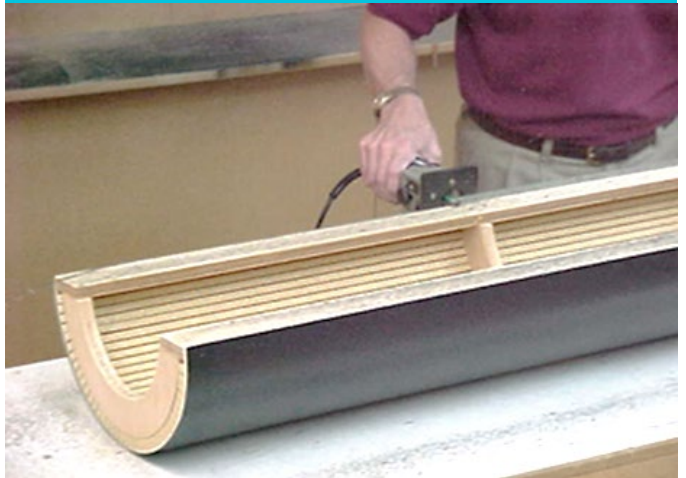
Step 3

Apply and smooth all areas to ensure attachment. (Use a J-roller)



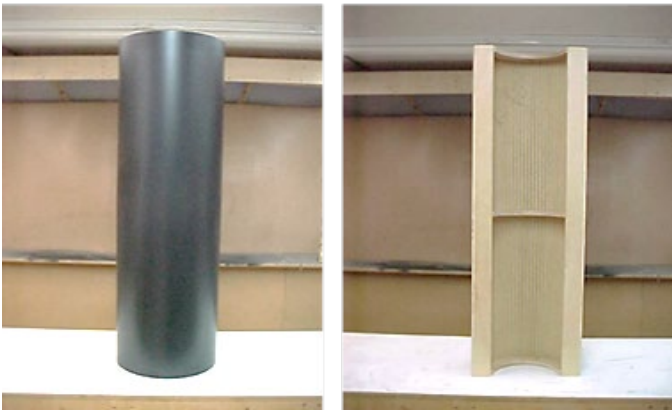
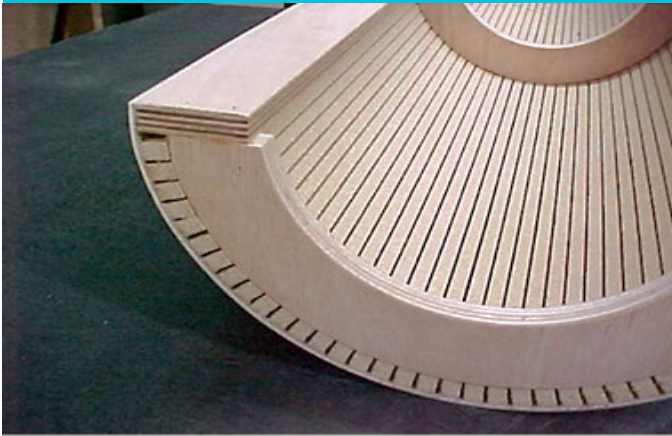
Step 4

Use a router to remove excess material. Smooth rough edges with a file or sandpaper.



Step 5

Results



COLUMNS

- a. Flexboard is designed to a maximum 10" radius
- b. The longer the column, the more difficult it is to bend the material, clamping may be required to allow the glue and staples to hold sufficiently
- c. **RECOMMENDATION:** Construct half columns to make handling and fabrication easier
- d. The two half columns can be attached to form a complete column
- e. For support, place a horizontal support rib every 15" to 18"
- f. Attach vertical support rails the length of the column
- g. **NOTE:** Center support rails may be needed to help form the column frame
- h. Cut Flexboard to cover the framework
- i. Use a narrow piece of Flexboard to determine the correct width necessary to wrap the column frame. This will allow for the thickness of the material being used and provide an accurate length measurement.
- j. Using glue, position Flexboard over the framework ribs
- k. Attach by shooting a narrow crown staple through the face of the material and into the support ribs. **TIP:** Clamp part in place while shooting the staples
- l. Clamps can be removed once the Flexboard is securely attached. The use of rabbet and dado

- cuts in the back of the Flexboard can help in locating material to the framework.
- m. **RECOMMENDATION:** Apply hot melt glue on the inside of the framework to further provide a secure bond between the framework and the material
 - n. After the half column has been formed, edge trimming may be needed to ensure all edges are smooth and square
 - o. Use contact adhesive to attach surface material to the outer face of the column, trim edges as needed
 - p. **TIP:** When producing a column, machine a spline or biscuit joint to attach half columns together. After assembly is complete, column can be covered with a face material. (Fig. 7 and Fig. 8)

