

**General Information And Requirements****Types Of Veneer**

WalzCraft sells the following five types of “thin” veneer materials which rely entirely on adhesive for installation:

- 1) Resin Backed Veneer
- 2) Wood Backed Veneer
- 3) Paper Back Veneer (No Adhesive)
- 4) Wood Backed Veneer with Pressure Sensitive Adhesive (PSA)
- 5) Paper Back Veneer with Pressure Sensitive Adhesive (PSA)

If instructions for proper application are followed, each of these materials will result in a lasting, high quality installation.

**General Requirements For Installation**

Veneer sheets, and the substrate they are being applied to, should be stored in the same environment for 5 days prior to installation to ensure that the moisture content is in equilibrium. Extreme temperature and humidity fluctuations will effect both the veneer and the substrate. If the veneers are rolled up in a shipping carton, they should be removed from the carton during this acclimation period. Both the veneer and the substrate must be smooth, clean, dry and free of grease, dirt, dust, oil or any other foreign matter.

**Types Of Adhesive To Use**

The best way to apply veneers is in a vacuum press, cold press, or hot press using PVA white or yellow glue. If press equipment is not available, please follow these adhesive recommendations:

**Resin Backed Veneer**

The material that WalzCraft sells is either *Duraback®*, *PolyBak*, or *PolyLam Resin Backed* veneer, depending on the wood species. The adhesive for applying this material may be either a water based or solvent based contact cement.

**Wood Backed Veneer (Non-Adhesive)**

Water based or Solvent based contact cement is recommended for this application.

**Paper Back Veneer (Non-Adhesive)**

Water based or Solvent based contact cement is recommended for this application.

**Wood Backed Veneer with Pressure Sensitive Adhesive (PSA)**

Supplied with 3M 468 pressure sensitive adhesive applied to the back of the sheet. Often referred to as “Peel and Stick.”

**Paper Back Veneer with Pressure Sensitive Adhesive (PSA)**

Supplied with 3M 468 pressure sensitive adhesive applied to the back of the sheet. Often referred to as “Peel and Stick.”

**Application Of Veneer Using Contact Cement**

It is important to remember that when using contact cement, you are using a flexible adhesive designed to glue a rigid overlay such as plastic laminate. With a veneer sheet, you are using a flexible adhesive to glue a flexible overlay. Because of this it is necessary to use a different method of application than that used with plastic laminate.

**A) Always Use 100% Coverage**

Always use 100% coverage on both the back of the veneer sheet and the face of the substrate. As a rule, use twice (2 times) as much adhesive as when you are gluing plastic laminate.

**B) Let the Adhesive dry down...*Don't Rush!***

Let the adhesive have the right amount of dry down time. You don't want to trap gases that can later cause blisters. The time can vary depending on ambient moisture, air flow around your work area and ambient temperature. Check with the adhesive supplier for a dry down time that is correct for your conditions.

**C) A Proper Bond Will Only Be Achieved With Adequate Pressure**

The desired bond is an intimate bond. This is a bond that makes two pieces one. It can be reached only when two things are present; adhesive and pressure. The right amount of adhesive has to be used or all the pressure in the world will mean nothing. An ample amount of pressure is required to hold your pieces together long enough for the adhesive to do its job. When contact adhesive is being used, you will need a lot of pressure all at one time. This pressure can be reached by using either of the two Veneer Smoothing Tools offered by WalzCraft. (WalzCraft Part #156872 or #171376).

Starting at the center of the surface to be bonded, pull the smoothing tool toward you going with the grain. Apply pressure with both hands, pushing down as hard as possible. Keep doing this as you move over 3-4 inches at a time until you have smoothed down the entire surface. If working with a prefinished veneer, protect the finished surface with a thin piece of material, like a piece of plastic laminate. The pressure you exert will transfer through.

**Do Not Use A J-Roller To Apply Sheet Veneer.**

A J-roller will not apply enough pressure to achieve an intimate bond. In most cases, the use of a J-Roller will result in a series of blisters, every 16"-20", when rolling out a full sheet of veneer. This is the distance at which the point of pressure is lost due to the extension of your arms.

**D) Allow 4 to 6 Hours Before Finishing and Apply Finish In Stages**

If your veneers are unfinished and you are finishing them after lamination, please remember this fact: Wood expands when moisture is added to it and contracts when moisture is removed. Allow 4 to 6 hours before applying finish over veneer adhered with contact cement. This will give the contact adhesive an opportunity to establish a stronger bond and also allows any residual solvents from the adhesive to escape. Be sure to apply sealer coats in stages. A sealer coat sprayed in a very fine mist using multiple coats is better than one heavy coat. Avoid flooding the surface all in one coat. When you apply a heavy amount of finish, all at once, over sheet veneer glued with contact cement, you risk movement of the sheet which could result in cracks in the finish or delamination of the veneer.

**Application Of Veneer using Pressure Sensitive Adhesive (PSA)****Remove Memory and Acclimatize**

Remove memory and acclimatize the veneer sheet by laying it flat between two sheets of plywood on the jobsite where it will be applied. 5 days is the recommended acclimatization period. The ideal temperature is between 70 and 80 degrees and the ideal relative humidity is 35%.

**Test The Surface**

Testing the surface you are applying veneer to, prior to application, is highly recommended. The surface must be clean, dry and smooth. The surface must be free of grease, wax or dust. PSA will stick to surfaces that are varnished, lacquered or enameled, provided they are not flaking or peeling. PSA generally will not stick to bare wood, sanding sealers, melamine or other plastics. PSA requires 48-72 hours to achieve its maximum strength bond.

**Prepare The Surface**

- 1) Use Denatured Ethyl Alcohol to wipe down the surface of the substrate to remove any grease, dust or wax.
- 2) Uniformly scuff the substrate with 100-150 grit no fill sandpaper.
- 3) Wipe the surface with a tack rag after sanding so it is dust free.
- 4) Re-wipe the surface with denatured Ethyl Alcohol.

**Apply The Veneer and Apply Pressure To Make Bond**

Align the veneer sheet with the substrate surface and pull back two inches of the release paper. Allow the veneer to make contact with the substrate and make certain the alignment is correct. Slowly peel back the release paper while applying optimum pressure with either of the two Veneer Smoothing Tools offered by WalzCraft. (WalzCraft Part # 156872 or #171376). Constant pressure must be applied over the entire surface. Pull the tool toward you while going in the same direction as the grain and applying as much downward pressure as possible. If working with a prefinished veneer, protect the finished surface with a thin piece of material, like a piece of plastic laminate. The pressure you exert will transfer through.

**Do Not Use A J-Roller To Apply Sheet Veneer.**

A J-roller will not apply enough pressure to achieve an intimate bond. In most cases, the use of a J-Roller will result in a series of blisters every 16"-20" when rolling out a full sheet of veneer. This is the distance at which the point of pressure is lost due to the extension of your arms.

**Allow 24 Hours Before Finishing and Apply Finish In Stages**

If your veneers are unfinished and you are finishing them after lamination, please remember this fact: Wood expands when moisture is added to it and contracts when moisture is removed. Allow 24 hours before applying finish over veneer adhered with PSA. Be sure to apply sealer coats in stages. A sealer coat sprayed in a very fine mist, using multiple coats, is better than one heavy coat. Avoid flooding the surface all in one coat.