

TECHNICAL DATA

SUPPLIER

Octopus Products Limited
23 Gurney Crescent
Toronto, ON
CANADA M6B 1S9
Phone: (416) 531-5051 or
Toll free: 1-877 OCTOLAM

TECHNICAL DATA

| | |
|-----------------|--------------------------|
| Sheet Width | 1220.0 mm (0 + 20 mm) |
| Sheet Lengths | 2440.0 mm (0 + 20 mm) |
| Sheet Thickness | 2.2 mm (-0.2mm + 0.2 mm) |
| | 1.5 mm (-0.2mm + 0.2 mm) |

Typical Fire Test Data

In order to achieve Class A fire rating, an approved fire rated lacquer or coating must be used as per manufacturer's instructions.

Physical Properties

Veneer moisture content: 12-15%.

Formability

Non-post forming, flat work only

Dimensional Stability

1. NEMA - Dimensional Changes

Machine Direction: 0.5242 %

Cross-machine Direction: 0.9609 %

2. Room Temperature - Dimensional Change

Machine Direction: 0.4935 %

Cross-machine Direction: 0.1843 %

Others:

NC surface coating: Meet the requirement of European Communities Commission Directive 1999/10/EC (Establishing the ecological criteria for the award of the Community eco-label to paints and varnishes)

FABRICATION

Conditioning

They are sensitive to ambient conditions (temperature and humidity). Due to their real wood surface, the panels are slightly more sensitive to warping than conventional laminates.

Prior to gluing, they have to be perfectly conditioned. If they are glued when moist, there is a risk of cracking due to shrinking of the wood, particularly in winter when humidity often falls below 20%.

The best method of conditioning is to store substrates and panels for a period of 8 to 10 days (min. 24 hours) in the same room where the atmospheric conditions are the closest possible to those of the site where they are to be used. This is especially important in the case of overheated rooms without humidity control. Ideal conditions are:

- Temperature: 18 C to 22 C

- Relative humidity: 50% to 60%

There is a risk of cracking due to shrinkage of the wood if the panel is used too moist, while too dry a panel may expand with, as a result, warping or blisters on the surface, if gluing was not perfect.

Conditioning is effective only if air circulation is possible between the sheets during storage. When substrates are to be faced on both sides it is advisable to stack panels and substrates in the same sequence as their eventual construction in order to achieve hygrometric balance. A dry atmosphere is preferable to high humidity.

Substrates

The panels can be applied to all kinds of base material having a perfectly flat and thoroughly clean surface, such as particle board, MDF, etc, with the exception of solid wood.

Gluing to metal requires careful preparation of the surface, particular attention being paid to thorough degreasing with a strong solvent, for example, trichloroethylene.

It is recommended to use substrate with thickness over 15mm.

Fabrication

Sawing °C milling °C drilling: can be done with all tools currently used for the fabrication of laminates. Avoid sawing, milling, drilling on the cross section of the braided wood veneer. Use white PVAc glue to bond the chipping edge and iron out the surface by hot iron.

In the application with BWVL length over 1000mm, then the whole panel thickness should be thicker than 11mm, which means the substrate should be thicker than 8mm, plus BWVL (2.2mm) and the balance backside backer (0.8mm).

Consult the professional carpenters in the veneer product field, would know how to treat this live product.

Gluing

The surface to be glued must be sound, thoroughly dry, clean and free of dust, wood chips and oil. Gluing with the use of a press is the safest method. Conventional adhesives normally applied to laminates are recommended, such as, vinyl glue, formol urea glue, etc.

When a press is used in the bonding process, apply a thick flat board in between each braided veneer surface for protection.

Surface treatment

Depending on the product, nitro lacquers or two-component lacquers can be used. Do not use water-based lacquers or water-based wood stain for any of our products! We recommend conducting lacquer tests prior to every lacquer run.

Lacquering with cup gun. The best surface results, however, are achieved with the Airless method.

Instant repair

Tools

- a) Iron
- b) Wood Carving Chisel & Carpenter's flat chisel
- c) Utility Knife
- d) Forceps
- e) Scraper
- f) White PVAc Glue
- g) 300 mesh sandpaper (check with your carpenter veneer expert for a suitable one)

Phenomenon I: Bubble

- a) Bubble occurs underneath the wood veneer
 1. Using an utility knife to cut through the bubble

2. Filling the white PVAc glue underneath the veneer and then pressing down firmly
3. Hardening the glue and ironing out the surface by a hot iron
4. Smoothing the surface by chisel in the direction of veneer texture
5. Polishing gently by sandpaper
6. Varnishing

b) Foreign particles underneath the wood veneer

1. Using an utility knife to cut an opening around the defect area;
2. Using a forceps to peel up the veneer and take out the foreign particles;
3. Filling in the white PVAc glue underneath the veneer and then pressing down firmly
4. Hardening the glue and ironing out the surface by a hot iron
5. Smoothing the surface by chisel in the direction of veneer texture
6. Polishing gently by sandpaper
7. Varnishing

Phenomenon II: Veneer sting or veneer turn up

1. Filling in the white PVAc glue underneath the sting or veneer turn up area and then pressing down firmly
2. Hardening the glue and ironing out the surface by a hot iron
3. Smoothing the surface by chisel in the direction of veneer texture
4. Polishing gently sandpaper
5. Varnishing

Phenomenon III: Wood Hole caused by wood knur or Veneer Breakage

1. Making up the hole or veneer breakage by the same wood veneer strip
2. Filling the white PVAc glue underneath the veneer strip and then pressing down firmly
3. Hardening the glue and ironing out the surface by a hot iron
4. Smoothing the surface by chisel in the direction of veneer texture
5. Polishing gently by sandpaper
6. Varnishing

Phenomenon IV: Surface scratch or dent

a) Scratch or dent

1. Using scraper to smooth out the surface in the direction of veneer texture
2. Polishing gently by sandpaper
3. Varnishing

b) Veneer crack

1. Cutting off crack veneer cell with an utility knife
2. Insert into the same area with a same size and same type of veneer strip backing with white PVAc glue
3. Hardening the glue and ironing out the surface by a hot iron
4. Smoothing the surface by chisel in the direction of veneer texture
5. Polishing gently by sandpaper
6. Varnishing

Attention

All above data is based on state of the art and our current knowledge and experiences. However, these do not exempt the craftsman from conducting his own tests and experiments. Our experiences shall not be construed to be the basis for a legally binding warrant of characteristics/prosperities or for a warrant of appropriateness for a specific purpose.

In case of doubt, we recommend that you refer to our technical consultants.

CARE & MAINTENANCE

Normally, a slightly dampened cloth can be used to wipe over the surface to remove dust or minor dirt smudges. Care should be taken not to over saturate the cloth so that the liquid itself accumulated on the BWVL. For additional cleaning information, contact your representative at Octopus.

Flat storage and shipped is the best. Store the products face to face with a slip-sheet of paper shown as below. It is recommended to store the BWVL's in an atmospherically stabilized room to avoid extreme fluctuations of moisture. When handling, care should be taken to avoid scratches and cracking of the veneer. The best way to carry panels is with two persons so that the decorative face is on the concave side.

DISCLAIMER 1

Octopus is not liable in any way for final suitability of woods to your intended purpose, nor for any health conditions or accidents that arise during their use.

DISCLAIMER 2

This information and data herein are believed to be accurate and have been compiled from sources believed to be reliable. It is offered for your consideration, investigation and verification. There is no warranty of any kind, express or implied, concerning the accuracy or completeness of the information and data herein.

OCTOWEAVE

FAQ's

Q: Is coordinating edge banding available?

A: Yes. BWVL edge banding is a stress relieved veneer, finger jointed, end matched and backed with 5 mil paper. This product is normally offered in nine popular wood species, in 300cm rolls of 30cm width.

Q: How consistent is the veneer appearance from sheet to sheet?

A: We make every effort to maintain reasonable consistency within each wood species. Naturally, like any real wood product, every BWVL sheet exhibits individual coloration, features and character marks.

Q: How many sheets fit into a 20ft and 40 ft HQ container?

A: Normally, a 20ft container can contain 1,200 sheets; a 40ft container contains 2,400 sheets.

Q: What is the package condition?

A: Usually 200 sheets are packed in one wood crate; each sheet is packed in one paper bag.

Q: What is the minimum quantity order? (Not applicable to Octopus)

A: 50 sheets per design.

Q: What is the lead time?

A: 4-5 weeks.

Q: What are the uses of BWVL?

A: Wilsonart Braided Wood Veneer Laminates (BWVL) are designed for interior applications. These enduring natural wonders are appropriate for vertical areas in commercial market segments such as hotel, office lobbies, theatres, restaurants, chained store, hall, EXPO, where its special eye-catching properties add a definite prestigious. Certain protection should be included when use it in horizontal area.