

## Resurfacing High Pressure Laminates with KYDEX® Sheet

For information applicable to KYDEX® FST please refer to 300 series technical briefs.

### TB - 154

#### Introduction

High pressure laminated (HPL) counters, shelving, fixtures, etc may be resurfaced with KYDEX® sheet, which can be installed directly onto an existing laminate that is not loose or damaged. The following steps are suggestions to help assure satisfactory performance when resurfacing preexisting HPL flat surfaces. Do not attempt to resurface formed parts or items having rounded edges.

#### Precautions

Examine the item closely for loose or poorly bonded laminate and repair where needed. KYDEX® sheet should only be applied to a clean substrate or a well-bonded laminate.

Determine the proper order for applying the laminate edges, face, etc.

Trim the substrate as required prior to applying the new laminate. Be certain to allow for the additional thickness of the KYDEX® sheet to be applied, if needed.



#### Preparation

Make sure that the KYDEX® sheet and the substrate have been at room temperature (approximately 21°C or 70°F) for at least 48 hours prior to laminating. This will help to reduce the possibility of buckling and will help reduce the stress on the glue line.

Clean the HPL with a strong detergent or non-flammable solvent to remove any wax, grease, and polish deposits. Clean the HPL thoroughly prior to sanding so that they do not contaminate the top during sanding. Make sure the KYDEX® sheet is free of debris as well.



Completely sand the surface to remove the original finish. It is not necessary to sand off the color or pattern.

Formica® recommends using a belt sander, which is the best option, but if a belt sander is not practical, hand sanding the surface with 180 or 220 grit sandpaper should result in adequate surface preparation. Be sure to remove all of the sheen off the surface of the HPL. After sanding, remove sanding dust with a vacuum and tack cloth.



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#### Adhesive and Assembly

Coat the sanded surface and the back of the KYDEX® sheet with a uniform coating of contact adhesive. Allow drying thoroughly prior to assembling. We recommend 3M 2262 but a similar solvent-based adhesive should work equally well.

**Note:** Assembling wet adhesive lines could trap solvent and may result in a poor bond. Follow the adhesive manufacturer's recommendations. Do not use water-based adhesives.

It's easiest to lay wooden dowel rods or strips of lath every 152.40mm - 304.80mm (6" - 12") along the existing HPL substrate. Place the KYDEX® sheet on top of the rods and make sure it is aligned properly. Once it touches the surface, it cannot be repositioned.

One by one remove the wood pieces and press the KYDEX® sheet into position. Use sweeping motions from the center of the surface outward to prevent bubbles from forming. Once all the wood pieces have been removed, apply firm, even pressure all over the surface with a hand roller. Apply extra pressure near the edges.

When applying KYDEX® sheet to vertical surfaces, one can usually position the glued sheets without using wooden strips. Simply index the KYDEX® sheet to one corner and slowly position the sheet across the entire surface. Use extreme care when laying the sheets. A general rule for contact adhesives is that 50 percent to 75 percent of the bonding strength is present in the first contact.

The wooden strips could also be used in the same fashion as the flat surface, just make sure there is enough room to remove the strips. This helps to line up the edges if the KYDEX® sheet was cut to an exact size. Simply line up the edges, remove the strips one by one, and press the KYDEX® sheet into place. Having more than one person during installation would be helpful.

Continue by smoothing the sheet from the center outward to remove any remaining air bubbles. Then finish by using the hand roller and trim if needed. Thin KYDEX® sheet can usually be trimmed with just a utility knife.



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