



The Fusion Of Science And Art™

TECHNICAL DATA SHEET

FiberBak Series™

2019-21 ver01

About FiberBak Laminates

- General Guidelines
- Basic Limitations
- Standard Sizes And Colors
- Repair and Maintenance
- Technical Properties
- Warranty Data
- Certifications
- Machining
- Care And Maintenance
- Applications

FiberBak™



Deco Technologies Inc.

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Deco Technologies Corporation

FiberBak Series

General Description

DECO FiberBak Series laminates are a decorative polymer finish applied to high basis weight saturated kraft paper ideally suited for use in door skins, architecture shapes, office furniture, fixtures and casework, column cladding, interior wall applications, displays, signage, and other decorative and functional applications.

Basic Limitations

DECO FiberBak Series are a veneered laminate series meant for decorative or non-critical structural applications. It is not intended for use as a structural component in any application regarding safety, support for humans, or in applications where metal fatigue or failure could result in injury, death, or ancillary property damage. DECO FiberBak Series laminates should not be subjected to temperatures higher than 150F for substantial periods of time.

Finishes

DECO FiberBak Series laminates are available in many standard and hundreds of special order finishes including 3D woodgrains, metallic, abstracts, and stones. Custom matched finishes are available.

Standard Sheet Sizes

Deco FiberBak Series laminates are manufactured trimmed to nominal or with a "shaggy" edge allowing customer a 1" oversizing to trim during layup processing. "Shaggy" is by far the most common.

| Sheet Trim | Width | Length | Nominal Thickness |
|------------|-------|----------|-------------------|
| Nominal | 48" | 96"/120" | .030" |
| Shaggy | 49" | 97"/121" | .030" |

Typical Properties Surface

| Test | Standard | Deco FiberBak |
|------------------|---|--|
| Surface Abrasion | JAS Abrasion A | Less than .1g abrasion loss in 100 cycles |
| Anti-Scratch 1 | Pencil Hardness JIS-K5400 (500 grams of weight) | B-2B |
| Anti-Scratch 2 | Hoffman Scratch Test (WT) | 200-300g No Appreciable Change |
| Steel Wool | Steel Wool #0000 1.5kg of WT | No Appreciable Change |
| Color Fastness | Xenon Meter | No Appreciable Change 300 hrs (E codes 5000hrs) |



At A Glance

Higher 90# Basis Weight Paper
No Added Formaldehyde (NAF)
GreenGuard Gold Certified
Stronger Than Other Kraft Backers
Excellent Moisture Resistance



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| Test | Standard | Deco FiberBak |
|--------------------------------------|----------------------------|-----------------------|
| Heat Stability | NEMA 11-14-95 | No Appreciable Change |
| Chemical Resistance | | |
| Benzene | | |
| Ethanol | | |
| n-Hexane | | |
| HCl – 10% | NEMA 11-14-95 | No Appreciable Change |
| NaOH – 10% | | |
| H ₂ SO ₄ – 10% | | |
| Ca(OH) ₂ - Saturated | | |
| Solvent Resistance | | |
| Toluene | | |
| MEK | NEMA 11-14-95 | Some Change |
| Ethyl Acetate | | |
| Acetone | | |
| Abrasion Resistance | ASTM D-1044 | 5000 cycles min |
| Impact Resistance | 8 oz Steel Ball Dropped 2" | No Change |
| Stain Resistance | | |
| Distilled Water | | |
| Orange Peel | | |
| Lemon Peel | | |
| Mineral Oil | | |
| Cloudy Ammonia | | |
| Chlorox (Cleaning) | | |
| Milk | EN 438/2.15 and NEMA | No Appreciable Change |
| Cola | LD3.4 | |
| Coffee | | |
| Tea | | |
| Ketchup | | |
| Prepared Mustard | | |
| Bacon Grease | | |
| Hamburger Grease | | |

Typical Properties Substrate

| Test/Condition | Standard | Deco FiberBak |
|--------------------------|-----------------|---------------|
| Density | lbs/cubic foot | 62.2 |
| Hygroexpansivity-Cross | %change 50-70rh | .411% |
| Hygroexpansivity-Machine | %change 50-70rh | .275% |
| Tensile-Cross | lbs/lineal inch | 197 |
| Tensile-Machine | lbs/lineal inch | 363 |



Many Uses

Door Skins
Column Wrapping
Signage
Vertical Panels
Partition Skins



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| Test/Condition | Standard | Deco FiberBak |
|--------------------------|-----------------|----------------|
| Flame Spread Rating | 0-25 ASTM E84 | Class A |
| GreenGuard Certification | UL | Gold |
| Optimal Bonding Cond | 45-50%rh 70-75f | PVA or Contact |
| Min Curve Radius | N/A | 3" |

Use And Machining

DECO FiberBak Series laminates may be used with most manufacturing equipment including; perforators, saws, edge banders, laminators, routers, etc..

DECO FiberBak laminates may be laminated to most surfaces such as particleboard, medium density fiberboard (MDF), high density fiberboard (HDF), fiber reinforced gypsum board (FRG), straw/wheat stalk board, or "A" sided plywood. Cracks or porous areas should be filled with the appropriate filler to provide a smooth bonding surface, and an adhesive compatible with the substrate is used. Deco FiberBak laminates should not be applied directly to non-reinforced gypsum, concrete, masonry, or other similar surfaces as warping and bond failure may occur. FiberBak laminates may not be used as structural members or supporting components.

For laminating applications virtually any adhesive that is compatible with paper and/or wood will perform well. Follow the techniques recommended by the adhesive manufacturer. Even edge-to-edge coating is recommended for best results. Roll coating with PVA and PUR adhesives work well.

When routing or sawing, use of carbide-tipped saw and router blades is advisable. High tool speed and medium-fast feed rate will produce the best results. To prevent tearing of the surface or the substrate layer, use clamps or other hold-down devices when sawing, routing, or drilling.

Protective Polyfilm Use

Protective removable polyfilm will be applied only when directed by the customer. Deco Technologies Inc. does not recommend the use of protective polyfilm unless other means of scratch or abrasion prevention prove unsuccessful in the manufacturing or final installation. The use of polyfilm in general leads to increased cost, waste when removed, and can prove difficult to remove after manufacturing if heat was used in processing.

Light Fastness

Standard laminates are for interior or shrouded exterior applications such as soffits, overhangs, ceilings, or other installations that are not in direct sunlight. The use of DECO laminates in direct sunlight applications should be avoided unless used for temporary applications as fading can occur. Direct sunlight rated laminates are available on special order basis.



Easily Machined

Cold Bonding
Pressing
Routing
Sawing
Edgebanding
Perforating
Drilling
Sawing



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Warranty Statement

DECO Technologies warrants that, DECO FiberBak Series laminates under normal use, will conform to the standards set forth by this technical data sheet for a period of sixty (60) months from the date of sale to the first consumer purchaser. DECO Technologies Inc. will also warrant for a period of LIFETIME years against de-lamination of the artwork from the backer substrate. In the event that this product does not perform as warranted, the first purchaser's sole remedy shall be limited to repair or replacement of all or any part of the laminate product that is defective, at the manufacturer's sole discretion. This warranty applies only to product in its original installed form from the first consumer buyer. This warranty is not transferable, and expires upon resale or transfer by the first consumer purchaser. This warranty shall not apply to defects or damage arising for any of the following caused by accidents, abuse, improper installation or fabrication, misuse, or failure to properly prepare the bonding surface.

NO OTHER WARRANTIES, EXPRESS OR IMPLIED, ARE MADE. UNDER NO CIRCUMSTANCES SHALL DECO TECHNOLOGIES INC. BE LIABLE FOR ANY LOSS OR DAMAGE ARISING FROM THE PURCHASE, USE OR INABILITY TO USE THIS PRODUCT, OR FOR ANY SPECIAL, INDIRECT, INCIDENTAL OR CONSEQUENTIAL DAMAGES. NO FABRICATOR, INSTALLER, DEALER AGENT OR EMPLOYEE OF DECO TECHNOLOGIES INC. HAS THE AUTHORITY TO MODIFY THE OBLIGATIONS OR LIMITATIONS OF THIS WARRANTY.

This warranty gives you specific legal rights, and you also may have other rights that vary from state to state; therefore, some of the limitations stated above may not apply to you. It is to your benefit to save your documentation upon purchase of a product.

Care And Maintenance

The decorative surface may be cleaned with warm water and mild detergents or dishwashing soaps. Do not use cleansers that contain abrasives, they will scratch or damage the decorative surface. Household cleaners such as Fantastik®, 409, and other like products may be used on stubborn stains. Always test any new cleaner in an inconspicuous spot to ensure no degradation of the surface will occur.

Do not allow any of the following chemicals to remain in prolonged contact with the decorative surface:

- Acetone
- Bleach (except for disinfecting)
- Greater than 10% solutions of hydrochloric, sulfuric, or nitric acid
- Caustic solutions containing lye (drain cleaners commonly use lye)
- Sodium bisulfate
- Potassium permanganate
- Juice from staining berries
- Violet (genetian)
- Bluing
- Fabric dye
- Alcohol containing iodine
- Hydrogen peroxide solutions



Easy Maintenance

- Moisture Resistant
- Surface Easily Cleaned
- Resistant To Most Stains
- No Off Gassing
- Graffiti Resistant
- Repairable



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Repair and Finishing

DECO laminates can be finished with topcoats for higher gloss and durability. Finishing steps must be in accordance with the manufacturers' application instructions and performed when the laminate is in its final bonded position. Cracking, crazing, or complete de-lamination of the topcoat may occur if applied to sheet prior to bonding or forming. Always test any topcoat bond and finish on a sample to ensure topcoat meets desired finish quality. Surface should be 40 dyne minimum before applying topcoat. Corona, blown plasma, and/or flame treating may be needed to raise surface above 40 dyne. Care should be taken to not scorch surface.

Repair of scratches and gouges can be done through the use of high-quality furniture repair kits. Follow repair kit instructions. Avoid repair kits that use an iron in direct contact with the veneer surface as this may increase the gloss level of the finish in that area. Please note that this method will not provide a complete repair if damage is extensive.

Technical Questions

For technical assistance with any of the following technical specifications, please contact us at 866-757-9845, Monday through Friday, 8 a.m. – 5 p.m. EST.



Excellent Properties

Formable To 3" Contours
Excellent Moisture Resistance
Sanded For Improved Bond
Economical



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