

## Tools & Materials

Before you begin, we suggest you read through these instructions to familiarize yourself with the entire application process. A grasp of the tasks ahead as well as being prepared with the correct materials and tools is necessary to facilitate a smooth and successful application.



We recommend you gather the items in this section as a start.

1. Sheet Veneer
2. The Substrate of Your Choice

## Bonding



The desired bond will make the two pieces one, created with the proper amount of both adhesive and pressure. Pressure can be applied mechanically in a press or with rollers. If done by hand, fiber or wood scrapers are best. Do not use J-rollers. Contact your local distributor for a veneer scraper.



Position separator sheets, hardboard separator strips or waxed papers between the backed veneer and the contact cemented substrate. Be sure separators completely cover the area coated with contact adhesive. One application approach, the Centerline Method shown left, makes initial contact down the centerline of both the sheet and the substrate. Grasp the top half of the sheet and pull it taut. Lower the tightly stretched sheet and carefully move the underlying separator away from the centerline. Use extreme care. Once the cement has come into contact with the backer, it cannot be repositioned. Starting in the center of the surface, pull the scraper in the direction of the grain. Push down with both hands as hard as possible in overlapping strokes as illustrated below. Pull away underlying separators as you go until the top half is affixed. Repeat this process on the bottom half until the entire sheet is adhered. After you have bonded the



The Centerline Method is one approach to the bonding process that has proven successful in the delicate task of positioning the veneer exactly.

sheet veneer to the substrate, allow it to sit. Wait at least four to six hours, or overnight, before applying any sealers or finishes to a veneered surface. This allows the adhesive gasses time to properly vaporize and thus facilitate the required bond.

**Air Bubbles ...** result from using J-rollers, from a lack of adhesive or insufficient application of pressure. They are able to be repaired.

First, slit the bubble with a utility knife in the direction of the grain. Second, apply a combination of heat and pressure with an iron. Be sure to use a protective sheet on top of the veneer surface and keep the iron moving. This process should reactivate the bond, given adhesive coverage was sufficient.

Scraping the veneer thoroughly with substantial force and pressure is the second step to a successful application. Remember: scrape hard, scrape light and scrape in the grain direction. Beat down on the scraper with your full weight, using both hands.



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## Application Instructions

**F**lexible veneer laminates are readily available and easy to use. We are pleased to introduce you to the application procedures that we recommend for best results. If you follow these basic instructions, you will surely be successful in your woodworking projects.



Before bonding, it is important to acclimate the sheet veneer and the substrate to which it will be affixed for at least 48 hours. Lay out the materials together, allowing them to relax. Use boards or panels to flatten sheets showing any curl.

## Preparation

For best results, two smooth surfaces are required. It is critical that both are absolutely clean and free of dust. Holes, depressions, indentations or raised areas should be filled and evenly sanded. Unprimed metal substrates should be coated with a good quality rust inhibiting primer following the paint manufacturer's instructions. Primed surfaces that have been scratched to bare metal should be spot primed and sanded smooth.

**Absolutely do not install sheet veneer over sheetrock, drywall or substrates that have been treated with fire retardant agents.**

Last, clean the back of the veneer sheet as well as the substrate with air pressure and gently wipe down with denatured alcohol.



3. Contact Cement

4. Separator sheets or strips

Veneer Scraper



## Problems to Avoid

**Ridges...** result from inadequate adhesive coverage or drying time. If there is a stringy residue when the sheet is pulled away from the substrate, the adhesive was not fully cured before bonding.

## Adhesive



Most often, the adhesive of choice is contact cement because it is readily available and is the easiest to use. In this application, contact cement, a flexible adhesive, will be used to lend a flexible overlay to a rigid substrate. Determine how many

coats the substrate will require. Keep in mind, more adhesive is always better than less. Be sure that there is 100% full and even coverage on both the back of the veneer sheet and on the face of the substrate. This can be achieved by either rolling, brushing or spraying.

Allow the adhesive adequate time to dry. The time can vary depending on ambient moisture, temperature and air flow around your work area. Read the label or check with your adhesive supplier to find the drying time that is right for your conditions and the adhesive



you are using. A successful adhesive application is vital to this process. With the appropriate quantity, thorough coverage and the required drying period completed, you are ready to move forward into the bonding phase of your veneer application project.



Thoroughly applied, full and even coverage of your adhesive is the first step to a successful veneer application.



## Finishing



Commercially available finishing systems will work effectively on sheet veneer. Bleaching processes are not recommended. When you begin finishing, remember, wood moves when moisture is either added or removed. Thus, it is best to apply your sealer coat in stages. The veneer can be stained if the stain is applied sparingly with a cloth. Lacquers and shellacs can be applied successfully with knowledge of technique and equipment. A sealer coat sprayed in a very fine mist often works with great success. It is important not to flood the surface in one coat. Be sure to check with your finish supplier for recommendations for products and application procedures. Upon completion, inspect the finished panel by shining a light across the grain. Insure that any problems are addressed before proceeding with your woodworking project.



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