

SPECIFICATION SHEET

ECONOKORE®

- **⊘** Form First, Then Laminate



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

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.

BEND TYPE (RIB DIRECTION)



48" x 96"
Column Bend

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.



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)
 - (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 intial 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.