

FORMICA® LAMINATE BY FORMICA GROUP / BACKING SHEETS

TECHNICAL DATA



PRODUCT DESCRIPTION

Phenolic resin-treated kraft papers are consolidated in a press at high pressures. The sheet back is sanded to maintain a uniform thickness and facilitate bonding.

RECOMMENDED APPLICATION

GRADE 91/BKL

Formica® brand backing sheet 91/BKL is intended for interior application to the backside of panels clad with Formica brand vertical grade decorative laminate to prevent moisture absorption and minimize warpage.

GRADE 99/BKH

Formica brand backing sheet 99/BKH is intended for interior application to the backside of panels clad with Formica brand horizontal grade decorative laminate to prevent moisture absorption and minimize warpage.

FABRICATION AND ASSEMBLY

LIMITATIONS

Formica brand backing sheets are designed for interior use only. Do not adhere directly to plywood, plaster, drywall (gypsum board), or concrete. Do not use in areas exposed to temperatures exceeding 275°F (135°C) or for exterior applications. Backing sheets are not intended for use on the decorative face of any application.

STORAGE

Backing sheets should be stored horizontally, with the top sheet turned face down and a caul board or other protective sheet placed on top to protect the material from possible damage and reduce the chance of warpage of the top sheets.

Backing sheets should be protected from moisture, and should never be stored in contact with the floor or an outside wall. Optimum conditions for storage are approximately 75°F (24°C), and 45% to 55% relative humidity.

PRECONDITIONING

Prior to fabrication, allow face laminate, backing sheet, and the substrate to acclimate for at least 48 hours at the same ambient conditions. Optimum conditions are approximately 75°F (24°C), and relative humidity of 45% to 55%. Provisions should be made for the circulation of air around the materials.

SUBSTRATES

Formica brand backing sheets should be bonded to an appropriate substrate, such as Medium Density Fiberboard (MDF) or a #45 density particleboard (CS 236-66: Type 1, Grade B, Class 2). The use of plywoods is discouraged whenever possible due to the potential for stress crack, shrink-back, and surface telegraphing problems. The substrate should be sanded smooth, and should be clean, free of oil or grease, and uniform in thickness.

ADHESIVES

Contact, semi-rigid (PVAc), or rigid (urea, resorcinol) adhesives may be used. Follow the adhesive manufacturer's recommendations. Certain combinations of finish, substrate, and adhesive can cause telegraphing. To minimize warpage, use the same adhesive for face and back laminates.

ASSEMBLY

Material, equipment, and workmanship should conform to the industry standard practices, conditions, procedures, and recommendations as specified by ANSI/NEMA LD3-1995, Section 4, Architectural Woodwork Quality Standards, DLPA (Decorative Laminate Products Association) and ANSI 161.2-1979 standards.

Always align sanding marks in the same direction.

Formica brand backing sheets can be sawed, drilled, routed, and fabricated using standard carbide-tipped cutting tools.

All inside corners of cutouts must be radiused as large as possible, 1/8" (3.18mm) minimum, to avoid stress cracking. The edges and corners should be routed, sanded, or filed smooth and free of chips or nicks.

TECHNICAL DATA

Performance compliance of Formica Brand Backing Sheets:

ANSI/NEMA STANDARDS PUBLICATION — LD3-2005

PHYSICAL PROPERTIES	LD3 TEST	FORMICA® BRAND GRADE 99/BKH	BACKING SHEET GRADE 91/BKL
Thickness – in	n/a	0.042"	0.020"
– mm		1.0mm	0.5mm

CODES AND SPECIFICATIONS

FORMICA BRAND BACKING SHEET, GRADE 91/BKL

- U.S. Federal Specification, LP508-H, Style ND, Type IV
- International Organization of Standardization, ISO 4586-2

FORMICA BRAND BACKING SHEET, GRADE 99/BKH

- U.S. Federal Specification, LP508-H, Style ND, Type IV
- International Organization of Standardization, ISO 4586-2

FIRE TEST DATA — ASTM E-84

Fire test data for selected panel assemblies using Formica brand decorative face laminate incorporating Formica brand backing sheets are listed in the *Postforming and General Purpose Laminate Technical Data* sheets. Test reports are available upon request.

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TECHNICAL DATA CONTINUED



SIZES AND FINISHES

GRADE 91/BKL

Natural Finish (-00)

Dull, utility finish inherent with materials and press method. Natural finish is not intended for use on the decorative face of any application.

Sizes

Width: 48" (121.9cm), 60" (152.4cm)
Length: 96" (243.8cm), 120" (304.8cm), 144" (365.8cm)

GRADE 99/BKH*

Natural Finish (-00)

Dull, utility finish inherent with materials and press method. Natural finish is not intended for use on the decorative face of any application.

Sizes:

Width: 48" (121.9cm), 60" (152.4cm)
Length: 96" (243.8cm), 120" (304.8cm), 144" (365.8cm)

*Available on a factory order basis

COLORS

Dark brown, inherent with materials and press methods.

Samples are available from Formica Corporation specification representatives or directly from Formica Corporation. Call 1-800-FORMICATM for ZIP-CHIP™ service.

HOW TO SPECIFY

Backers shall be Formica brand backing sheets produced by Formica Corporation, Cincinnati, Ohio.

GRADE

FINISH

Natural (00)

SIZE

All backing sheets shall meet the minimum performance standards of the International Organization of Standardization, ISO 4586-2, and National Electrical Manufacturers Association, ANSI/NEMA LD3-1995. Note to specifier: For U.S. Government projects, refer to Federal Specification LP508-H, Style ND, Type IV.

USE AND CARE

Formica brand backer sheets are a utility grade and not intended for use where maintenance is required. They may be wiped clean with a clean, non-abrasive, damp cloth and mild liquid detergent or household cleaner. More stubborn dirt, grease or adhesive spills may be removed with lacquer thinner or contact adhesive solvents.

LIMITED WARRANTY

Formica Corporation expressly warrants that, for a period of one (1) year from the date of first sale, these products will be reasonably free of defects in materials and workmanship, and that when properly handled and fabricated, will conform, within accepted tolerances, to applicable manufacturing specifications. This limited warranty applies only to Formica® brand backer sheets that are stored, handled, fabricated and installed in the manner recommended by Formica Corporation. Due to the variety of uses and applications to which these products may be put, **FORMICA CORPORATION CAN MAKE NO WARRANTY THAT THIS PRODUCT IS SUITABLE FOR ANY PARTICULAR PURPOSE AND CAN MAKE NO OTHER WARRANTIES, EXPRESS OR IMPLIED, OTHER THAN THOSE SET FORTH ABOVE.**

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TECHNICAL DATA CONTINUED



MANUFACTURER

Formica Corporation
10155 Reading Road
Cincinnati, Ohio 45241-5279

TECHNICAL SERVICES

Technical assistance may be obtained through your local Formica® Brand Products Distributor or from Formica Corporation trained representatives in sales offices throughout the country. To assist these representatives, Formica Corporation maintains a sales and technical services staff in Cincinnati, Ohio. For technical assistance, contact your distributor or sales representative; write the company directly at Formica Corporation Technical Services Department, 10155 Reading Road, Cincinnati, OH, 45241; call (513) 786-3578 or 1-800-FORMICA™; or fax (513) 786-3195. In Canada, call 1-800-363-1405. In Mexico, call (525) 530-3135.

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GreenGuard Environmental Institute

Formica® high-pressure laminate (HPL) is GreenGuard Indoor Air Quality Certified under the GreenGuard Standard for Low-Emitting Products.

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