

SPECIFICATION SHEET

FLEXBOARD®

- ✓ Flex Bending Radius 8"
- ✓ Stable Base Layer
- ✓ Form First, Then Laminate
- ✓ Edgeband Ready



MATERIALS



Eucalyptus Hardboard



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




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

THICKNESS

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

NOMINAL PANEL SIZE

	48" x 96"	96" x 48"	48" x 120"	120" x 48"
Particleboard	✓	✓	✓	✓
Plywood	✓	✓		
MDF	✓	✓		
NAUF Particleboard 	✓	✓	✓	✓

STANDARD FLEXBOARD PRODUCTS

Item #	Core Material	Nominal Panel Size	Thickness	Weight/Square Foot
FB50PB	Particleboard	48" x 96"	1/2"	2.2lbs
FB50PBX	Particleboard	96" x 48"	1/2"	2.2lbs
FB62PB	Particleboard	48" x 96"	5/8"	2.7lbs
FB62PBX	Particleboard	96" x 48"	5/8"	2.7lbs
FB75PB	Particleboard	48" x 96"	3/4"	3.2bs
FB75PBX	Particleboard	96" x 48"	3/4"	3.2lbs

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 Hardboard 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 Flexboard 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 PROCESS

There are **two methods** to laminate Flexboard. To achieve a maximum radius of 8", form Flexboard first into desired shape and then apply decorative surface. The decorative surface can also be applied to Flexboard flat and then formed into desired shape achieving a 16" radius.

DECORATIVE SURFACING APPLICATION METHODS

J-ROLLER APPLICATION

METHOD 1:

1. Form First
2. Then Laminate

Maximum Radius: 8”

Application Tools: J-Roller Only

Equipment Needed

- Flexboard 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 Flexboard to desired shape and attach to framework.
- b) Rigid / Free-Standing Part - Attach a backing sheet to the rib side to lock Flexboard 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 Flexboard 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 Timberflex.
 - 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.

DECORATIVE SURFACING APPLICATION METHODS

J-ROLLER APPLICATION

METHOD 2:

1. Laminate Flat
2. Form Into Desired Shape

Maximum Radius: 16"

Application Tools: J-Roller or Press Machine

Equipment Needed

- Flexboard panel
- Decorative surface material
- **i** **ONLY** use single ply or 10mil paperbacked veneers
- J-Roller
- Contact cement (solvent or water-based)
- **i** **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 Flexboard 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 Flexboard.
 - 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 Flexboard to desired shape and attach to framework.
- b) **Rigid / Free-Standing Part** - Attach a backing sheet to the rib side to lock Flexboard 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.

- **i** 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

METHOD 2:

1. Laminate Flat
2. Form Into Desired Shape

Maximum Radius: 16"

Application Tools: J-Roller or Press Machine

Equipment Needed

- Flexboard panel
- Decorative surface material
 - ⓘ **ONLY** use single ply or 10mil paperbacked veneers
- 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 Flexboard 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 Flexboard product with decorative surface in the press.

Recommended Uniform Pressure: 100 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 Flexboard to desired shape and attach to framework.
- b) **Rigid / Free-Standing Part** - Attach a backing sheet to the rib side to lock Flexboard into desired shape. Use PVA or wood glue. For maximum consistency and uniformity, use a vacuum forming process.

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