LENDERINK TECHNOLOGIES

Backings for Wood Veneer, Plywood, Particle Board, Paper, etc.

Pre-coated with dry film adhesive. Available in rolls or sheets.

Adhesive Backers	Finger Joint Tape	101TS	160TS	170TS	204TS	208	363	610 TS	374	710TS	S320 Liquid	330TS
Thickness	.003"	.006"	.010" or .020"	.004"	.005"	.001"-.002" +	.001"- .002" +	.010" or .020"	.001" or .002"	.005"	.003"	.008"
Min. Glue Line Bonding Temp.	350ºF 217ºC	210 ºF 139 ºC	260ºF 127ºC	290ºF 140ºC	290 ºF 143 ºC	220ºF 144ºC	235º-300ºF 112º -149ºC	250ºF 121ºC	275ºF 135ºC	260ºF 130ºC	60ºF 16ºC	275ºF 135ºC
Press Time at Full Temp.	1 Second	7 minutes	30 Seconds	30 Seconds	2 minutes	10 Seconds	10 Seconds	1 Minute	10 Seconds	1 Minute	Spray/Roll/Dip	1 Minutes
Estimated Cost/Square Foot (Large Volume)	$0.126	$0.14	$0.14	$0.12	$0.07	$0.06	$0.10	$0.119	$0.13	$0.07	$0.13	$0.13
Minimum Pressure (PSI)	100 +	70	85	100 +	150	10	50+	100	50	100	5	90
Heat Resistance	Thermo-Set	Thermo-Set	Thermo-Set	Thermo-Set	Thermo-Set	190ºF	220ºF	Thermo-Set	250°F	Thermo-Set	2000°F +	Thermo-Set
Need Release Sheet	No	Yes	No	Yes	Yes	Yes	Yes	No	Yes	Yes	Air Dry	Acrylic/Melamine
Backer Type	Acrylic Micro-Fleece	Modified Melamine	Certified Green Woven Cellulose	Acrylic Fleece	Phenolic	PE	Clear Polyurethane	Certified Green Thick Strong Paper	Polyester	Melamine	Latex Acrylic	Thick Fleece
Color	Cream, Brown, Tan	Cream	Cream, Brown, Tan	Cream, Beige, Tan	Purple	Semi-Clear	Any	Cream, Tan, Brown	Clear	Beige	White (custom color available)	White
Adhesive Can Reactivate for Second Bonding	No	Yes	Yes	No	No	Yes	Yes	Yes	Yes	No	No	No
Water Resistance	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes
Flame Resistance	No	Yes	Optional	No	No	No	No	No	No	Yes	Yes	No
Flexibility	Excellent	Good	Excellent	Excellent	Low	Excellent	Excellent	Good	Good	Low	Yes	Good
Printability	Fair	Good	Fair	Good	Fair	Good	Good	Good	Good	Fair	Fair	Fair
Shelf Life	6 mo. @ 75ºF	6 mo. @ 75ºF	6 mo. @ 75ºF	6 mo. @ 75ºF	6 mo. @ 75ºF	6 mo. @ 75ºF	No Known Limit	6 mo. @ 75ºF	No Known Limit	6 mo. + @ 75ºF	24 mo. @ 75ºF	6 mo. + @ 75ºF
Used For:												
Flexing	Yes	Medium	Yes	Yes	No	Medium	Yes	Yes	Medium	No	Yes	Yes
Surface	Fleece Resin	Fleece Resin	Cloth FSC Certified – Fiber/Fabric	Fleece Resin	Fleece Resin	Clear	Clear	Non-Porous Kraft	Clear	Fleece Resin	Opaque	Fleece Resin
Panel Balancing	No	Yes	Yes	Medium	Yes	Yes	Yes	Yes	Yes	Yes	Medium	Yes

In most cases the above bonding strengths are a function of the following 5 components:

1. Temperature: The Temperature at the glue line should be checked with a "K" Thermo Couple Thermometer from Cole Palmer Catalog # 91100-10 (www.colepalmer.com or (800) 323-4340). In addition, you will need "K" type adapter plugs, Catalog # 93840-52 and a spool of very fine teflon coated wire, Catalog # 08541-02. Lenderink Technologies will be happy to supply you with all of the above materials together for approximately $250.00.

2. Pressure = $\dfrac{\text{Hydraulic Line Pressure (lbs.)} \times \text{Surface Area of Cylinders (in}^2\text{)}}{\text{in}^2 \text{ of Material Being Pressed}}$ Stacks or multiple pieces can be pressed at one time

3. Time = when the glue line is at full temperature and pressure. Pressing time is often related to temperature and pressure. Higher temperature / pressure settings often allow for a shorter cycle time.

4. Surfaces being bonded must be compatible with particular dry film adhesive being used. Surfaces must also have compatible energy and texture.

5. Vapor/Off gassing: Pre Press at full temperature and low pressure before adding Lenderink Dry Film Adhesive, i.e. vapors vacated from surfaces. Vapors cause bubbles and/or poor bonds. Moisture contents of wood should be below 8%, press breathing may be needed.

The above 5 components can be varied some and still provide good bonds. i.e. Temperature increase can often allow for pressure decrease and vice-versa. Extremely slick surfaces may have improved bonds if Corrona Treated or sanded.

Start as close to our recommendations as possible. Vary from the recommendations only one variable at a time. If any questions please feel free to either call or email us.

Send samples to our lab for adhesive recommendations so that we may test the material.

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