### Overlays and Backers for Wood Veneer, Plywood, Particle Board, Paper, etc.

**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.**

**Overlay and Backers Comparison Sheet**

<table>
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<tr>
<th>Thickness</th>
<th>20</th>
<th>170TS</th>
<th>160TS</th>
<th>201TS</th>
<th>208</th>
<th>350TS</th>
<th>500</th>
<th>374</th>
<th>444</th>
<th>640TS</th>
<th>720TS</th>
<th>Dear Overlay Film</th>
<th>Foils</th>
<th>Fold &amp; Mold 3D</th>
<th>Glass Fiber</th>
<th>Rubber</th>
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<tbody>
<tr>
<td>Perforates Clear Overlays Sewing Can Be Flexed Flexibility Color Need Release Sheet Overlays/Backers</td>
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#### Pre-press at full temperature and low pressure before adding Lenderink Dry Film Adhesive, i.e. vapors vacate ... bubbbles and/or poor bonds.

- Moisture contents of wood should be below 8%
- Press breathing may be needed.

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

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

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 #951100-10) at 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 #86541-02). Lenderink Technologies, Inc. will be happy to supply you with all of the above materials together for approximately $250.00.

2. **Pressure**

   - **Hydraulic Line Pressure (lbs) x Surface Area of Cylinders (in²) = 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 Corrorna 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.**

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