



**OVERLAYS AND BACKERS FOR WOOD VENEER, PLYWOOD, PARTICLE BOARD, PAPER, ETC**

**Overlay and Backers Comparison Sheet**

Pre-Coated with dry film adhesive. Products available in rolls or sheets. We will be happy to test any combination and provide a free lab report. Please contact us for further information.

Overlays/Backers	20	170TS	160TS	204TSA	208	330TS	360	374	444	610TS	710TS	Clear Overlay Film	Foils	Fold & Mold 3D	Glass Fiber	Rubber
Thickness	.003" - .006"	.004"	.010"	.005"	.001" - .010"+	.005"	.001" - .008"	.001" - .010"+	.001" - .004"	.010" - .020"	.005"	.002" - .020"	.001" - .003"	.017" - .100"	0.055"	.062"-0125"
Minimum Glue Line Bonding Temp	225°F+	290°F/140°C	260°F/127°C	290	220°F/144°C	275°F/135°C	170°F	275°F/135°C	275°F/135°C	250°F/121°C	260°F/130°C	180°F to 250°F	Dribond Adhesive	225°F+	Per Order	Dribond
Press Time At Full Temp (Glue Line)	Seconds	30 Seconds	30 Seconds	1 Minute	10 Seconds	1 Minute	10 Seconds	10 Seconds		1 Minute	1 Minute	10 Seconds+	1 Minute	20 Seconds	Varies	2-3 Minutes
Minimum Pressure - PSI	10 PSI	100+ PSI	85 PSI	150 PSI	10 PSI	90-150 PSI	10 PSI	85 PSI	150 PSI	100 PSI	100 PSI	10 PSI+	20+ PSI	10+ PSI	Varies	10 PSI
Heat Resistance	200°F	Thermo-Set	Thermo-Set	Thermo-Set	190°F	Thermo-Set	Yes	250°F	240°F	Thermo-Set	Thermo-Set	180°F+	200 Dribond Adhesive	200°F	Varies	Variable
Need Release Sheet	Yes	Yes	No	Yes	Yes	Yes	No	Yes	Yes	No	Yes	No	No	No	No	No
Type of Adhesive		Acrylic/Fleece	Woven Cellulose	Phenolic	PE	Acrylic/Melamine	Urethane	Polyester	Copolyamid	Thick Strong Paper	Melamine	Varied	Dribond	#20+	Varies	Varies
Color	Any	Translucent	Cream/Brown/Tan	Tan	Semi-Clear	Translucent/White	Clear	Clear	Clear	Tan	Clear/White	Clear/Any	Reflective	White/Grey/Pink	White	Black
Adhesive Can Reactivate For Second Bonding	Yes	No	No	No	Yes	No	Yes	Yes	Yes	Yes	No	Yes	Yes	Yes	Per Order	Yes
Water Resistance	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Good	Yes	Yes	Yes	Yes	Yes	Yes	Yes
Flame Resistance	Possible	No	Optional	Medium	No	No	No	No	Fair	No	Yes	Possible	Yes	Possible	Yes	Possible
Flexibility	Excellent	Good	3D Moldable	Low	Excellent	3D Moldable	Yes	Good	Good	Good	Fair	3D Moldable	3D Moldable	3D Moldable	Good	Medium
Printability	Good	Fair	Fair	Fair	Good	Yes	Good	Good	Good	Yes	Yes	Yes	Yes	Yes	Fair	Poor
Shelf Life Before Laminated	1 Year +	6 Mo.+ @ 75°F	6 Mo.+ @ 75°F	6 Mo.+ @ 75°F	6 Mo.+ @ 75°F	6 Mo.+ @ 75°F	1 Year +	1 Year +	6 Mo.+ @ 75°F	6 Mo.+ @ 75°F	6 Mo.+ @ 75°F	1 Year +	1 Year +	1 Year +	Per Order	1 Year +
Can Be Flexed	Yes	Yes	Yes	No	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Medium	Yes	Yes	No
Used For:	Carpet backing, non-slip	Backer for Perforated Wood Veneer	Backer for Wood Veneer, Wood Veneer Strengtheners	2 Ply Thermoset Overlay	Pre-Applied Adhesive	2 Ply Balance	Low-Temp Pre-Applied Adhesive	Pop Bottle Boat To Australia	For Flooring, PVC, Vinyl	Rigid Backer, Multiple Layers for Thicker Pieces	Countertops, High Wear, Rigid, Embossable	Protective Overlay	Reflective, Deco	Core, 3D Parts, Signs, Lampshades	Acoustic, Extreme Fire Retard	Backer for Carpet, mat
Surface	Film, Clear, White	Translucent Backer, Balance	Cloth FSC Certified - Fiber/Fabric	Balance	Balance, Adhesive	Thermo-Set Adhesive, Balance	Non-slip Overlay, Balance, Adhesive	Clear Overlay, Balance, Adhesive	Clear, Balance, Adhesive	Thermo-Set, Balance	Overlay, Clear, Fleece/Resin	Surface Protection, Printable, Erasable, High Wear, 18,000 Tabor Balance	Balancing Backer	Printable, Balance, Adhesive	Core, breathable, hydrophobic	Surface protection and non slip cushion
Panel Balancing	Medium	Medium	Medium	Yes	Yes	Yes	Medium	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Poor
Sewing	Yes	No	Yes	No	Yes	No	Yes	Yes	No	No	No	Yes	Some	Yes	Yes	Yes
Clear Overlays	No	No	No	Yes	No	No	Yes	Yes	No	No	Yes	Yes	No	No	No	No
Translucent (Light Transfer)	Yes	Yes	No	Medium	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	No	Yes	Yes	No
Perforates	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Some	Yes	Yes	Yes	Some	Yes	Some	Yes
Laser Cuts	Yes	Yes	Yes	No	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Some	Yes	Some	Yes
Die Cuts	Yes	Yes	Yes	Yes	Yes	Yes	No	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes

In most cases above, the bonding strengths are a function of the following 5 components:

**1. TEMPERATURE** The temperature at the glue line should be checked with a "K" Thermo Couple Thermometer from Cole Palmer-(Catalog #91100-10) at [www.colepalmer.com](http://www.colepalmer.com) or call (800) 323-4340. In addition, you will need "K" type adapter plugs-(Catalog #93840-52) and a spool of very fine teflon coated wire-(Catalog #08541-02). Lenderink Technologies, Inc. will be happy to supply you with all of the above materials together for approximately \$250.00.

**2. PRESSURE =** 
$$\frac{\text{Hydraulic Line Pressure (lbs)} \times \text{Surface Area of Cylinders (in}^2\text{)}}{\text{in}^2 \text{ of Material Being Pressed}}$$
 \*Stacks or multiple pieces can be pressed at one time.

**3. TIME** When the glue line is at full temperature and pressure. Pressing time is often related to temperature and pressure. Higher temperature/pressure settings often allow for a shorter cycle time.

**4. SURFACES** Surfaces being bonded must be compatible with particular dry film adhesive being used. Surfaces must also have compatible energy and texture.

**5. VAPOR/OFF GASSING** Pre-press at full temperature and low pressure before adding Lenderink Dry Film Adhesive, i.e. vapors vacated from surfaces. Vapors cause bubbles and /or poor bonds. Moisture contents of wood should be below 8%, press breathing may be needed.

The above 5 components can be varied some and still provide good bonds. i.e. Temperature increase can often allow for pressure decrease and vice-versa. Extremely slick surfaces may have improved bonds if Corrona Treated and sanded. Start as close to our recommendations as possible. Vary from the recommendations only one variable at a time. If any questions, please feel free to contact us.

Please send samples to our lab for adhesive recommendations so that we may test the material.

**LENDERINK TECHNOLOGIES, INC. 1267 HOUSE STREET NE BELMONT, MI 49306**  
[www.lenderink.com](http://www.lenderink.com) [sales@lenderink.com](mailto:sales@lenderink.com) [www.dryfilmadhesives.com](http://www.dryfilmadhesives.com) [sales@dryfilmadhesives.com](mailto:sales@dryfilmadhesives.com)