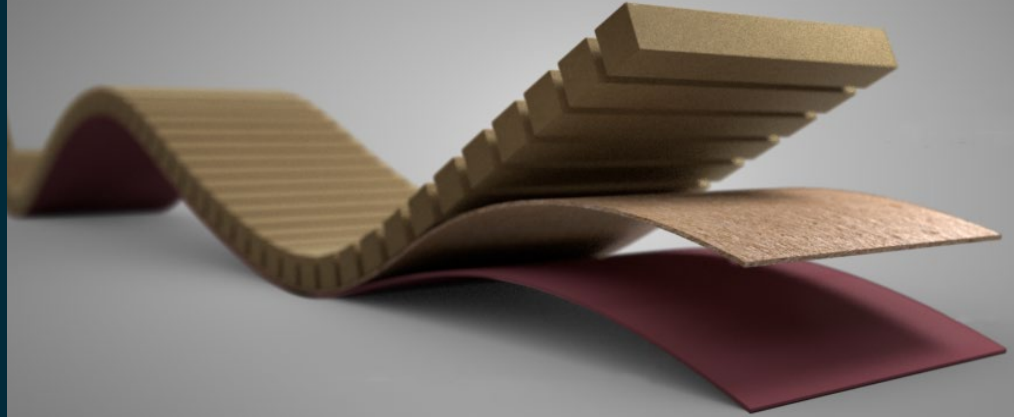


## SPECIFICATION SHEET

### ECONOKORE®

- ✓ Flex Bending Radius 10"
- ✓ Stable Base Layer
- ✓ Form First, Then Laminate
- ✓ Edgeband Ready



## MATERIALS



### FACING

HD Fiberboard



### CORE

MDF



### DECORATIVE SURFACE

- High-Pressure Laminates
- Veneers
- Metal
- Leather
- Paints
- Other Similar Materials

## THICKNESS

	1/4"	3/8"
MDF	✓	✓

## NOMINAL PANEL SIZE

	48" x 96"	96" x 48"
MDF	✓	✓

## STANDARD ECONOKORE PRODUCTS

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

For other thickness sizes and material options, contact us at [912.264.6496](tel:912.264.6496)

## STORAGE & HANDLING

**Proper Air Circulation** – Store flat with HD Fiberboard side facing up in a dry area away from direct contact with the floor.

To prevent pinching, keep fingers clear of grooves.

**Temperature Conditioning** - Acclimate Econokore to the same environment as the decorative surfacing materials. Two to three days recommended for conditioning. Use guidelines recommended by the decorative surfacing manufacturer.

**Note:** Do not over flex the material or bend past the recommended radius when handling.

## TESTING

Cannot be used in wet applications.

**Impact Resistance** - Approximately the same as unkerfed core material.

**Flame Spread Test** - Call 912-264-6496 for additional information.

## BEND TYPE (RIB DIRECTION)



48" x 96"  
Column Bend



96" x 48"  
Barrel Bend

# DECORATIVE SURFACING APPLICATION METHODS

## J-ROLLER APPLICATION

### Equipment Needed

- Econokore panel
- Decorative surface material
- J-Roller
- Contact cement (solvent or water-based)
  - ❗ **DO NOT USE RIGID SETTING ADHESIVES** (i.e. PVAC, hot melt glue, epoxy, etc.)
- Sprayer, brush, or roller
- Tack cloth

### Forming

- a) Framework Attachment - Bend Econokore to desired shape and attach to framework.
- b) Rigid / Free-Standing Part - Attach a backing sheet to the rib side to lock Econokore into desired shape. Use PVA or wood glue. For maximum consistency and uniformity, use a vacuum forming process.

- ❗ Surfacing materials become more brittle when cold. Always condition decorative surfaces to the manufacturer's recommended temperature prior to bending.

### Prep

1. Remove all dust and debris from panel surface

### Application

1. Adhesive Application – Use a sprayer, brush, or roller to apply a medium coat of contact adhesive to both decorative and Econokore surface.
  - Tip:** Less adhesive is generally better than too much. Use a test strip to determine the correct amount of pressure and adhesive.
2. Decorative Surface Application
  - a) Use LIGHT TO MODERATE pressure with initial placement/positioning of the decorative surfacing material to Econokore.
  - b) Use firm hand pressure or moderate pressure with a J-Roller.

**DO NOT OVERPRESS!** Over pressing can cause ridge lines and stress cracks.

### Finishing

**Dry Time & Temperature** - Follow glue manufacturer's recommendations.

**Finishing** – Using a router, remove unwanted decorative surface material.

**Note:** If edgebanding by hand, use contact adhesive. If using an edgebanding machine, use PVA glue.