



KERFKORE® SPECIFICATIONS

PRODUCT CHARACTERISTICS

Kerfkore combines our unique base layer manufacturing process with our LTX Black™ Flexible Backer to create a highly flexible and extremely stable base layer that allows for fast and easy attachment of high-pressure laminates, veneers, metals and many other semirigid materials. When using Kerfkore the decorative surfacing material can be applied while flat and then formed into the desired shape achieving a maximum 3 1/2" 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: LTX Black Flexible Backer

Kerfkore is also available with an optional rigid backing sheet.

DECORATIVE SURFACING MATERIALS

High-Pressure Laminates (vertical, post formable, standard)
Two-Ply Veneer
Phenolic Backed Veneer
20mil Paper Backed Veneer
Metal
Other Similar Materials

BENDING RADIUS

Maximum Achievable Radius: 3 1/2" (Outside Dimension) when using 3/4" Kerfkore.
2 1/2" (Outside Dimension) when using 3/8" Kerfkore.
2" (Outside Dimension) when using 1/4" Kerfkore.

Note: Bending Radius is directly related to the decorative surface material being applied to Kerfkore. While a smaller radius may be obtainable, it is best to test before proceeding.

PRECAUTIONS

Note: Although Kerfkore makes bending semi-rigid materials easier, care must be taken especially in cool conditions. Most of these materials become more brittle when cold. Always condition decorative surfacing material to the manufacturers recommended temperature for fabrication prior to bending.

ADHESIVE OPTIONS

1. Any contact cement recommended for use with decorative laminates or veneers should be acceptable when using a J-Roller (Solvent or water-based system are both satisfactory)

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 when using a press machine.

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

For additional width or length, align separate sections of Kerfkore and then apply the decorative surface material. This will create much larger pieces that can be produced and shipped by the factory.

DECORATIVE SURFACE APPLICATION PROCESS

The decorative surface should be applied to Kerfkore while flat and then formed into the desired shape.

LAMINATING PRESSURE

Contact Adhesive

Apply contact adhesive to both materials.

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

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

DO NOT OVERPRESS! Over pressing can cause ridge lines and stress cracks to occur. (The reason only light or moderate pressure is required is that once the decorative surface material is laminated to Kerfkore and it is bent, it “pulls” itself down evenly over the entire radius, providing the proper amount of contact pressure over the radiused surface.)

PVA Glue

Apply glue to one side only, either decorative surfacing material or Kerfkore material will work.

The use of PVA adhesive with a cold press is recommended.

Adequate uniform pressure should be applied.

Recommended Pressure: 30-35 PSI

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

Note: Applying with a pressure that is too high can reduce the flexibility of the LTX Black Flexible Backer and may affect the bending radius.

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 necessary 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

After decorative surfacing lamination, Kerfkore can be locked into shape by gluing a backing sheet to the rib side while it is bent into the desired shape.

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 Kerfkore to the same environment as the decorative surfacing materials that are being used. Use the guidelines recommended by the face material manufacturer.

HANDLING

Roll into a coil for ease of handling

Keep the LTX Black Flexible Backer on the outside when rolling

Be careful to keep fingers clear of grooves to prevent pinching

Note: Panels may bend towards the LTX Black Backer side during handling. This will not affect the product, the small surface puckers that occur will not cause telegraphing on the finished product.

STORAGE

Store flat with the LTX Black Flexible Backer material facing up

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

RATINGS AND TEST DATA

Kerfkore is not recommended for wet applications.

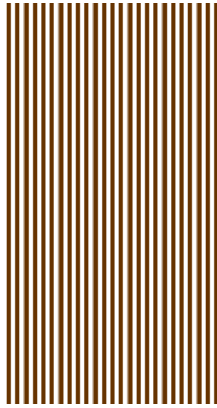
Kerfkore has approximately the same impact resistance as similar core materials that have not been kerfed.

FLAME SPREAD TEST

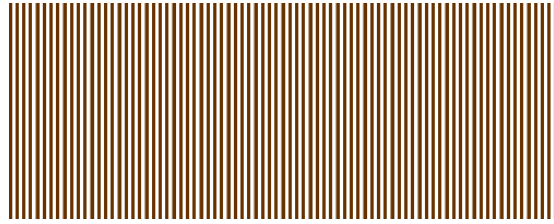
Call 912-264-6496 for additional information.

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

KERFKORE CLASSIFICATION AND DIMENSIONS

| Item # | Core Material | Nominal Panel Size | Thickness | Weight/ Square Foot |
|--------|---------------|--------------------|-----------|---------------------|
| SK50PB | Particleboard | 49" x 97" | 1/2" | 2.0lbs. |
| SK62PB | Particleboard | 49" x 97" | 5/8" | 2.5lbs. |
| SK75PB | Particleboard | 49" x 97" | 3/4" | 3.0lbs. |

Additional technical information available at: www.kerfkore.com.