



Formica DecoMetal[®]

Metal Laminate & Solid Metal

POSTFORMING TECHNICAL DATA

RECOMMENDED APPLICATION

Postforming

Grade 82 is a special formula phenolic-backed metal laminate that can be heat postformed to radii as tight as 3/8" (9.5mm). The postforming process is similar to Formica[®] brand laminate, except the temperature is lower. 275° F (135° C) is the ideal temperature. Lower temperatures than 275° F (135° C) could cause cracking of the phenolic core, whereas higher temperatures can cause delamination and bubbling between aluminum foil surface and the phenolic core. Heater temperature, time of exposure to the heater, and the reflectance of the aluminum are some of the factors to consider. Since equipment can vary, it is recommended to test these conditions prior to fabrication using Tempilaq[®] temperature indicator. Refer to Formica DecoMetal[®] Technical Data (Form No. 08-101 (02/00)) for more information on substrate selection, storage and limitations.

SENSITIVE PAINT

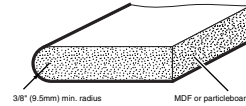
Leave peelfilm on during postforming.

1. Radius core materials.
2. Bond Grade 82 Formica DecoMetal to the core material with a neoprene contact cement which has been formulated for postforming.
3. Apply at 275° F (135° C) temperature-sensitive paint (such as Tempilaq[®]) to the back of the Formica DecoMetal sheet in an inconspicuous place in the area to be radiused. *Note: Always apply the temperature sensitive paint in the oversized or off fall area, as the paint will telegraph through.*
4. Leaving the peelfilm on the face, place the area to be formed over the heater, face down. Hold over heater until temperature-sensitive paint indicates.
5. Quickly remove from heat source and form into fixture until cool. Remove from fixture and jay roll.

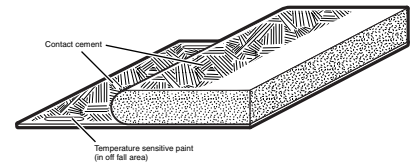
Grade 83 Cold Forming

Formica DecoMetal solid metals can be cold formed and bent using sheet metal fabrication techniques. Sheet metal brakes and pipe rollers can be used to shade the metal prior to bonding to substrates.

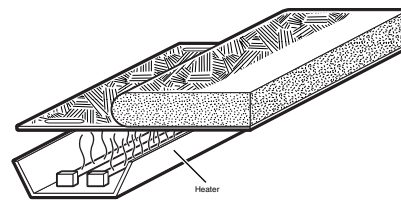
For 3/8" (9.5mm) radius, the above technique for Grade 82 can be used, skipping steps three and four (no heat required). *Note: Very tight radii, less than 1/8" (3.1mm), can crack the anodized finish. Always test first.*



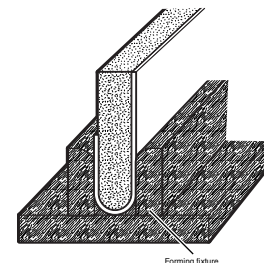
Storyboard illustration 1



Storyboard illustration 2



Storyboard illustration 3



Storyboard illustration 4

USE AND CARE

Formica DecoMetal metal laminate and solid metal may be cleaned with a damp cloth and mild detergent or citrus cleaner. If in doubt about the suitability of a particular cleaner or detergent, check with its manufacturer. Use of abrasive cleaners, powders, scouring pads, steel wool, sandpaper, etc., will damage the finish. Acid or alkaline-based cleaners, compounds, solvents, etc., will mar, etch, corrode, and permanently discolor Formica DecoMetal products. Never use these materials on Formica DecoMetal items, nor allow bottles, rags, etc., contaminated with them to contact the surface. Accidental spills or splatters from these harsh materials should be wiped off immediately, and the area cleaned thoroughly with a damp cloth.

Examples of these materials are:

drain cleaners	coffeepot cleaners
ceramic cooktop cleaners	chlorine bleach
some countertop cleaners	rust removers
metal cleaners	tub and tile cleaners
oven cleaners	toilet bowl cleaners

Use hexane, heptane, Formica® Brand #203 Adhesive Remover or citrus cleaner to remove contact adhesive overspray.

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 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) 786-3048 or 1-800-FORMICA™; or fax (513) 786-3195. In Canada, call 1-800-363-1405. In Mexico, call (525) 530-3135.

LIMITED WARRANTY

Formica Corporation expressly warrants that, for a period of one (1) year from the date of first sale, Formica DecoMetal® metal laminate & solid metal 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 only applies to Formica DecoMetal items which are stored, handled, fabricated and installed in the manner recommended by Formica Corporation. Due to the variety of uses and applications to which Formica DecoMetal 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, EXPRESSED OR IMPLIED, OTHER THAN THOSE SET FORTH ABOVE.**

Buyer's exclusive remedy for any loss or claim resulting from the use or inability to use this product shall be replacement of the defective Formica DecoMetal item, or at the option of Formica Corporation, return of the product and refund of the purchase price. **IN NO EVENT SHALL FORMICA CORPORATION BE LIABLE IN EITHER TORT OR CONTRACT FOR ANY LOSS OR DIRECT, SPECIAL, INCIDENTAL, CONSEQUENTIAL OR EXEMPLARY DAMAGES.**

This limited warranty gives the purchaser of Formica DecoMetal products specific legal rights. Other rights may be available which vary from state to state.

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