



Technical Data Sheet

Formboard Overlay

May 31, 2005

Page 1 of 1

Overview.

Phenolic Surface films manufactured at Australian Panel Products are based on a kraft paper carrier. This paper is impregnated with a modified phenolic resole resin and then partly cured in a float on air dryer to provide a film which user friendly.

Technical aspects.

All Formboard films manufactured at APP are heat and pressure activated. All films are based on phenolic resins, which have been specially modified to suite the substrates being bonded.

The phenolic resin in APP overlays begins to flow above 70°C and full crosslinking occurs above 130°C. Recommended press temperatures for multi-daylight presses are between 135°C and 140°C. Single daylight presses should have their temperature set at 170°C.

For APP overlays the following press table can be used:

Base Paper Weight	Pressing Time @ 135°C	Recommended Specific Pressure
40/120	7 minutes	> 175 psi
60/150	7 minutes	> 175 psi

Production aspects.

Surface films are produced in the required size sheet, standard width sheets are 1250mm. APP are able to produce sheet widths up to 1365mm.

Phenolic Surface Film sheets arrive covered with plastic, which must be replaced if sheets are to remain unused for any time greater than half an hour.

If using multi-daylight presses, open times during material loading should be kept under 30 seconds and ideally be under 20 seconds. Open times of greater than 30 seconds will lead to pre-curing, reduced flow and “zebra-stripe” defects.

High temperature (170°C) single daylight presses should have open times of no greater than 5 seconds.

For further information contact Australian Panel Products technical staff.



Technical Data Sheet Formboard Overlay

May 31, 2005

Page 2 of 2

Storage Life.

Ideally, films should be stored below 25°C with a relative humidity of 50% in a horizontal position with no direct pressure from any other objects. When stored at these conditions APP Surface Films have a working life of approximately six months.

Unopened films should be kept with the plastic covering undisturbed until ready to use.

Direct pressure, direct sunlight and high moisture environments should be avoided.

OH&S Issues.

Phenolic Surface films cause an allergic reaction in some people. This can be avoided with the use of soft gloves and barrier creams.

Working areas must be adequately ventilated.

Please refer to Overlay MSDS.