

# WORKING WITH **PolyBak** LAMINATING BEST PRACTICES

**PolyBak**  
by RICHWOOD

## STANDARD PRESS SETTINGS

### HOT PRESS SETTINGS

|                          |                                  |
|--------------------------|----------------------------------|
| MILS OF ADHESIVE:        | 3 - 6 WET (PVA ADHESIVE)         |
| PRESS TEMPERATURE RANGE: | 190° - 230° F (88° - 110° C)     |
| PRESSURE (PSI):          | HPL: 35-45; VENEER: 60           |
| PRESS TIME:              | TYPICAL RANGE: :53 SEC - 3.5 MIN |

#### Notes:

For best results, acclimate all materials to the same temperature before beginning the lamination process. Substrates over 100° F will rapidly shorten the open/closed assembly time. At this temperature, additional adhesive may be needed.

### COLD PRESS SETTINGS

|                             |  |
|-----------------------------|--|
| MILS OF ADHESIVE:           | 6 - 8 WET (PVA ADHESIVE)                           |
| ADHESIVE TEMPERATURE RANGE: | 60° - 70° F & ACCLIMATED TO SUBSTRATE              |
| PRESSURE (PSI):             | HPL & INDUSTRIAL PRODUCTS: 35-45; SOFTBOARD: 40-50 |
| PRESS TIME:                 | AVERAGE: 30 MIN                                    |

#### Notes:

For best results, acclimate all materials to the same temperature before beginning the lamination process. The information listed above is to be used as a general guideline for cold and hot press laminating. Various adhesive products require different settings and coverage. Contact your adhesive representative for product specific requirements.

## CAN'T GET IT TO STICK?

- Do you have *uniform* coverage with the proper adhesive?
- Are your glue rollers unevenly worn?
- Was the amount of adhesive on the top and bottom of the board the same?
- Was your adhesive acclimated to the same temperature as the other materials used?
- Did you use the correct open and close assembly time?
- Did you use the correct press pressure?



## STILL NEED HELP?

Contact our Sales Engineer - Rich Rivera  
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