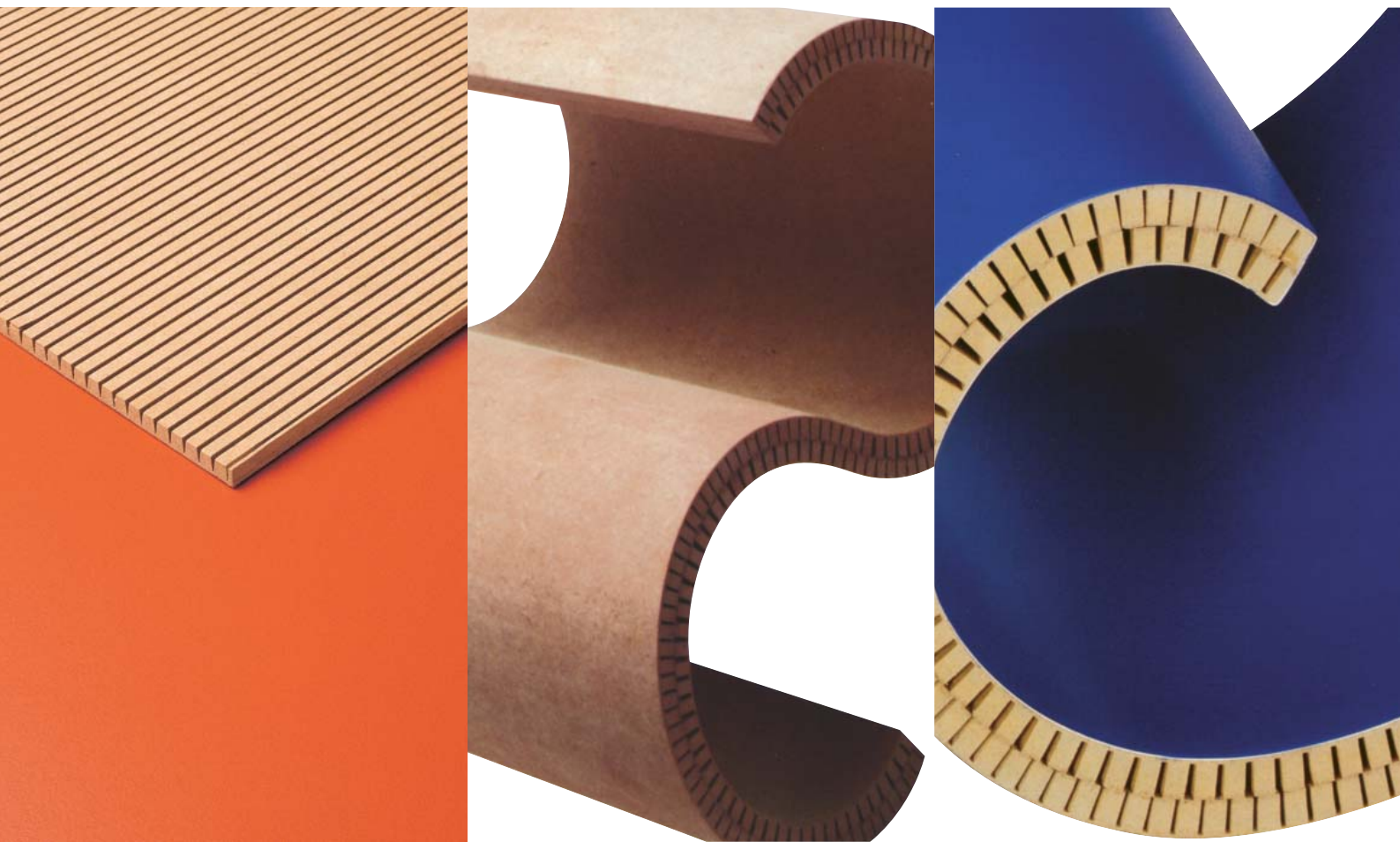


Craftform®

The tradesman's essential guide



another **trade essential** from
THE laminex GROUP™

Craftform[®]

The tradesman's essential guide

The Craftwood[®] panel with unlimited possibilities

Trade Essentials[®] Craftform is the Craftwood[®] panel with unlimited possibilities for quick, easy and cost-efficient production of large curved areas. Large and small radii can be produced without splitting and without recoiling. This is possible due to precise industrially cut grooves at even intervals and depths.

Circular construction



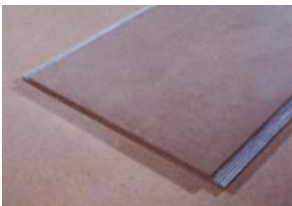
Circular construction



1. First of all, construct a template out of particleboard. To achieve an exact moulding over the whole surface, keep a maximum distance of 250mm between the ribs.



2. Apply **Craftwood® PVA Adhesive** with a glue roller to the grooved sides that are to be joined together.



3. Place glued boards together, bearing in mind that when constructing circular forms the interior radius is smaller than that of the outer board and therefore the two boards are to be of different width.



4. Secure boards with clamps to the lower half of the template.



5. There should also be further pressure between clamps in a longitudinal direction, e.g. use timber straight edge.



6. After 5 hours curing time, take the shell half out of template.



7. Level both longitudinal edges on the planing machine in order to achieve well-fitting gluing of the upper and lower 'shell halves'. Use locating dowels or Lamello tongues.



8. When bonding two halves use gap-filling two-component glue such as Epoxy.



9. Apply glue with spatula.



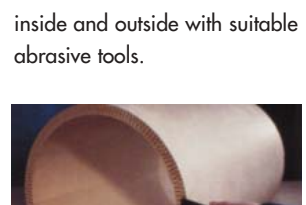
10. After application of the glue on both longitudinal edges, add upper shell. To prevent sticking on the template, use sealing tape in the area of the separating joints.



11. Produce the necessary pressure using clamps. Use sealing tape in the area of the glue joint to prevent the clamps sticking.



12. Sand down the finished item inside and outside with suitable abrasive tools.



13. Fill the open notches with two-component filler.

The MDF board you can bend into a variety of shapes

Craffform® truly is the MDF board you can bend into a variety of shapes. Both circular and undulating constructions, and a high quality finish are easy with Craffform® MDF when you follow the tips in **The tradesman's essential guide**.



Undulating construction



Undulating construction



1. Construct a template out of particleboard. To achieve an exact moulding over the whole surface, keep a maximum distance of 250mm between the ribs.



2. Use edge strip for all ribs of the template so that boards which are to be moulded slide easily into the template. Also helps to avoid damaging the surfaces.



3. In case of extremely narrow radii we recommend you moisten external surfaces in order to achieve greater flexibility during the moulding.



4. Apply **Craftwood® PVA Adhesive** glue with a glue roller on the internal surfaces if two boards are to be joined together.



5. Put the boards which are to be pressed together between upper and lower templates, gradually.



6. Press the boards together – either by using a screw press or hydraulic press.



7. Take the moulded part out of the template/former after 5 hours curing time.



8. After cutting to the required sizes, further processing of the curved surfaces can be carried out.



9. Use a two-component filler to fill the open notches.



10. Apply filler with spatula.

The finishing touch

Once you've crafted Craftform® MDF into the precise shape you wish, all that is left is the finishing. The following finishing tips ensure your construction has the unique appeal that only Craftform® MDF can deliver.

Finishing



1. Veneering

Craftform® MDF can be veneered and painted easily. The veneer is best applied before the wood is shaped. Adhesives used in heat-bonding are suitable for gluing the smooth non-grooved side. Flexibility of the glued joints can be ensured by using **Trade Essentials® Cross Linking PVA**.

The glue must be applied sparingly in order to prevent it from bleeding through on account of the surface density of Craftform® MDF. Press-bonding is carried out at temperatures normally used for particleboard and MDF. The veneered side will be tubular if the grooves in the board run parallel to the grain in the veneer. A lesser degree of bending will result if the veneer is applied at right angles to the grooves. After cooling and subsequent shaping, the board must be sanded on the veneered side to eliminate any polygon effects.

2. Surfacing

The formability must be taken into account when selecting surfacing materials. A radius of less than 200mm should be avoided if the surfacing material is less than 0.8mm thick, otherwise the grooves on the reverse side of the board will mark through onto the surfacing material. Also, in most cases, matt or high-gloss plain-coloured decorative finishes are only suitable for large-radius bends, although much smaller radii are possible when using sturdy imitation wood finishes. The steps for surfacing are the same as for veneering, except that sanding is not required.



3. Craftform® extension boards with offset butt joints

If the standard Craftform® width panel is not adequate, additional boards can be butt-joined and glued together. A sandable glue such as Craftwood® PVA should be used for this purpose to avoid joint marks. Care must be taken to ensure that the joints are flush; any irregularities can be sanded down after approx. 2 hours setting time. This also applies for the 2-layer construction of boards which are bonded with the slit sides together in order to obtain a permanent shape after pressing in a template. The glued joints should be generously off-set in order to improve the stability.



4. Combining pre-formed Craftform® elements

Pre-formed Craftform® elements can be combined if the standard panel width is not sufficient or if extension boards cannot be used due to weight and size limitations. The elements are simply joined together using dowels or Lamello loose cross tongues. A continuous tongue-and-groove connection is not recommended.

Note: When Craftform® MDF is overlaid with timber veneer or laminate, the minimum radius may be reduced.

Craftform® MDF technical details

Craftform® is an innovative Medium Density Fibreboard (MDF) product featuring specially machined V-grooves which provide enhanced flexibility of the MDF sheet. This flexibility allows for creative shapes to be formed, with a radius of down to 200mm being achievable. The Craftform® substrate is 9mm Moisture Resistant MDF which provides added security in areas of humidity and accidental wetting.

Applications

Craftform® panels are recommended for interior joinery applications where a flexible substrate is required. The substrate can be used either as a supporting material for further decorative finishing or as the feature itself. Craftform® MDF is ideal for fabricating into curved furniture and formed shapes for counter fronts, gondolas, displays and other decorative featured joinery.

Insulation properties

Thermal conductivity varies with thickness. Usual range is 0.05 to 0.08 kcal/m Sec. °C.

Note: A PVA adhesive such as **Trade Essentials® Craftwood PVA** is recommended when creating forms using Craftform® MDF.



Bending properties

This is a feature of Craftform® MDF, allowing fabrication of the 9mm MDF sheet into curves and shapes down to a minimum radius of 200mm.

Dimensional stability

Length 0.4% Thickness 5.0% with changes from 35% Relative Humidity to 85% Relative Humidity (relative to datum point of 65% Relative Humidity).

Moisture resistance

Craftform® MDF complies with the Wet Cyclic Test for moisture resistant properties as specified in AS/NZS 1859.2: 2001 (Int). Refer to the Physical Properties table for details.

Safety and handling

Craftform® MDF is a reconstituted wood product containing wood, resin and wax. Machine tools should be fitted with dust extractors and the wearing of a dust mask and eye protection is recommended. Material Safety Data Sheets for Craftform® MDF are available on request from any branch of The Laminex Group.

Physical Properties

(Typical physical properties when tested to AS/NZS 1859.2: 2001.Int)

Property	Board Thickness	
	Unit	9mm
Board Density	Kg/m ³	760
Internal Bond	KPa	1,000 av.
Modulus of Rupture	MPa	42 av.
Modulus of Elasticity	MPa	3500 av.
Surface Soundness	MPa	1.0
Moisture Content	%	6-9
Thickness Swell 24hr	%	10
Moisture Resistance	Test	V313
General Board Weight	Kg/m ²	6.8

Fire Hazard Indices

(Typical achieved when tested to AS/NZS 1530.3: 1989)

Indices	Result	Range
Ignitability	14	0 - 20
Spread of Flame	8	0 - 10
Heat Evolved	7	0 - 10
Smoke Developed	4	0 - 10

Trade Essentials®

Product Range

- Adhesives • Craffform® • Craftwood®
- Craftwood® Mouldings • Particleboard
- Particleboard Flooring • Whiteboard

Craffform® MDF is marketed and distributed in Australasia by The Laminex Group

The information contained in this technical publication is intended to give a general indication of the characteristics of the material. While all possible care has been taken to ensure that the information is correct, the manufacturer cannot accept any liability, nor is any liability on the part of the manufacturer to be implied as a result of the data given. All measurements shown are in millimetres and nominal unless otherwise stated. The information contained in this publication supersedes all previous information and is subject to alteration without notice.

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