

**NEWS**  
**UP/DATE** <sup>GB</sup> 1.6

PVA BONDING



## PVA bonding of SIBU DESIGN sheets

Following pre-treatment, non-adhesive design sheets from the DECO-LINE, ACRYLIC-LINE, SIBUGLAS, LEATHER-LINE and STRUCTURE-LINE series (with a few exceptions, please see the product list) can be bonded using standard PVA adhesive (white glue).

## ADVANTAGES

As a result of this type of processing, standard plastic, aluminium or wood edge trims can be used! This is because the PVA adhesive prevents the usual expansion of our design sheets due to the effects of heat. Consequently, the design sheets can be used for problem-free, edge-to-edge applications.

●-----LL Leguan Gold



Positioning of PVA label with date

## PVA pre-treatment

In order that our sheets are suitable for PVA bonding, depending upon their thickness, they must either be subjected to an additional pre-treatment, or be roughened. Please see the product list.

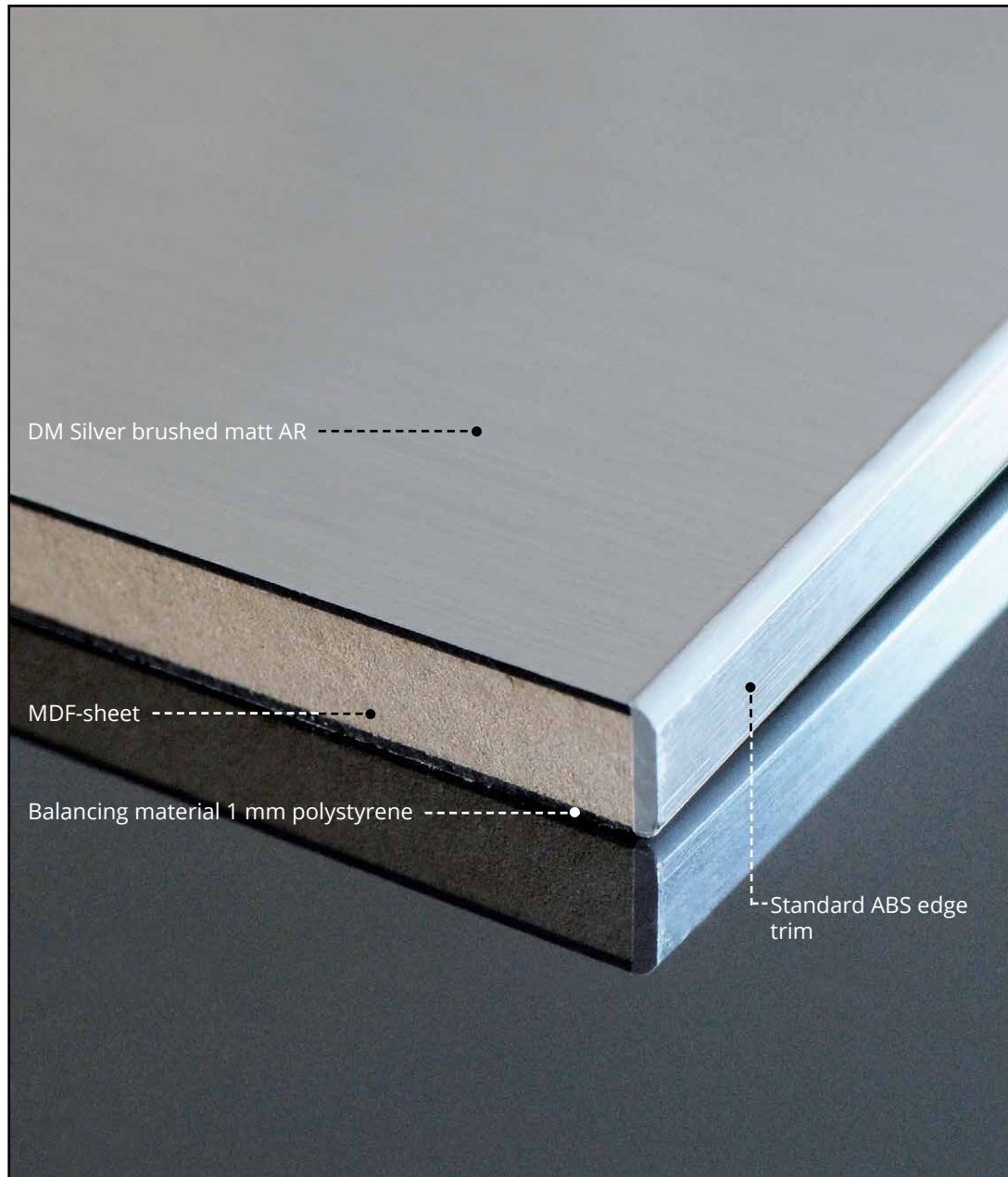
### PRE-TREATMENT

As this special pre-treatment is not a standard procedure, a PVA pre-treatment requirement must be stated upon ordering. In line with the product, pressing must take place within a period of two or six months following the delivery date. Each design sheet bears a label confirming its suitability for PVA bonding. The date on the label marks the beginning of the period for use.

### SANDING OF THE REVERSE SIDE

SIBU DESIGN testing was carried out with 80-grain sandpaper. This procedure is to be completed by the customer.

Should any questions arise, please contact our sales team!



Cross-section of PVA bonding

## PROCESSING

Both of the pressing sheets have to be cleaned thoroughly prior to beginning the working process. The material from the wood sheet must be brushed or blown off.

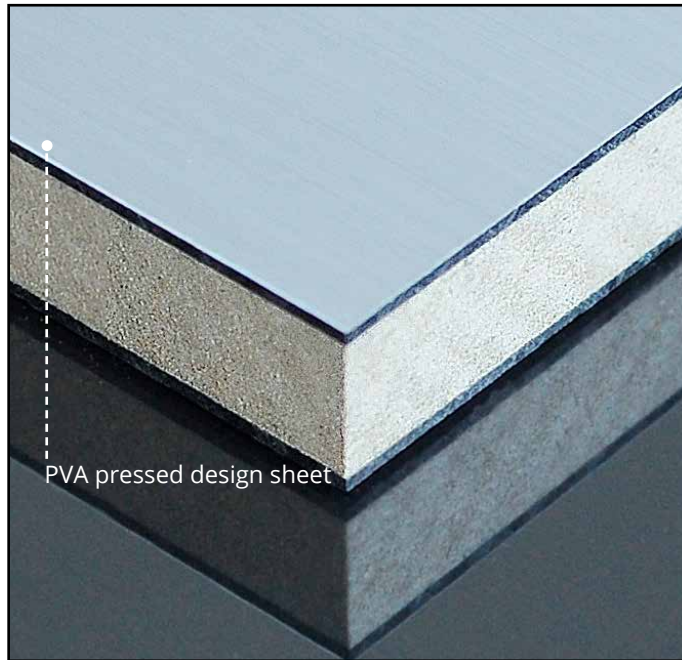
It is imperative that the reverse side of the design sheet is clean and dust-free before pressing starts and therefore it is recommended that gloves be worn in order to avoid any negative effects to the reverse side. Check the surfaces for any damage prior to pressing.

Pre-treated SIBU design sheets can be easily bonded onto smooth, absorbent wood surfaces (untreated chipboard, MDF) using a panel press. The adhesive may only be applied to flat wood sheets.

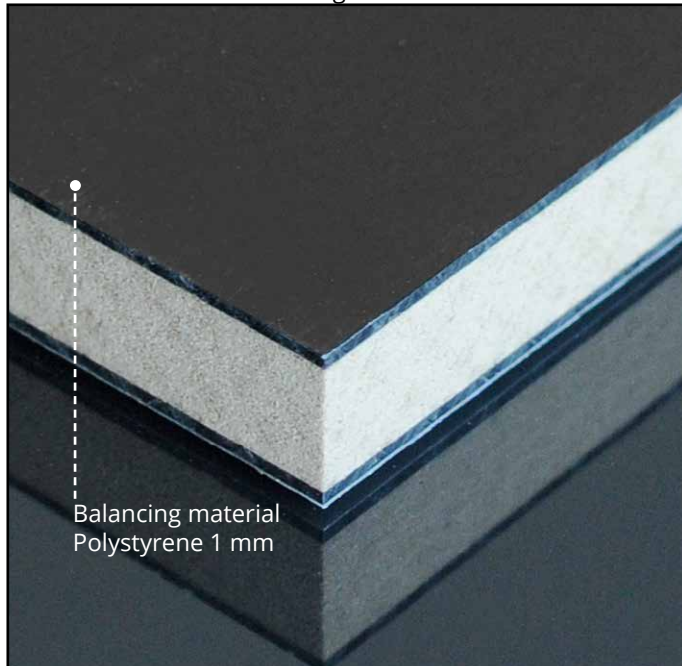
The acclimatised SIBU design sheets, the backing panel and the wood base sheet should be laid out next to one another on a flat, clean and sufficiently large work-table. The cut wood base sheet must be roughly 10 cm larger than the SIBU design sheet. Firstly, the two SIBU design sheets are to be generously covered with adhesive using a glue roller. They should then be positioned in the middle of the wood base sheet virtually simultaneously. No adhesive should be applied directly to the wood base sheet as this can have a negative effect upon flatness.

## SIBUGLAS

Owing to the highly absorbent reverse side of the SibUGlas sheet, PVA white lime consumption is higher. Approximately 200-300 g/m<sup>2</sup> are required. The synthetic fibres should demonstrate a wet, adhesive shine shortly before bonding.



Patterned side of PVA bonding



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 at the same time prevents undesirable pressure spots caused by particles of dirt between the pressing sheet and the design sheet. However, when using smooth design sheets, it is better to complete pressing without the sponge rubber mat, as this can cause the surface to appear uneven. In order to achieve a smooth surface, enquire about our 2mm-thick design sheets.

**WARNING!** When pressing mirror or high-gloss products, an undamaged and clean pressing sheet is essential.

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.

During pressing onto an untreated particleboard with a thickness of 16 mm the best results were achieved with a 1 mm polystyrene sheet for balancing. 1 mm-thick balancing material (PMMA) should be used for Sibuglas, but roughening is unnecessary. 2mm-thick balancing material must be employed for Sibuglas AR+ products, but pre-treatment is not required. SL LINEA products require a polystyrene balancing sheet with a thickness of 1.5mm. Following pressing allow the sheets to cool over night (approx. 16 hours) in a stack. Cover the stack with a 19 mm-plate so that the uppermost sheet also remains flat.

The patterned side should be uppermost, i.e. visible. The protective film should only be removed when the workpiece has been finished, as it 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.

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



Presenter with PVA bonded surface

## RECOMMENDATION

For the PVA bonding of our design sheets with either a mirror surface (DM Silver, DM Gold, DM Anthracite, etc.), or our high-gloss surfaces (DM Magic Black, DM Magic White), we recommend the use of the 2mm- thickness. This will improve the visual effect of the surface. When 2mm-thick mirror and high-gloss products are employed, the thickness of the polystyrene balancing sheet also has to be increased to 2mm.

## SIBUGLAS

SibuGlas AR+ products can be bonded without PVA pre-treatment. For more detailed information please see the SibuGlas-Infos Update 1.4C Page 12-15.



Detail view: PVA bonded DM Magic Black 2 mm

## 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 panels pre-treated for PVA bonding (6-month processing period):

deco-line	DM Magic Black AR DM Magic White AR DM Magic Red AR DM Silver/white DM Silver/black DM Silver H23/black DM Silver AR12 DM Silver AR23 DM Gold DM Gold 30 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 Copper DM Fashion Red DM Fashion Red AR DM Galaxy Silver 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 Titan 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 Zebrano graphite touch 1 DM Zebrano touch1 DM Makassar touch 1 DM Tobacco touch 1 DM FLEUR Gold/Brown DM FLEUR Silver/Brown DM MONSOON Vintage Brown DM OAK TREE Light	DM OAK TREE Dark DM Vintage Silver DM Vintage Copper DM LUXURY Bronze DM LUXURY Gold DM LUXURY Silver DM Hollywood DM Iron Age DM Golden Age DM Copper Age DM CEMENT Light DM CEMENT Light/Grey brushed 8L
wood-line	WL Wenge Wood WL Nutwood	WL Nutwood/Grey brushed 8L WL Nutwood Country	WL Nutwood Country/Grey brushed 8L WL Maple Alpine	WL Maple Alpine/Grey brushed 8L	
structure-line	SL SQUARE 3 HGS SL SQUARE 3 Silver PF met SL SQUARE 3 Silver brushed SL WAVE Silver PF met SL WAVE Silver SL WAVE Silver brushed matt AR SL STEP 5 Silver brushed matt AR SL STEP 5 HGS SL STEP 5 Silver PF met SL BUBBLE Zebrano graphite/Silver SL BUBBLE Silver PF met/Silver SL BUBBLE Orange PF/Silver	SL BUBBLE Blue PF/Silver SL WAVE 1 Silver PF met SL WAVE 1 Silver brushed matt AR SL WAVE 1 Silver SL CROCO Silver PF met/Silver SL CROCONOVA Magic White SL CROCONOVA Magic Black SL ALISE Vintage Black SL ALISE Vintage Copper SL IMPERIAL Vintage Black SL IMPERIAL Vintage Copper SL URBAN Light Grey	SL URBAN Grey SL URBAN Titan SL LAVA Grey SL LAVA Copper SL DAKOTA Smoke SL DAKOTA Copper SL DAKOTA Metal SL MOTION ONE Anthracite AR SL MOTION ONE Silver AR23 SL MOTION TWO Grey brushed matt AR SL MOTION TWO Silver brushed matt AR SL MYSTIQUE Vintage Copper	SL MYSTIQUE Vintage Silver SL ORIENT Vintage Copper SL ORIENT Vintage Silver SL IMPACT Vintage Silver SL IMPACT Antique Bronze SL IMPACT Antique Brass SL RAW Vintage Silver SL RAW Antique Brass SL RAW Antique Bronze SL RAW Vintage Copper SL PEARL RAY Vintage Silver SL RACE Silver	SL RACE Vintage Silver/Bronze SL RACE Vintage Copper/Silver SL RIVET Vintage Silver SL MOTION ONE Pearl White PF SL LINEA 104x62 Old Platin SL LINEA 104x62 Silent Gold SL RIGATO Silent Gold SL RIGATO Silver brushed matt AR SL ART Old Platin SL ART Golden Age SL ART Iron Age
leather-line	LL LEGUAN Silver LL LEGUAN Gold LL LEGUAN Copper LL LEGUAN Nero	LL LEGUAN Bianco LL LEGUAN Silk LL LEGUAN Blue LL ELEGANZA Gold	LL ELEGANZA Silver LL PELO Marabu LL PELO Savanna LL REGGAE	LL PEARL RAY Gold LL LACE Black/Platin	
acrylic-line	AC MOTION ONE White AC MOTION ONE Creme AC MOTION ONE Red	AC MOTION ONE Black AC MOTION TWOWhite AC MOTION TWO Creme	AC MOTION TWO Red AC MOTION TWO Black	AC TOUCH White AC TOUCH Creme	AC TOUCH Red AC TOUCH Black



## Design panels requiring sanding of the reverse side for PVA bonding:

leather-line / structure-line	LL Antiqua Gold	LL FLORAL Aubergine	LL CROCO Oro	LL COLLAGE Oro	SL CROCO Smoke PF met/Silver
	LL OXY Steel	LL FLORAL Platin	LL CROCONOVA Platin	LL SNAKE Aubergine	
	LL OXY Terra	LL FLORAL Oro	LL CREPA Oro	LL SNAKE Platin	

## Design panels pre-treated for PVA bonding (2-month processing period):

leather-line	LL White	LL FLORAL Black	LL COLLAGE Nero matt	LL ALISE White/Silver	LL Vintage Silver
	LL Creme	LL FLORAL White	LL COLLAGE Mocca matt	LL ALISE Black	LL PERSIAN Gold
	LL Dark Brown	LL FLORAL Black/Silver matt	LL SNAKE Nero matt	LL IMPERIAL White/Gold	LL PERSIAN Metallic
	LL Brown	LL FLORAL White/Silver matt	LL SNAKE Bianco matt	LL IMPERIAL White/Silver	
	LL Beige	LL FLORAL White/ Gold matt	LL MYSTIQUE Gold/Silver	LL IMPERIAL Black/Silver	
	LL Black	LL CROCO Black	LL MYSTIQUE White/Gold	LL IMPERIAL White	
	LL Azzurro matt	LL CROCO Creme	LL MYSTIQUE White/Silver	LL MYSTIQUE Vintage Silver/Silver	
	LL STRUZZO White	LL CROCO White	LL MYSTIQUE Black/Silver	LL ORIENT Vintage Silver/Silver	
	LL STRUZZO Dark Brown	LL CROCO Uni Magenta	LL ORIENT Gold/Silver	LL FLORAL Vintage Silver/Silver	
	LL STRUZZO Creme	LL CREPA Nero matt	LL ALISE White/Gold	LL Vintage Copper	

## Design panels suitable for PVA bonding without special pre-treatment:

MultiStyle Fashion	alle Designs aus dem MultiStyle Fashion Programm sind für die PVA Verklebung geeignet.
SibuGlas	alle Designs (mit Ausnahme von SG YUKON/SG YUKON AR+) aus dem SibuGlas und SibuGlas AR+ Programm sind für die PVA Verklebung geeignet.

## Design panels, which cannot be PVA bonded:

leather-line / translucent-line / deco-line / punch-line / punch-line 3D	LL Bianco matt ZN 200/Black	LL ROMBO 40 Nero matt	LL QUADRO Bianco matt	TL LINEA 104x62 Silent Gold	PL 3D Q 5-15-15 Mahogany/Silver
	LL Nero matt ZN 200/White	LL ROMBO 40 Antigua Gold	LL QUADRO Creme	DM Sahara Silver	PL 3D Q 5-15-15 Black touch 1/Silver
	LL Creme ZN 200/Brown	LL ROMBO 40 Oxy Terra	LL QUADRO Nero matt	PL 3D ROSES Pearl White PF/Gold	PL 3D Q-10-30 Old Platin/Silver
	LL Dark Brown ZN 200/Beige	LL ROMBO 85 Bianco matt	LL QUADRO Argento	PL 3D ROSES Champagne Pf met/Gold	PL 3D H-10-30 Pearl White PF/Gold
	LL LEGUAN Silver ZN 200/Silver	LL ROMBO 85 Creme	LL QUADRO Luxury Bronze	PL 3D ROSES Silver PF met/Silver	PL Q 10-40-40 Silver PF met
	LL LEGUAN Copper ZN 200/Copper	LL ROMBO 85 Mocca matt	LL LOUNGE Bianco matt	PL 3D Q 10-40-40 Silver PF met/Silver	PL Q 5-15-15 Silver PF met
	LL LEGUAN Nero ZN 200/Silver	LL ROMBO 85 Nero matt	LL LOUNGE Creme	PL 3D Q 10-40-40 Silver brushed/Silver	SL PIANO Golden Age
	LL ROMBO 40 Bianco matt	LL ROMBO 12 Bianco matt	LL LOUNGE Mocca matt	PL 3D Q 10-40-40 Silver PF met/Blue	SL PIANO Iron Age
	LL ROMBO 40 Creme	LL ROMBO 12 Creme	LL LOUNGE Nero matt	PL 3D Q 10-40-40 Smoke PF met touch1/Silver matt	
	LL ROMBO 40 Mocca matt	LL ROMBO 12 Nero matt	TL LINEA 104x62 Old Platin	PL 3D Q 5-15-15 Tobacco touch 1/Silver	Alle Artikel aus der MS-Produktgruppe

# SIBU | DESIGN

we decorate.

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