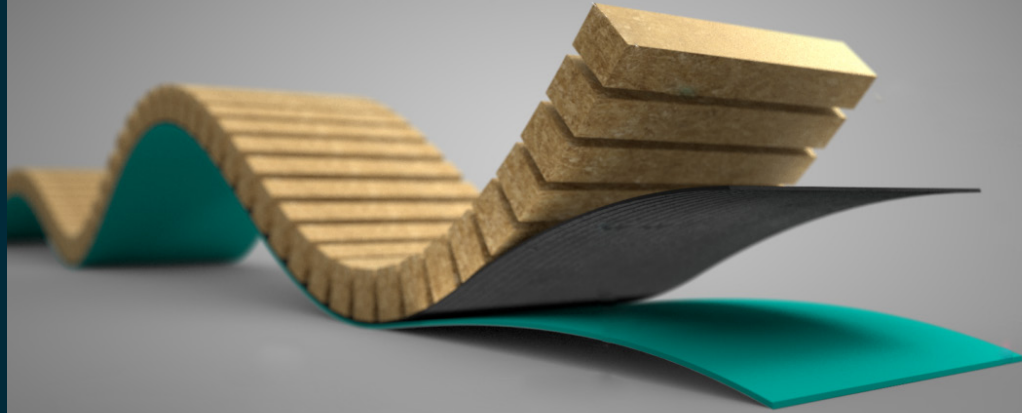


## SPECIFICATION SHEET

### SOFLEX™

- ✓ Dynamic Bending Radius 3 1/2"
- ✓ Stable Base Layer
- ✓ Laminate Flat, Then Form
- ✓ Edgeband Ready



## MATERIALS



### FACING

LTX Black Flexible Backer



### CORES

- Standard Particleboard
- MDF
- Plywood
- Fire Rated Particleboard 
- NAUF Particleboard 




### DECORATIVE SURFACE

- High-Pressure Laminates
- Two-Ply Veneer
- Phenolic Backed Veneer
- 20mil Paper Backed Veneer
- Metal
- Leather
- Other Similar Materials

## THICKNESS

	1/4"	3/8"	1/2"	5/8"	11/16"	3/4"
Particleboard		✓	✓	✓		✓
Plywood			✓	✓		✓
MDF	✓	✓	✓	✓		✓
NAUF Particleboard 					✓	✓

## NOMINAL PANEL SIZE

	48" x 96"	49" x 97"	61" x 97"	48" x 120"	48" x 144"
Particleboard		✓	✓	✓	✓
Plywood	✓				
MDF	✓			✓	✓
NAUF Particleboard 		✓			

## STANDARD SOFLEX PRODUCTS

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

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 black side facing up in a dry area away from direct contact with the floor.

**Handling** – When rolling into a coil, keep the black side facing out.

To prevent pinching, keep fingers clear of grooves.

**Temperature Conditioning** - Acclimate Soflex 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:** During handling, creasing may occur if Soflex is bent towards the black side. This will not cause telegraphing on the finished product.

## 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

- Soflex 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

### 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 Soflex 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 Soflex.
  - 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.

### Forming

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

**Note:** Maximum Bending Radius is directly related to the flexibility of decorative surface material. While a smaller radius may be obtainable, it is best to test before proceeding.

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

# DECORATIVE SURFACING APPLICATION METHODS

## PRESS MACHINE APPLICATION

### Equipment Needed

- Soflex panel
- Decorative surface material
- Hydraulic or vacuum press
- PVA glue
- Sprayer, brush, or roller
- Tack cloth

### 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 PVA glue to either the decorative or Soflex 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

Place Soflex product with decorative surface in the press.

Recommended Uniform Pressure: 30-35 PSI

Exceeding pressure recommendation can affect flexibility and bending radius.

### 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.

### Forming

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

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