QUERKUS
finest oak collection

FLEX
Gluing instructions

zero
ZERO ADDED UREA-FORMALDEHYDE

IMPORTANT

- Querkus Flex is not a laminate but a thin sheet of real wood (veneer) bonded onto paper. Consequently, the finishing of this product requires a different method of application.
- Querkus Flex is delivered sanded with grit 120/150. It can be further sanded if deemed necessary with grit 180 to obtain an even smoother surface.
- Querkus Flex can be glued onto almost any substrate (PVC tubes, wooden panels, table tops, metal, doors,…). It goes without saying that each type of gluing requires its own specific process. Also it has to be checked that the glue used doesn't contain chemicals that can react against finishing products such as lacquer or oil. Querkus Flex may not be bonded to laminated panels.
- Querkus Flex, glue, substrate and finishing products should be stored in the same area or at least at the same temperature and humidity for at least 48 hours. The recommended temperature is between 15°C and 20°C and the relative humidity is between 50% and 60%. If these parameters are not respected, this can lead to ridges between the Querkus Flex and the substrate. It is preferable to leave 4 or 5 days between gluing and lacquering Querkus Flex to be sure that all the solvents from the glue have disappeared.

Note on Querkus Vintage: the subsequently applied finish product can give a color change of the black film between the gaps in the veneer. The adhesion of the finish product on the film should be thoroughly checked before the entire surface is treated.

EQUIPMENT REQUIRED

• In the absence of a veneer press, choose a good quality contact adhesive. In addition to solvent-based contact adhesives, also water-based contact adhesives can be used on the condition that the open time (= time between the application of the adhesive onto the surfaces and the application of the Querkus Flex) is fully respected. Pay careful attention to the instructions of the glue manufacturer. When using a spray-gun (nozzle to be set as economical as possible) it is recommended to spray several thin layers instead of 1 thick layer onto both the Querkus Flex and the substrate, with the necessary waiting time between the different layers. If the gluing is done by a press (hot or cold), then it is recommended to use a PVCA-glue or a UF-glue.

- Glue spatula
- Sandpaper
- Chisel or veneer saw
- Stanley knife
- Stiff scraper or a roller with 2 grips
- A roller with firm mousse
- Hardboard separator strips or Kraft paper
- Decospan press fabric (for Querkus Oak Vintage)

If necessary:
- Iron
- Light

GLUING

Before applying the glue, ensure that all surfaces are free of grease, dust and other dirt. The surface can be cleaned efficiently by denaturated ethyl alcohol.

For contact glue it is important that the glue is applied on both surfaces. If using a glue spatula, apply the glue on one surface at right angles to the other. (Fig. 1)

It is easier, especially on larger surfaces, to use separator strips or craft paper once the glue is dry. (Fig. 2)

For best results apply 2 layers of glue. Pay attention that the drying time is respected (see technical sheet of the glue) before you pass to the following operation.

PRESSING

Start to press from the middle of the board (never begin from the sides). Rubbing from the middle to the sides you can remove the craft paper or the separators one by one. Once the 2 surfaces are making contact they can be properly pressed by using the stiff scraper or the roller with 2 grips. Use body weight for the maximum pressure. (Fig 3). Never use a hammer and block or rollers with only one grip!!!! (Fig. 4)

Note on Querkus Vintage: Open spaces between the veneer strips have to be pressed intensive using a roller with firm mousse. When using a press a compressible press fabric of Decospan must be placed on each Querkus-sheet with the aluminium side against the press plate, which can cope with the differences in thickness in the Querkus Flex.
It is recommended to use a new fabric for each press turn.

FINISHING AND CHECKING

Remove the excess of Querkus Flex veneer with a cutter. (Fig. 5)

By means of floodlight (use a lamp) gluing failures can be detected. (Fig. 6)

When glue or pressure is incorrectly applied, bubbles or ridges may appear.
Ridges: This processing error occurs when there is too little adhesive applied and the relative humidity in the room is too high. When the veneer dries, the expansion and contraction process causes longitudinal splits, cracks & ridges along the grain.
Bubbles: appear where not enough glue was applied to the surface. When cutting the bubble in the middle, you will see that the glue does not hold the 2 surfaces together. By using an iron, you can reactivate the glue to remove the bubble or the ridge when there is enough glue applied between the Querkus Flex and the substrate. Always keep the iron in motion on the Querkus Flex (preferably with a piece of craft paper or cotton in between), in order to avoid discoloration of the veneer by overheating. (Fig. 7)

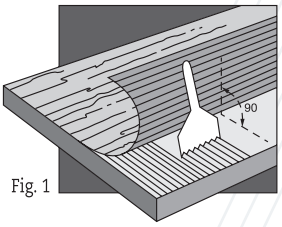

Fig. 1

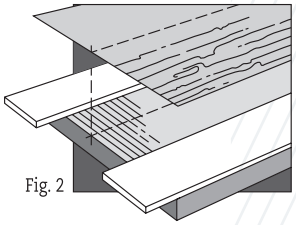
Fig. 2

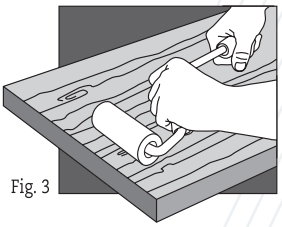
Fig. 3

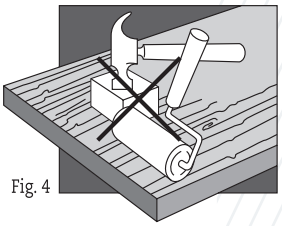
Fig. 4

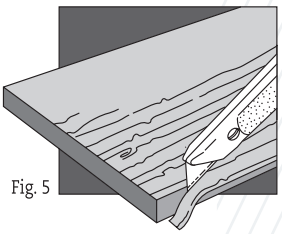
Fig. 5

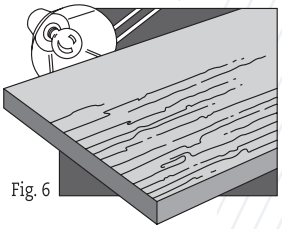
Fig. 6

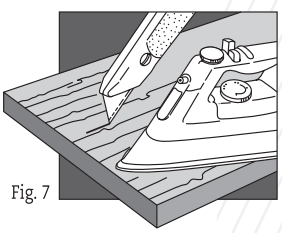
Fig. 7