

## Technical Data Sheet Veneer Backer VC300+

VC300+ is a high-grade veneer backer with one-side glue coating for application onto veneer in hot presses without needing additional glue. Due to the high resistance of the carrier material VC300+ is particularly suitable for lamination of large-sized veneer sheets.

### Carrier Material

The carrier mainly consists of long-fibrous cellulose. Synthetic fibres as well as latex binder are admixed for increasing tearing resistance and flexibility.

### Glue Coating

The glue coating is applied from a water-based system. In combination with sufficient press temperature and pressure it provides a very heat- and water-resistant glue bond. The closed surface of the glue avoids penetration of water or solvents.

### Processing

For the pressing process no additional glue is required. As consequence of frequent tolerances in veneer thickness we recommend to use a press cushion or to press several veneer layers at one time. The following pressing conditions base on our own experience. Please consider that all types of wood and all presses are different. Therefore it is absolutely necessary to carry out own tests.

pressing time	minimum 30 seconds (*)
pressure	minimum 6 kg/cm <sup>2</sup> , ideally 10 kg/cm <sup>2</sup> or more
pressing temperature	120°C - 140°C (**) / 250°F - 290°F (**)

(\*) When pressing several veneer layers at one time please increase pressing time according to number of layers.

(\*\*) The pressing temperature of 140°C (290°F) is necessary to activate cross linking reactions in the glue in order to provide maximum heat and water resistance of the glue bond.

### Main Applications

production of flexible veneer sheets, particularly for flexed and sanded sheets  
manufacture of veneered doors  
production of moulded plywood

### Product Properties

maximum reinforcement at high flexibility  
increased productivity due to low pressing time  
good bonding of carrier's back side to various kinds of glue  
different colors and widths available

### Physical Properties

weight	approx. 150 g/m <sup>2</sup>
thickness	approx. 300 µm (12 mil)
tensile strength longitudinal	4.500 N/m
tensile strength lateral	3.000 N/m

### Storage

temperature	cool storage, by short-term up to 50°C (120°F)
humidity	dry storage, protect against water and humidity
shelf life	minimum 6 months

### Form of Delivery

packing	rolls on pallets
roll length	250 l.m. (820')
production width	1.270 mm (50") or 1.550 mm (61")
inside diameter	76 mm (3")