

1	DESCRIPTION
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Type: Decolam is a jointed sheet of veneer pressed onto a paper which was impregnated with a phenolic resin. This way we become a sturdy sheet that is still flexible enough for slightly curved surfaces. Decolam can be glued onto any kind of wooden substrate and is therefore very suitable to manufacture doors or other furniture components. It is not recommended to glue Decolam on solid wood. Decolam is always pre-sanded with a 150 grain but the surface has not yet been treated and must still be protected by the processor (oil or varnish). Ease of use is undoubtedly the biggest asset of this product.

Thickness: backing: 0,4 mm; veneer: 0,6 mm⁽¹⁾

Splicing method: bookmatch splicing, other techniques upon request

Finishing: pre-sanded grain 150

Bending radius: maximum 150 mm

Applications: This product is ideal for laminating the most common wooden substrates and for (re)decorating doors. Decolam is slightly bendable and can therefore be used to decorate large arches. Postforming is not possible. Maximum radius = 50mm.

Sizes: regular size = 3050x1300x1mm / 4'x10'x1/25" ; doorsize = 2150x1000x1mm / 3'x7'x1/25";
Tolerance on dimensions: ± 20mm; Tolerance on flatness: 60mm/m

Possible additional surface treatments by the manufacturer: upon request Decolam can be treated with a soft brushing "B1" or rough cut look "S1". Also a surface finish with an acrylate UV varnish with very low VOC emissions can be applied. Decolam can also be stained and lacquered with a matte finish ex works. Please note that special prices and minimum order quantities apply. Ask your contact person at Decospan for more information.

Storage:

It is advisable to keep Decolam in a dry place with a constant temperature of at least 18°C and maintain a constant relative humidity between 50% and 60%. The products should be acclimatized for 7 days before processing. We recommend to store Decolam horizontally, face-to-face. Avoid direct contact with the floor. The top layer of Decolam is real wood veneer, which is likely to discolour over time. Therefore, always store Decolam in a dark place or cover the sheets so that they are not exposed to light. Occasionally, Decolam is delivered in a cardboard package (parcel service). We recommend that you remove the sheets as quickly as possible from this package and store them flat as described previously. Thus, problems with the processing of the laminates are avoided. Be aware of the sharp edges when manipulating Decolam and always carry the sheets with 2 people.

¹ Keep in mind that this is the thickness of the veneer before we process it. The final thickness may vary.

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Application:

Always apply Decolam on both sides of the core you wish to ennoble to ensure a good stability. It is possible to use another type of backing that matches the characteristics of Decolam. Whenever chosen, any responsibility of the manufacturer expires. Under all circumstances, it is recommended to test the adhesion and stability before proceeding to full production.

Decolam, glue, substrates and finishing products should be stored in the same area or at least at the same temperature and humidity for at least 48 hours. The recommended temperature is at least 18°C and the relative humidity is between 50% and 60%. If these parameters are not respected, this can lead to ridges between the Decolam and the substrate.

Decolam can be manually glued with contact glue or in a press (hot, max 70°C, and cold). Always pay carefully attention to the instructions of the glue manufacturer. When using a spray-gun it is recommended to spray several thin layers instead of 1 thick layer onto both the Decolam and the substrate, with the necessary waiting time between the different layers. If the gluing is done by a press, then it is recommended to use a PVCA-glue or a UF-glue.

Before applying the glue, ensure that all surfaces are free of grease, dust and other dirt. The surface can be cleaned efficiently by denaturized ethyl alcohol. For contact glue it is important that the glue is applied on both surfaces. If using a glue spatula, apply the glue on one surface at right angles to the other.

Start to press from the middle of the board (never begin from the sides). Once the two surfaces are making contact they can be properly pressed by using a roller with two grips. Use body weight for maximum pressure. Never use a hammer and block or rollers with only one grip!

Finishing: Decolam can be finished like any other wood veneered board. It is preferable to leave 4 or 5 days between gluing and finishing Decolam to be sure that all the solvents from the glue have disappeared. Make sure the surface is clean and polished with the correct abrasive technique. Always follow the instructions of the supplier of stain/lacquer/oil.

2 TECHNICAL DATA MANUFACTURER

Thickness of the top layer	EN 14354	0,6 mm
Deviation of thickness	EN 14354	≤ 0,3 mm
Deviation of squareness	EN 324-2	± 5 mm/m
Tolerance on flatness	-	60 mm/m
Tolerance on dimensions	-	± 20 mm
Cup in width direction	EN 14354	5 %
Flatness deviation	EN 14354	5 %
Veneer gluing adhesion	EN 204/205	≥ 1 N/mm ²
Density	EN 323/EN672	1300 kg/m ³
Moisture content	EN 322	5 % - 9 %

3	OTHER DOCUMENTS
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- MSDS
- Pure Wood Charter
- FSC® Certificate
- PEFC Certificate

4	CONTACT DETAILS
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In case of clarity or additional questions, please contact Decospan NV.

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