

# DESIGN UP/DATE

PVA BONDING



LL Leguan Gold

# PVA BONDING

of SIBU DESIGN sheets

Non-adhesive design sheets from the deco-line, leather-line and structure-line series (with a few exceptions) can be offered with a special pre-treatment for bonding with standard PVA adhesive (white glue).

## ADVANTAGES

As a result of this type of processing, plastic, aluminium or wood edge trims can be used!

The PVA adhesive prevents the usual expansion of our design sheets due to the effects of heat!

As a result, the design sheets can be used for flush, edge-to-edge applications.



Positioning of PVA label with date

## PVA BONDING SUITABILITY

In order that design sheets are suitable for PVA bonding, they must be roughened on the reverse side. SIBU DESIGN tests in this regard were completed with 80-grain abrasive paper.

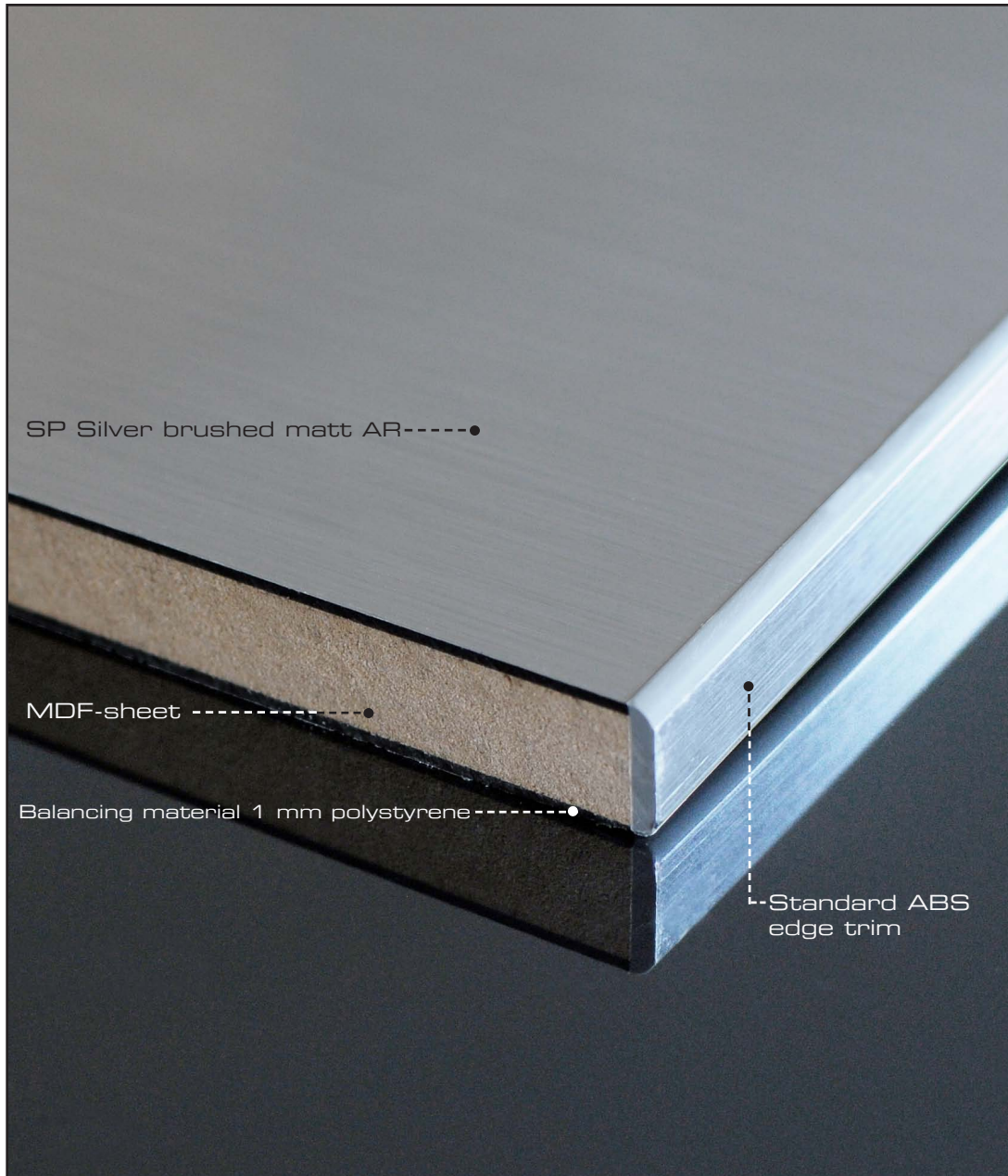
For industrial applications, many of our products (please see list) can be pre-treated in an additional production procedure.

As this special pre-treatment is not a standard-equipment on our design sheets the need for PVA adhesive suitability must be separately stated upon ordering.

The PVA pressing must be done within six months after delivery-date.

Each design sheet bears a label confirming its suitability for PVA bonding. The date on the label marks the beginning of the 6-months-period for use.

In case of any questions please get in contact with our sales team!



Cross-section of PVA bonding

## PROCESSING

Using a sheet press pre-treated SIBU design sheets can be easily bonded to smooth absorbent wood surfaces (untreated chipboard, MDF) with standard PVA adhesive.

The finished pressed design sheet can be easily cut with a saw and standard plastic, aluminium or wood edge trims can be used.

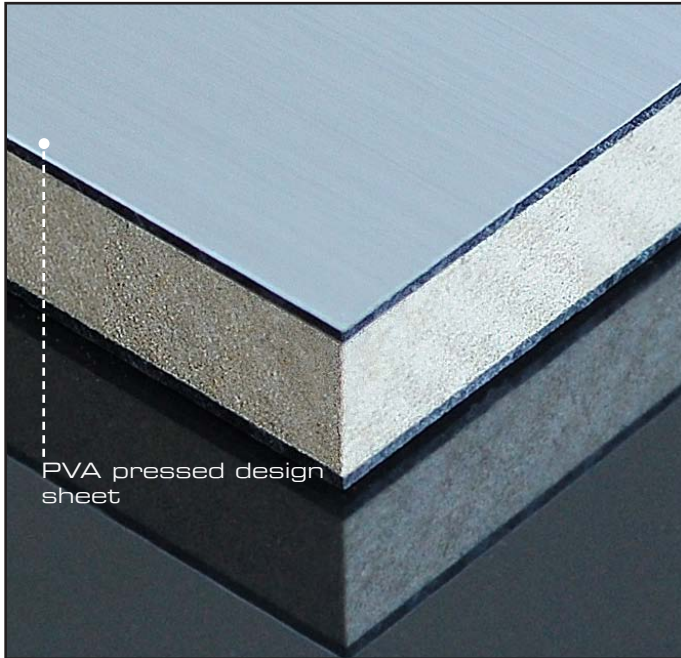
## GROUND

The wood ground must be absorbent.

Both pressing sheets are to be cleaned thoroughly prior to use. The wood sheet material must be brushed or blown clean. Both sides of the design sheet must be clean and dust-free and for this reason the wearing of gloves is recommended during pressing process.

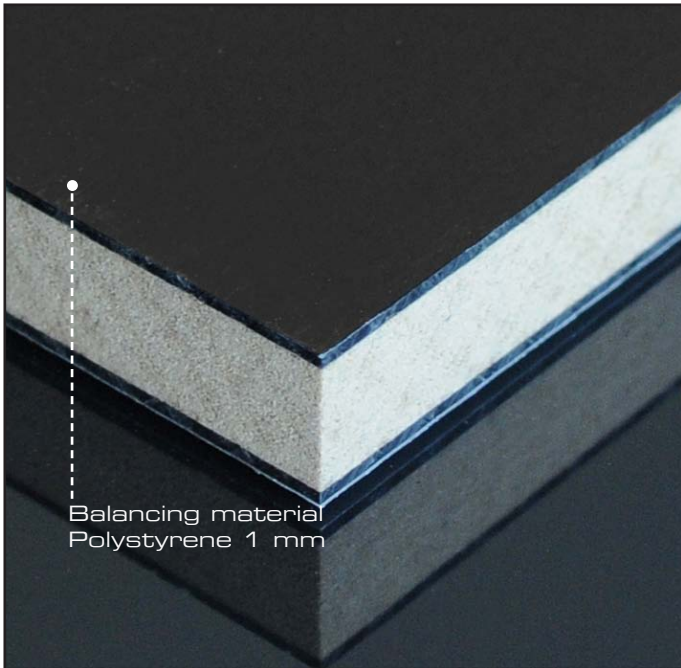
A surface-check for damage prior to pressing is highly recommended!





PVA pressed design sheet

Patterned side of PVA bonding



Balancing material  
Polystyrene 1 mm

Back side of PVA bonding

## PRESSING

When pressing the design sheets, a medium-hard sponge rubber mat with a thickness of approx. 5 mm should be used between the pressing-sheet and the patterned side of the design-sheet.

This provides uniform pressure distribution and prevents undesirable crushing spots caused inadvertently by particles of dirt between the pressing sheet and the design sheet.

Should the design sheet not have a crease-free protective film due to transport and storage conditions, this must be removed prior to pressing.

The pressure applied should amount to 2 kg/cm<sup>2</sup> (0.2 N/mm<sup>2</sup>), the temperature to approx. 45°C and the pressing time to around 10 minutes. The bonding of the balancing material and the design sheet is taking place in a single working process.

Standard HPL sheets can be used as balancing material. During pressing onto an untreated particle-board with a thickness of 16 mm the best results were achieved with a 1 mm polystyrene sheet for balancing.

Following pressing allow the sheets to cool over night (about 16 hours) in a stack. Cover the stack with a 19 mm plate so that the uppermost sheet also remains flat.

## SAWING INFORMATION

The patterned side should be uppermost, i.e. visible. The protective film should only be removed when the work-piece has been finished, the protective film serves as a safeguard during transport.

Should the protective film be removed in advance, take care that adhesive packing tape never comes into contact with the patterned surfaces



●-----DM Magic Black



Detail view: PVA bonded DM Magic Black  
2 mm

## RECOMMENDATION

For PVA bonding of our design sheets with mirror surface (DM Silver, DM Gold, DM Anthracite etc.) and of our high-brilliant surfaces (DM Magic Black, DM Magic White) we recommend to use these design sheets in 2 mm thickness.

This will improve the visual effect of the surface.

## ADHESIVE INFORMATION

The wet bonding time, working life, adhesive hardening time, application quantity/consumption should be read on the respective adhesive information sheet. The instructions on the adhesive container are to be regarded as supplementary.

Information concerning the PVA adhesives tested according to DIN or ÖNORM EN 204:

**Fa. H.B. Fuller Austria GmbH**, Kaplanstraße 30, 4600 Wels, Austria,  
Tel.: +43/7242-409-0, Fax: +43/7242 409-349 Internet: [www.hbfuller.com](http://www.hbfuller.com)

**RAKOLL Express 50**, PVAc adhesive, stress-group: DIN EN 204 - D2

**RAKOLL GLX3**, PVAc adhesive, stress-group: DIN EN 204 single-component without hardener, D4 with RAKOLL GLX-3-hardener.

**Fa. Henkel Central Eastern Europe GmbH**, Erdbergstr. 29, 1030 Wien,  
Austria Tel.: +43/1-711 04-0, Internet: [www.henkel-cee.com](http://www.henkel-cee.com)

**LEIFA PV/H standard joiner's adhesive**, PVAc D2 adhesive, DIN EN 204 - D2 stress pursuant to EN 204, 30 kg container.

**LEIFA PV/H D3 water-resistant, joiner's adhesive**, PVAc D3 adhesive, D3 stress group pursuant to EN 204, 10 kg and 30 kg containers.

**Synthesa Chemie GmbH**, Dirnbergerstraße 29-31, 4320 Perg, Austria Tel.:  
+43/7262/560-0, Fax: +43(0)7262/560-1500,  
E-Mail: [office@synthesa.at](mailto:office@synthesa.at), Internet: [www.synthesa.at](http://www.synthesa.at)

**Synturit Rapid**, PVA D2 adhesive, ÖNORM EN 204 - D2 stress group, 12 kg and 30 kg containers.

**Synturit F** PVA D3/D4 adhesive, ÖNORM EN 204 - D3 stress group, single-component without hardener, D4 with WA 34 hardener. 0,25 kg, 1 kg, 5 kg, 12 kg, 30 kg, 650 kg and 1000 kg containers.

## Design sheets requiring pre-treatment for PVA bonding:

deco-line	DM Magic Black DM Magic Black AR DM Magic White DM Magic White AR DM Magic Red DM Silver/white DM Silver/black DM Silver H23/black DM Silver AR12 DM Silver AR23 DM Gold DM Gold AR DM Anthracite DM Anthracite AR DM Brown DM Bronze DM Champagne	DM Brass DM Rose DM Viola DM Iceblue DM Skyblue DM Fashion Red DM Fashion Grey DM Silver brushed DM Silver brushed matt AR DM HGS DM HGS matt AR DM Champagne brushed DM Titan brushed DM Copper brushed DM Grey brushed matt AR DM Brass brushed matt AR DM Gold brushed matt AR	DM Silver PF met DM Smoke PF met DM Champagne PF met DM Lapis PF met DM Silver PF met touch 1 DM Champagne PF met touch 1 DM Smoke PF met touch 1 DM Titan PF met touch 1 DM Caramel PF met touch 1 DM Copper PF met touch 1 DM Bronzo PF met touch 1 DM Zebrano graphite touch 1 DM Zebrano touch 1 DM Makassar touch 1 DM Mahogany touch 1 DM Tobacco touch 1
structure-line	SL SQUARE 3 HGS SL SQUARE 3 Silver PF met SL WAVE Lapis PF met SL WAVE Silver PF met SL WAVE Silver SL STEP 5 Silver PF met/Silver SL STEP 5 HGS SL STEP 5 Silver PF met SL GRASS Silver PF met SL GRASS Champagne PF met SL DROPS Silver	SL BUBBLE Silver PF met/Silver SL BUBBLE Orange PF/Silver SL BUBBLE Blue PF/Silver SL GLOBE 18/50 HGS SL WAVE 1 Silver PF met SL CROCO Silver PF met/Silver SL CROCO Smoke PF met/Silver SL CROCONOVA Silver SL CROCONOVA Magic Black SL ALISE Vintage Black SL ALISE Vintage Copper	SL IMPERIAL Vintage Black SL IMPERIAL Vintage Copper SL URBAN Grey SL URBAN Titan SL LAVA Grey SL LAVA Copper SL DAKOTA Smoke SL DAKOTA Copper SL DAKOTA Metal
leather-line	LL Leguan Silver LL Leguan Gold LL Leguan Copper LL Leguan Nero LL Leguan Silver ZN 200/Silver	LL Leguan Gold ZN 200/Gold LL Leguan Copper ZN 200/Copper LL Leguan Nero ZN 200/Silver LL Eleganza Gold LL Eleganza Silver	LL PELO Marabu LL PELO Savanna LL Reggae
MultiStyle Fashion	All designs of the MultiStyle Fashion programme are suitable for PVA bonding. Our sales team will be pleased to provide more information!		

## Design sheets requiring reverse side roughening for PVA bonding:

leather-line	LL White LL Creme LL Dark Brown LL Brown LL Beige LL Red LL Black LL Stone Grey LL Caramel LL Creme ZN 200/Brown LL Dark Brown ZN 200/Beige LL Brown ZN 200/Beige LL Bianco matt ZN 200/Black	LL Nero matt ZN 200/White LL FLORAL Black LL FLORAL White LL FLORAL Black/Silver matt LL FLORAL White/Silver matt LL FLORAL White/ Gold matt LL CROCO Black LL CROCO Creme LL CROCO White LL ALISE White/Gold LL ALISE White/Silver LL ALISE Black LL IMPERIAL White/Gold	LL IMPERIAL White/Silver LL IMPERIAL Black/Silver LL IMPERIAL White LL STRUZZO White LL STRUZZO Dark Brown LL STRUZZO Creme LL CREPA Nero matt LL COLLAGE Nero matt LL COLLAGE Mocca matt LL SNAKE Nero matt LL SNAKE Bianco matt
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DESIGN  
UP/DATE