

## Introduction

Arborite ColorEdge Laminate – The solid choice when color continuity is a must.

## Product Description

Arborite ColorEdge laminates are produced for both horizontal and vertical applications where the surface must be functional, durable, high-quality, and resistant to scuff, scratch and stain.

## Product Composition

ColorEdge is a distinctive surfacing material composed of decorative papers impregnated with melamine resins pressed over a color-matched décor paper core saturated with special thermosetting resins. These sheets are then bonded at pressures greater than 1,000 pounds per square inch, and at temperatures approaching 275°F (135°C). Finished sheets are trimmed, and the backs are sanded to facilitate bonding.

## Patterns, Colors & Finishes availability

- S405 Black CA finish
- S405 Black GL finish
- S405 Black SR finish
- S550 Elegant White CA finish
- S550 Elegant White GL finish
- S550 Elegant White SR finish
- P391 Ruched Chiffon GL finish

**CA Cashmere finish** – a fine, matte texture finish for laminate with a slight sheen. Excellent for both horizontal and vertical applications.

**GL Gloss finish** – a flat texture with a high sheen, for an appealing, contemporary laminate look. Excellent for vertical application.

**SR – Structured finish** - A highly embossed linear texture suitable for woodgrains, solids and linear patterns

## Standard Width & Length

48.5” (1232 mm) width x 96.5” (2451 mm) length  
48.5” (1232 mm) width x 120.5” (3062 mm) length

## Thickness & Weight

0.048” ± 0.005” (1.22 mm ± 0.13 mm)  
0.382# Weight per square foot

## **Usage**

Color**Edge** sheets are for interior use only and are not recommended for direct application to plywood, plaster, concrete walls, or gypsum wallboard. Color**Edge** is not a structural material and must be bonded to a suitable substrate. Do not subject Arborite Color**Edge** to extremes in humidity, temperatures higher than 275°F (135°C), or intense, continuous, direct sunlight for substantial periods of time.

**Due to the unique resin composition, a slight color-shift can occur in ColorEdge laminates in comparison to standard Arborite high pressure laminate. Please be sure to request a sample for color confirmation.**

## **Storage & Handling**

Arborite Color**Edge** laminate sheets must be stored internally with optimum storage conditions at 75°F (24°C) and 45% to 55% relative humidity. Color**Edge** sheets should be stored away from exterior walls and never stored directly on the floor. Color**Edge** sheets must be stored horizontally, with the top sheet facing down in order to protect the material from damage and to reduce the chance of possible warpage to the top sheets. Good circulation and air movement is recommended around the Color**Edge** stored sheets.

It is recommended NOT to carry Color**Edge** flat, but rather turn the sheet on its side. In addition, always use two people in the handling to avoid breakage.

## **Preconditioning**

In preparation for fabrication, it is always recommended to ensure proper acclimation between the Color**Edge** laminate and the substrate. Recommended and optimum temperature is approximately 75°F (24°C), and Color**Edge** and substrate should be conditioned at 45% to 55% relative humidity. For proper acclimation, all components including face and backing/balancing laminates, substrates, and adhesives should be acclimated for 48 hours before bonding and fabrication.

## **Substrates**

Color**Edge** laminates must be bonded to substrates of reliable quality. Industrial 45# density particleboard or medium density fiberboard (MDF) is recommended. High pressure laminate, plaster, concrete, gypsum boards or plywood should not be considered and are not warranted, suitable substrates. Color**Edge** laminates may not be used as structural member.

## **Balancing**

Utilizing a balancing sheet opposite of the Color**Edge** material is required in most applications. For best results, using Color**Edge** on the other side of the panel will provide a well-balanced panel. For ideal application, using same type of adhesive, same coverage on both sides, and the Color**Edge** sanding marks assembled in the same direction will provide a quality assembly.

## **Recommended Balancing Materials:**

- CE5 Color**Edge** Laminate

Contact Arborite Technical Service Department for further information on proper panel component layouts.

## **Adhesives**

Since ColorEdge laminate does not provide camouflage for a colored adhesive glue line, adhesive selection is critical. Due to the color-through core, recommended adhesives are ridged set polyvinyl acetate (PVA) and non-pigmented contact types. A variety of PVA options and non-pigmented contact adhesives are available to meet the various types of bonding applications. Be sure to follow adhesive manufacturer recommendations.

**FAB TIPS: Do Not Use pigmented adhesives as these will create a visible adhesive line at the seam areas.**

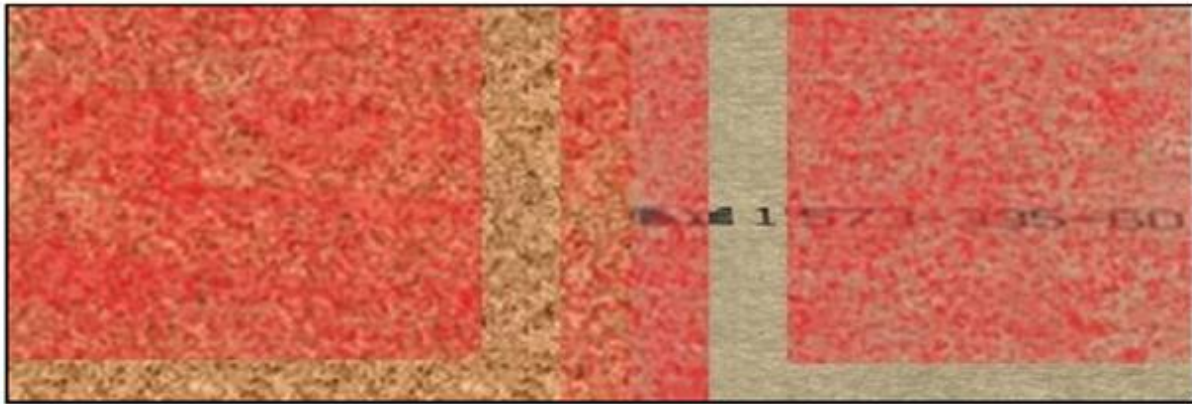
### **Special Adhesive Techniques – PVA & Perimeter Bonding**

Due to the special laminate formulation, ColorEdge can generate internal force when a humidity change causes movement. Slight shrinkage from loss of moisture is more frequent than expansion from increased moisture. A strong bond between the ColorEdge and the substrate is critical and can be achieved with multiple adhesive options and methods of applications. PVA type adhesives provide the most suitable bond between ColorEdge and substrate, providing a ridge expansion resistant bond.

### **PVA Masking Method**

When using contact adhesives, one of the two following methods are recommended. Determine critical (target) areas to enhance such as seams, front edges, and inside corners. Mask target areas on both laminate and substrate with masking tape approximately 1” from edge/seam. Apply contact adhesive as directed by manufacturer. When adhesive reaches the start of the open time, remove masking tape and apply a small bead of PVA adhesive. Index and apply pressure as recommended. Contact adhesive acts as a clamping device while PVA cures. Use caution on the amount of adhesive applied to minimize the likelihood of telegraphing.

**FAB TIPS: Perimeter bonding recommended for controlling**



**\*PVA and non-pigmented contact types are recommended. Pigmented adhesive in diagram illustrated for visual only**

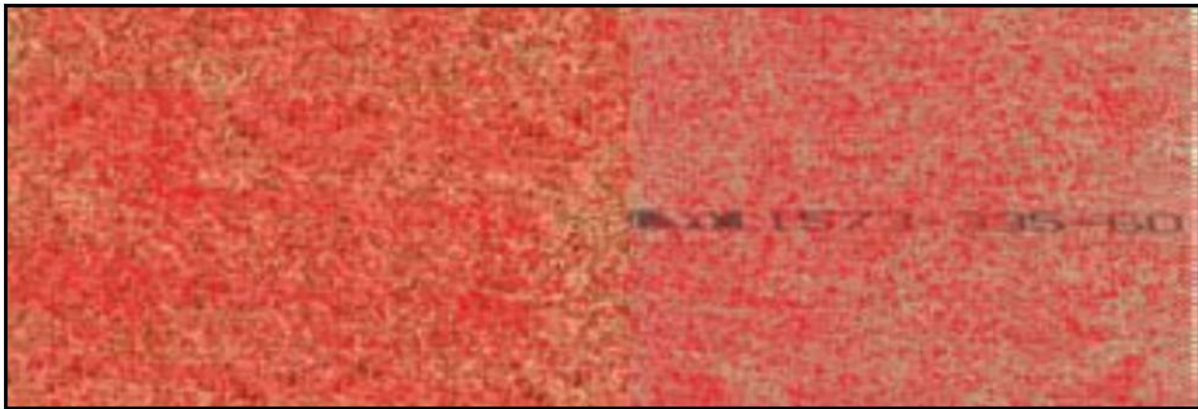
### **Alternative Method (Non-Masking)**

Determine critical (target) areas to enhance such as seams or front edges. Apply contact adhesive as directed by manufacturer. (no masking is necessary). When adhesive reaches the start of the open time, apply 3/16" bead of rigid type adhesive (examples: melamine adhesive, or Urethane) on the target area of the substrate approximately 2" from the edge(s). Use a disposable scraper or scrap laminate chip to spread the adhesive bead to a flat, uniform appearance. Index and apply pressure as recommended. Contact adhesive acts as clamping device while adhesive cures. Use caution on the amount of adhesive applied to minimize the likelihood of telegraphing.

**FAB TIPS: Contact adhesive acts as a clamping device while adhesive cures.**

### **Recommended Perimeter Bonding Adhesives:**

- Product Type Melamine Adhesive-PVA



**\*PVA and non-pigmented contact types are recommended. Pigmented adhesive in diagram illustrated for visual only**

### **Postforming**

The CE5 ColorEdge is recommended for flat surfaces only. Do not use in postforming equipment or applications. Smaller radii can fracture the surface of the ColorEdge material. Call Arborite Technical Services for further information regarding cold forming.

### **Fabrication**

Fabrication should follow approved methods. Assembled pieces should meet the specifications of KCMA (Kitchen Cabinetmakers Manufacturers Association), ANSI A-161.2-1998 (revised), and "Architectural Woodwork Quality Standards, Guide Specifications and Quality Certification Program" guidelines of the Architectural Woodwork Institute where applicable.

**FAB TIPS: Keep all ColorEdge seams and edges clean. Remove dirt, pencil, marker, finger prints, ColorEdge identification ink, etc.....prior to adhering material.**

To avoid stress cracking, do not use square-cut inside corners. All inside corners should have a minimum of 1/8" (3.175 mm) radius and all edges should be routed smooth. Drill oversized holes for screws or bolts. Screws or bolts should be slightly countersunk into the face side of a laminate-clad substrate. All edges and corners should be sanded or filed smooth and free of chips or nicks.

**FAB TIPS: A 1/4" diameter 2-flute carbide flush-trim bit provides a 1/8" inside corner radius.**

Carbide-tipped saw and router blades should be used for cutting. High tool speed and low feed speed are advisable. Cutting blades should be kept sharp. Use a hold-down to prevent any vibration. For saws, such as table or panels saws use sharp, carbide tipped blades with 60 or more triple-chip design teeth and with a low to 5° negative hook angle. When cutting ColorEdge material, use proper support (scrap wood) material to assist in support and help eliminate chipping.

**FAB TIPS: keep all tooling sharp and clean (2-Flut Carbide Spiral-Down bit is recommended)**

Routers for ColorEdge fabrication must have carbide tips, kept clean and sharp at all times. Basic laminate trim routers with standard laminate two-flute flush cutters and bottom-bearing guide are recommended.

Various other types of carbide tip bits are also recommended such as slight round-over and bevel bits to finish the edge profiles. Light finishing can be achieved with a fine-ribbed file and/or sanding block with finishing sandpaper. Belt sanders, shears, and slitters are not recommended to be used on ColorEdge material.

**FAB TIPS: Standard edge options recommended are 5/32" round over and 45° bevel, adjusted to the correct height these profiles will provide good wear with a nice attractive look.**

**FAB TIPS: The use of felt on the bottom of all router base plates is recommended. This will protect the surface of the ColorEdge face material.**

### **Care and Maintenance**

The ColorEdge surface may be cleaned with warm water and mild soaps, such as those used for hands or dishes. Do not use cleansers that contain abrasives, acids or alkalis; they will damage the decorative surface. Remove stubborn stains with a w-minute exposure to hypochlorite bleach such as Clorox®, followed by a clean water rinse.

Free copies of the "Care and Maintenance Guide", which covers all Arborite products are available. The guide can be accessed at <http://www.arborite.com/us/HPL-Technical-Information> or by calling our hotline at 1-800-361-8712. It can be used for your own information, for project manuals, and for provision to clients and contractors involved with interior construction and finishing.