

# FLEXBOARD® SPECIFICATIONS

## PRODUCT CHARACTERISTICS

Flexboard combines our unique base layer manufacturing process with a 0.080 hardboard face to create a flexible and extremely stable base layer that allows easy attachment of high-pressure laminates, veneers, metals and many other semirigid materials. When using Flexboard the decorative surfacing material is applied after the base material has been formed into shape achieving a maximum 8" radius.

## CORE MATERIAL OPTIONS

### Standard Material

High-Quality Particleboard

### Standard Options

MDF

Plywood

### Specialty Options

Fire Rated Particleboard

NAF FSC Particleboard

Other core materials may be available upon request.

## FACE MATERIAL OPTIONS

**Standard Material:** Eucalyptus Hardboard (.080" Thickness)

## DECORATIVE SURFACING MATERIALS

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

Veneers

Metal

Paintable

Other Similar Materials

## BENDING RADIUS

**Maximum Achievable Radius:** 8" (Outside Dimension) when using 3/4" Flexboard.

**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 a single ply veneer or a 10mil paper backed veneer provided that Flexboard is being laminated flat. See decorative surface application process below for more information.

**Note:** Test a small sample to determine how materials will work together before proceeding.

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

## SPLICING

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

## DECORATIVE SURFACE APPLICATION PROCESS

To achieve a maximum radius, apply the decorative surface after the desired shape has been formed. The decorative surface can also be applied to Flexboard while flat and then formed into desired shape.

**Note:** This is only possible if using a single ply veneer or 10mil paper backed veneer.

**Minimum achievable radius:** 16" (Outside Dimension) with Flexboard laminated flat.

## LAMINATING PRESSURE

### Contact Adhesive

Apply contact adhesive to both materials.

Use LIGHT TO MODERATE pressure when bonding decorative surfacing material to Flexboard.

Use firm hand pressure or moderate pressure with a J-roller.

### PVA Glue

If applying a decorative surface to Flexboard while flat, apply PVA glue to one side only, either the decorative surfacing material or the Flexboard material will work.

Adequate uniform pressure should be applied.

Recommended Pressure: 100 psi

Drying Time & Temperature: Use glue manufacturer's recommendations.

**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 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:** Use a vacuum forming process for an extremely uniform part. Great when repeatability is required.

## EDGE BANDING

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

## TEMPERATURE CONDITIONING

**Important:** Always acclimate Flexboard to the same environment as the decorative surfacing 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

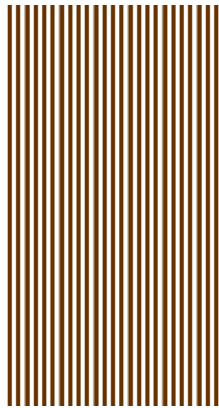
Flexboard has approximately the same impact resistance as similar core materials that have not been kerfed.

## FLAME SPREAD TEST

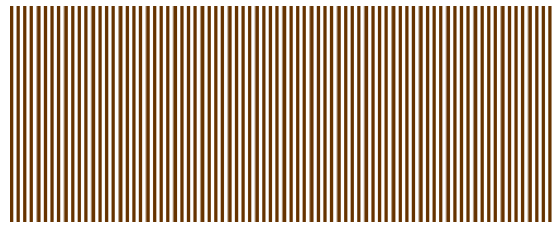
Call 912-264-6496 for additional information.

## 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

## FLEXBOARD CLASSIFICATION AND DIMENSIONS

Item #	Core Material	Nominal Panel Size	Thickness	Weight/Square Foot
FB50PB	Particleboard	48" x 96"	1/2"	2.2lbs.
FB50PBX	Particleboard	96" x 48"	1/2"	2.2lbs.
FB62PB	Particleboard	48" x 96"	5/8"	2.2lbs.
FB62PBX	Particleboard	96" x 48"	5/8"	2.2lbs.
FB75PB	Particleboard	48" x 96"	3/4"	2.4lbs.
FB75PBX	Particleboard	96" x 48"	3/4"	2.4lbs.

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