



NEWS
UPDATE 1.9

EN

PVA BONDING

SIBU | DESIGN
we decorate.



PVA bonding of SIBU DESIGN sheets

Following pre-treatment, non-adhesive design sheets from the DECO-LINE, ACRYLIC-LINE, SIBUGLAS, LEATHER-LINE and STRUCTURE-LINE series (with a few exceptions, please see the product list) can be bonded using standard PVA adhesive (white glue).

ADVANTAGES

As a result of this type of processing, standard plastic, aluminium or wood edge trims can be used! This is because the PVA adhesive prevents the usual expansion of our design sheets due to the effects of heat. Consequently, the design sheets can be used for problem-free, edge-to-edge applications.



Positioning of PVA label with date

PVA pre-treatment

In order that our sheets are suitable for PVA bonding, depending upon their thickness, they must either be subjected to an additional pre-treatment, or be roughened. Please see the product list.

PRE-TREATMENT

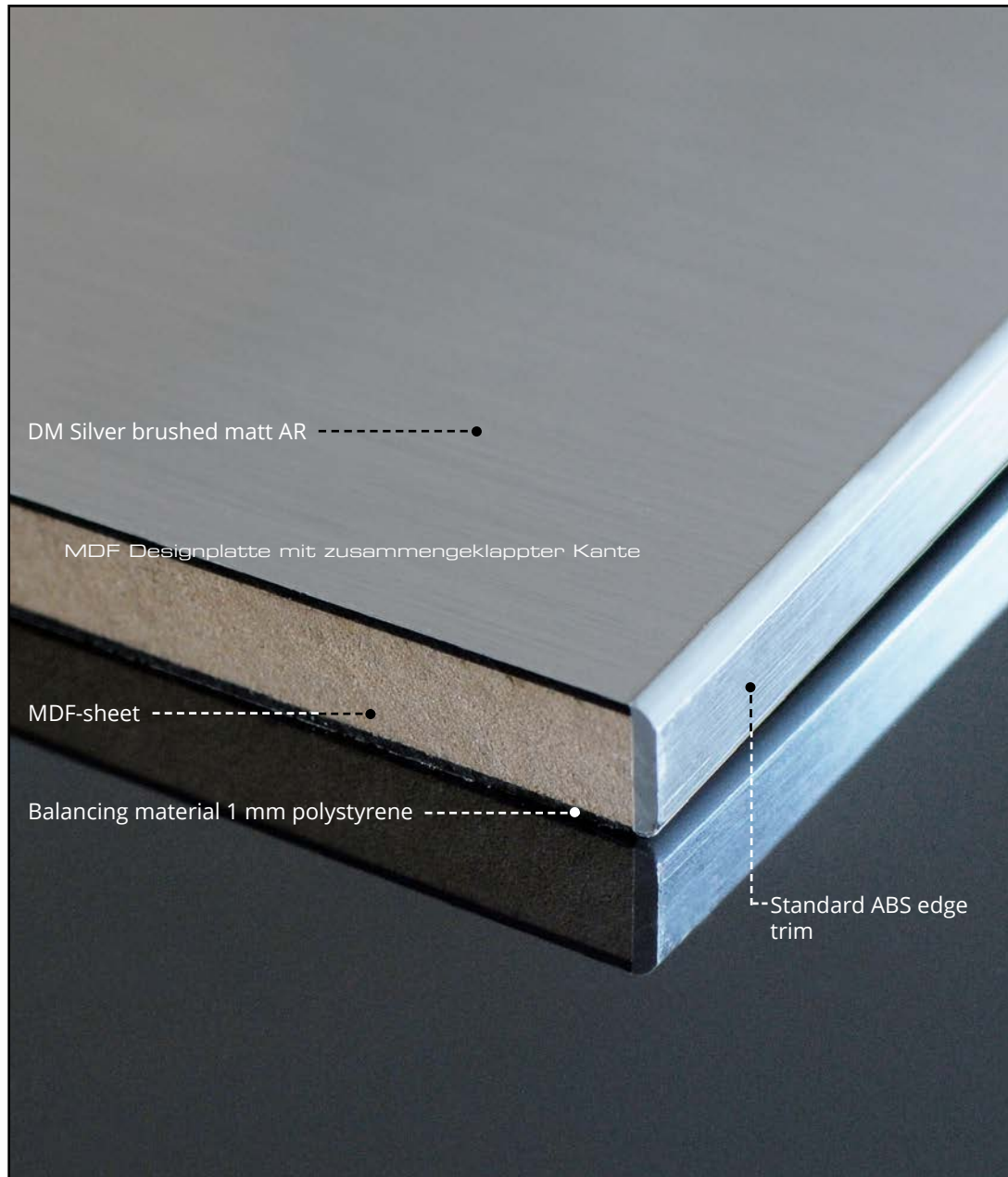
As this special pre-treatment is not a standard procedure, a PVA pre-treatment requirement must be stated upon ordering. In line with the product, pressing must take place within a period of two or six months following the delivery date. Each design sheet bears a label confirming its suitability for PVA bonding. The date on the label marks the beginning of the period for use.

SANDING OF THE REVERSE SIDE

SIBU DESIGN testing was carried out with 80-grain sandpaper.

This procedure is to be completed by the customer.

Should any questions arise, please contact our sales team!



Cross-section of PVA bonding

PROCESSING

Both of the pressing sheets have to be cleaned thoroughly prior to beginning the working process. The material from the wood sheet must be brushed or blown off.

It is imperative that the reverse side of the design sheet is clean and dust-free before pressing starts and therefore it is recommended that gloves be worn in order to avoid any negative effects to the reverse side. Check the surfaces for any damage prior to pressing.

Pre-treated SIBU design sheets can be easily bonded onto smooth, absorbent wood surfaces (untreated chipboard, MDF) using a panel press. The adhesive may only be applied to flat wood sheets.

The acclimatised SIBU design sheets, the backing panel and the wood base sheet should be laid out next to one another on a flat, clean and sufficiently large work-table. The cut wood base sheet must be roughly 10 cm larger than the SIBU design sheet. Firstly, the two SIBU design sheets are to be generously covered with adhesive using a glue roller. They should then be positioned in the middle of the wood base sheet virtually simultaneously. No adhesive should be applied directly to the wood base sheet as this can have a negative effect upon flatness.

SIBUGLAS

Owing to the highly absorbent reverse side of the SibUGlas sheet, PVA white lime consumption is higher. Approximately 200-300 g/m² are required. The synthetic fibres should demonstrate a wet, adhesive shine shortly before bonding.

PRESSING

When pressing the design sheets, a medium-hard sponge rubber mat with a thickness of approx. 5 mm should be used between the pressing sheet and the patterned side of the design sheet. This provides uniform pressure distribution and at the same time prevents undesirable pressure spots caused by particles of dirt between the pressing sheet and the design sheet. However, when using smooth design sheets, it is better to complete pressing without the sponge rubber mat, as this can cause the surface to appear uneven. In order to achieve a smooth surface, enquire about our 2mm-thick design sheets.

WARNING! When pressing mirror or high-gloss products, an undamaged and clean pressing sheet is essential.

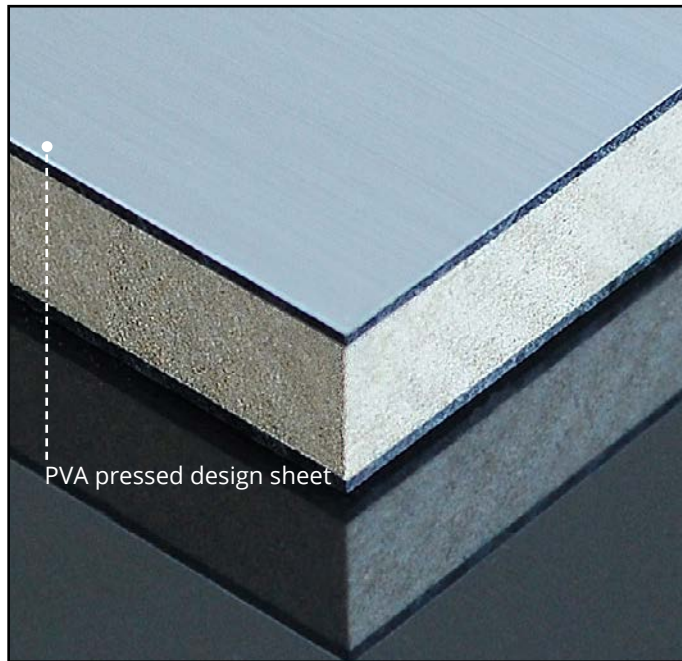
Should the design sheet not have a crease-free protective film due to transport and storage conditions, this must be removed prior to pressing. The pressure applied should amount to 2 kg/cm² (0.2 N/mm²), the temperature to approx. 45°C and the pressing time to around 15 minutes (SIBUGLAS: 30°C, 30min).

During pressing onto an untreated particle board in 16 mm thickness, best results were achieved with a 1 mm polystyrene balancing sheet. SL LINEA products require a polystyrene balancing sheet with a thickness of 1.5mm. For Sibuglas AR+ (PMMA 2 mm) we recommend the use of the PX Balance Sheet PMMA White 2800x1250x2 (article number: 20278) for balancing.

Following pressing allow the sheets to cool over night (approx. 16 hours) in a stack. Cover the stack with a 19 mm-plate so that the uppermost sheet also remains flat.

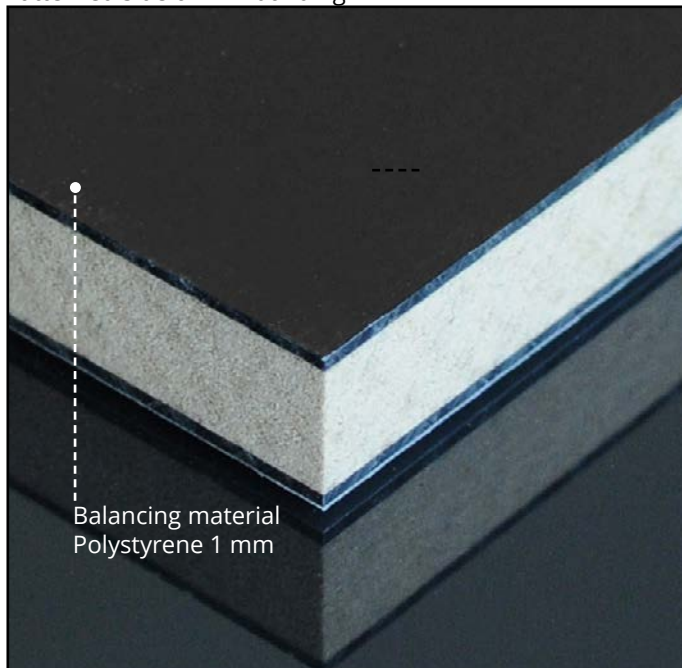
The patterned side should be uppermost, i.e. visible. The protective film should only be removed when the workpiece has been finished, as it serves as a safeguard during transport. Should the protective film be removed in advance, take care that adhesive packing tape never comes into contact with the patterned surfaces.

The finished pressed design sheet can be easily cut with a saw and subsequently fitted with standard plastic, aluminium or wood edge trims.



PVA pressed design sheet

Patterned side of PVA bonding



Balancing material
Polystyrene 1 mm

Back side of PVA bonding



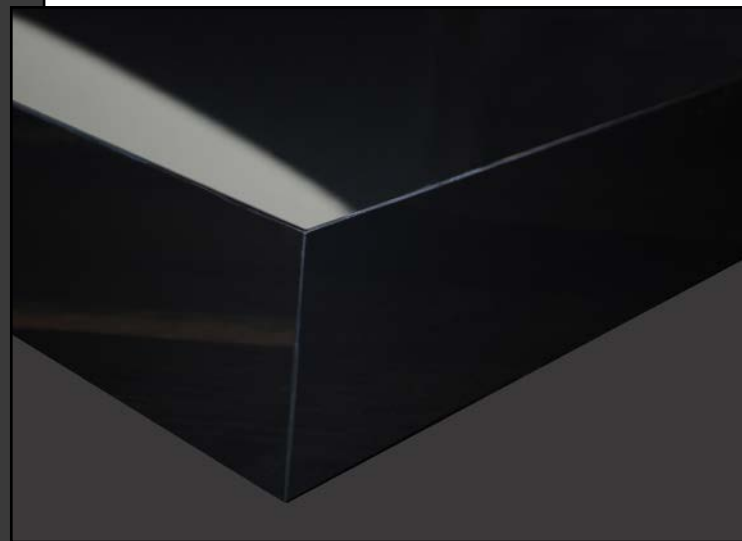
Presenter with PVA bonded surface

RECOMMENDATION

For the PVA bonding of our design sheets with either a mirror surface (DM Silver, DM Gold, DM Anthracite, etc.), or our high-gloss surfaces (DM Magic Black, DM Magic White), we recommend the use of the 2mm- thickness. This will improve the visual effect of the surface. When 2mm-thick mirror and high-gloss products are employed, the thickness of the polystyrene balancing sheet also has to be increased to 2mm.

SIBUGLAS

SibuGlas AR+ products can be bonded without PVA pre-treatment. For more detailed information please see the SibuGlas-Infos Update 1.8 Page 12-14.



Detail view: PVA bonded DM Magic Black 2 mm

ADHESIVE INFORMATION

The wet bonding time, working life, adhesive hardening time, application quantity/consumption should be read on the respective adhesive information sheet. The instructions on the adhesive container are to be regarded as supplementary.

Information concerning the PVA adhesives tested according to DIN or ÖNORM EN 204:

Fa. H.B. Fuller Austria GmbH, Kaplanstraße 30, 4600 Wels, Austria,
Tel.: +43/7242-409-0, Fax: +43/7242 409-349 Internet: www.hbfuller.com

RAKOLL Express 50, PVAc adhesive, stress-group: DIN EN 204 - D2

RAKOLL GLX3, PVAc adhesive, stress-group: DIN EN 204 single-component without hardener, D4 with RAKOLL GLX-3-hardener.

Fa. Henkel Central Eastern Europe GmbH, Erdbergstr. 29, 1030 Wien,
Austria Tel.: +43/1-711 04-0, Internet: www.henkel-cee.com

LEIFA PV/H standard joiner's adhesive, PVAc D2 adhesive, DIN EN 204 - D2
stress pursuant to EN 204, 30 kg container.

LEIFA PV/H D3 water-resistant, joiner's adhesive, PVAc D3 adhesive, D3 stress
group pursuant to EN 204, 10 kg and 30 kg containers.

Synthesa Chemie GmbH, Dirnbergerstraße 29-31, 4320 Perg, Austria Tel.:
+43/7262/560-0, Fax: +43(0)7262/560-1500,
E-Mail: office@synthesa.at, Internet: www.synthesa.at

Syntunit Rapid, PVA D2 adhesive, ÖNORM EN 204 - D2 stress group, 12 kg and 30
kg containers.

Syntunit F, PVA D3/D4 adhesive, ÖNORM EN 204 - D3 stress group,
single-component without hardener, D4 with WA 34 hardener. 0,25 kg, 1 kg, 5 kg,
12 kg, 30 kg, 650 kg and 1000 kg containers.

Design panels pre-treated for PVA bonding (6-month processing period):

deco-line	DM Magic Black AR DM Magic White AR DM Silver/white DM Silver DM Silver H23 DM Silver AR23 DM Silver MMS DM Gold MMS DM Gold DM Gold 30 DM Gold brushed matt AR DM Anthracite DM Brown DM Bronze DM Champagne DM Brass DM Rose DM Iceblue DM Skyblue	DM Copper DM Fashion Red DM Galaxy Silver DM Fashion Grey DM Silver brushed DM HGS DM Champagne brushed DM Titan brushed DM Copper brushed DM Brass brushed matt AR DM Smoke PF met DM Silver PF met DM MONSOON Vintage Brown DM Vintage Silver DM Vintage Copper DM LUXURY Bronze DM LUXURY Gold DM LUXURY Silver DM Hollywood	DM Aqua DM LUXURY Holografico DM Classy Black AR DM Classy Bronze AR DM Classy Copper AR DM Classy Gold AR DM Classy Silver AR DM Iron Age AR DM Silent Gold AR DM CEMENT Dark DM CEMENT Light DM MARBLE White DM Travertin DM Magic White matt AR DM Magic Black matt AR DM OXIDIZED Copper AR DM OXIDIZED Silver AR DM OXIDIZED Nickel AR DM OXIDIZED Platin AR	DM OXIDIZED Titan AR DM OXIDIZED Autumn AR DM METALLIC USED Titan AR DM METALLIC USED Silver AR DM METALLIC USED Bronze AR DM METALLIC USED Sand AR DM METALLIC USED Steel AR DM METALLIC USED Ivory AR DM METALLIC USED Champagne AR DM SLIGHTLY USED Copper AR DM SLIGHTLY USED Bronze AR DM SLIGHTLY USED Gold AR DM SLIGHTLY USED Titan AR DM REFINED Metal Silver AR DM REFINED Metal Titan AR
wood-line	WL Wenge Wood WL Nutwood	WL Nutwood Country WL Maple Alpine	WL Carbonized Wood	
structure-line	SL SQUARE 3 HGS SL CROCO Silver PF met/Silver SL LAVA Copper	SL IMPACT Vintage Silver SL IMPACT Antique Bronze SL RACE Vintage Silver/Bronze	SL RACE Vintage Copper/Silver SL CRASHED Mirror Silver SL CRASHED Old Platin	
leather-line	LL LEGUAN Silver LL LEGUAN Gold LL LEGUAN Copper LL LEGUAN Nero	LL LEGUAN Bianco LL LEGUAN Silk LL PELO Marabu LL PEARL RAY Gold		
acrylic-line	AC MOTION ONE White AC MOTION ONE Black	AC MOTION TWO White AC MOTION TWO Black		

Design panels requiring sanding of the reverse side for PVA bonding:

leather-line / structure-line	LL COLLAGE Oro SL CROCO Smoke PF met/Silver
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Design panels pre-treated for PVA bonding (2-month processing period):

leather-line	LL FLORAL White LL FLORAL Black/Silver matt LL FLORAL White/Silver matt LL FLORAL White/ Gold matt LL FLORAL Vintage Silver/Silver	LL PERSIAN Gold LL PERSIAN Metallic LL Charcoal Dark LL Charcoal Light LL Dove Tale	LL London Clay LL Stony Ground LL CORD Stony Ground LL CORD Dove Tale LL CORD Charcoal Light
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Design panels suitable for PVA bonding without special pre-treatment:

SibuGlas	All designs from the SibuGlas AR+ range are suitable for PVA bonding.
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Design panels, which cannot be PVA bonded:

leather-line / translucent-line / deco-line / punch-line / punch-line 3D	LL ROMBO 40 Bianco matt LL ROMBO 40 Creme LL ROMBO 40 Nero matt LL ROMBO 85 Bianco matt LL ROMBO 85 Creme LL ROMBO 85 Mocca matt LL ROMBO 85 Nero matt LL QUADRO Bianco matt LL QUADRO Creme	LL QUADRO Nero matt LL QUADRO Luxury Bronze CR CRISTAL ROMBO 85 Bianco matt/Silver TL LINEA 104x62 Old Platin TL LINEA 104x62 Silent Gold PL 3D ROSES Pearl White PF/Gold PL 3D ROSES Silver PF met/Silver PL 3D Q 10-40-40 Silver PF met/Silver PL 3D Q 10-40-40 Smoke PF met touch1/Silver matt	PL 3D Q 5-15-15 Black touch 1/Silver PL 3D Q-10-30 Old Platin/Silver PL 3D H-10-30 Pearl White PF/Gold PL Q 5-15-15 Silver PF met
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all items from the MS product group

If the patterned sheets are not pressed within the stated period for processing, we recommend a check on the surface tension of the reverse side and if necessary, its subsequent surface treatment.

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