

### General Information And Requirements

#### Types Of Refacing Materials

WalzCraft offers the following types of refacing materials which rely entirely on adhesive for installation:

##### Non Adhesive

Resin Back Veneer  
Wood Back Veneer  
Paper Back Veneer  
Paintable Laminate  
3D Laminate / RTF Phenolic Back  
Decorative Laminate Veneer (DLV)  
1/8" & 1/4" Plywood  
1/8" Raw HDF  
7/32" Raw MDF  
1/4" MDF-MR(Moisture Resistant), NAF  
Solid Wood Refacing Stock - 1/8", 3/16", 1/4"

##### Pressure Sensitive Adhesive (PSA) - Peel & Stick

Wood Back Veneer  
Paper Back Veneer  
Paintable Laminate  
3D Laminate / RTF  
Decorative Laminate Veneer (DLV)

#### Types Of Adhesive To Use

The best way to apply full 4' x 8' sheets of refacing materials is in a vacuum press, cold press, or hot press using PVA white or yellow glue. If press equipment is not available, please follow the below adhesive recommendations:

##### **Non Adhesive Refacing Materials**

The adhesive for applying this material may be either a waterborne or solvent based contact cement.

##### **Pressure Sensitive Adhesive (PSA) - Peel & Stick**

Supplied with pressure sensitive adhesive applied to the back of the sheet.

#### General Requirements For Installation

Remove memory and acclimatize  
Prepare the surface  
Test the surface  
Apply the refacing material with adequate pressure to create a proper bond  
Always use 100% coverage with contact cement  
Let the adhesive dry down...Don't Rush!  
Allow proper amount of time before finishing and apply finish in stages

##### **\*\*Do Not Use A J-Roller To Apply Refacing Materials\*\***

*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 refacing material. This is the distance at which the point of pressure is lost due to the extension of your arms.*



If instructions for proper application are followed, each of these materials will result in a long lasting, high quality installation. Please refer to the adhesive manufacturer's application instructions.

**Application Of Non Adhesive Refacing Materials Using Contact Cement**

*Please refer to the adhesive manufacturer's application instructions*

**Remove Memory and Acclimatize**

Remove memory and acclimatize the refacing materials by laying it flat between two sheets of plywood on the job site 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%.

**Prepare The Surface**

- 1) Use Denatured 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 Alcohol.

**Test The Surface**

Prior to application, testing the surface you are applying refacing materials to is recommended to be sure of adhesion if it is in question.

**Always Use 100% Coverage**

Always use 100% coverage on both the back of the refacing materials sheet and the face of the substrate. Multiple coats may be required on porous surfaces. If dried surface has a glossy appearance, sufficient adhesive has been applied.

**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.

**Apply the Refacing Material with Adequate Pressure to create a Proper Bond**

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). **Do Not Use A J-Roller To Apply Refacing Materials**

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 refacing material, protect the finished surface with a thin piece of material, like a piece of plastic laminate. The pressure you exert will transfer through.

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

If your refacing materials 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 wood 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 in one coat.

**Application Of Refacing Materials Using Pressure Sensitive Adhesive (PSA)**

*Please refer to the adhesive manufacturer's application instructions*

**Remove Memory and Acclimatize**

Remove memory and acclimatize the refacing materials by laying it flat between two sheets of plywood on the job site 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%.

**Prepare The Surface**

- 1) Use Denatured 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 Alcohol.

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. It is recommended that you first seal the surface with contact cement. Always use 100% coverage on the face of the substrate. Multiple coats may be required on porous surfaces. 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. If dried surface has a glossy appearance, sufficient adhesive has been applied. Check with the adhesive supplier for a dry down time that is correct for your conditions.

PSA requires 48-72 hours to achieve its maximum strength bond.

**Test The Surface**

Prior to application, testing the surface you are applying refacing materials to is highly recommended.

- The surface must be clean, dry and smooth.
- The surface must be free of grease, wax or dust.

**Apply the Refacing Material with Adequate Pressure to create a Proper Bond**

Align the refacing materials with the substrate surface and pull back two inches of the release paper. Allow the refacing material 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 refacing material, 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 Refacing Materials**

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

If your refacing materials 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 refacing materials 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 in one coat.