Specification Information
Richwood Industries Magnetic Dry-Erase Laminate
Phenolic Backed Decorative Laminates **2012**

Richwood Industries Magnetic Dry-Erase Laminate

1. Product Identification:
Richwood Industries Magnetic Dry-Erase High Pressure Laminate (HPL)

2. General Description: Richwood Industries Magnetic Dry-Erase Laminates are composed of a layer of Melamine Saturated decorative paper, a layer of thin iron foil bonded to several layers of phenolic impregnated Kraft paper. The backside of the laminate is sanded to ensure uniform bonding and consistent thickness.

- **Sheet sizes**: 4' x 8'
- **Thickness Available:** 1.0mm thickness (.040")
- **Recommended Uses: Richwood Industries Magnetic Dry-Erase Laminates** are recommended for interior vertical applications. Possible uses are wall coverings, class rooms, office furniture, children's furniture or any area that needs a high quality writable surface with magnetic properties.
- **Not recommended for:** Areas exposed to high temperatures, or exterior use.

4. Installation: Richwood Industries Magnetic Dry-Erase Laminates can be bonded to the following substrate material. Plywood, MDF Board, or Particle Board. Typical contact adhesives or white wood glue can be used. Contact adhesive is recommended. Material should be installed in conformance with basic techniques outlined by NEMA LD-3 for high pressure laminate; or as recommended by your adhesive manufacture.

5. Balancing: We recommend that all **Richwood Magnetic Dry-Erase Laminates** adhered to a substrate should be balanced with a 1.0mm to 1.2mm thick Richwood Phenolic backer on the opposite side of the substrate to help ensure a proper balance to keep finished boards flat.

Cutting and Tooling: Please note that safety precautions must be taken during cutting and tooling when cutting Magnetic Dry-Erase Laminate. Sparking can occur during cutting and edge tooling of Magnetic Dry-Erase Laminates. Cutting Magnetic Dry-Erase Laminate adhered to a substrate, or cutting with the laminate face down or sandwiched between 2 carrier boards will reduce the chance for sparks.

Cutting Specifications:
Circular Saw

Blade Diameter	203.2 to 355.6 mm (8 to 14 in.)
Speed per min.	2438 to 4572 m (8000 to 15000 ft.)

Carbide Tip blades are recommended for cutting Magnetic Laminates. Specific Blades for cutting thin sheet metal can also be used.

Material should be supported near the point of blade contact to avoid vibration that causes chipping. Feeding the laminate into the blade at a rate only as fast as it will cut without forcing the saw. Teeth should be kept sharp at all times.

6. Routing:
Routing may be done with electric or air powered routers. Cutters should be carbide tipped. The speeds recommended are similar to those used in standard laminate cutting practices.
Router speed should be16000 to 22000 rpm. It is important to use a router having adequate horsepower to maintain cutting speeds (based on the type and amount of material to be cut). For unique edge trimming, very high speed routers are available which produce smooth-edge chip-free work.
Sharpness of the router cutters should always be maintained.

7. Safety and Proper Handling: Safety precautions should be considered with proper handling and machining in regards to dust extraction, dust collection and fire precautions.

Protective gloves and safety goggles should be used during machining in order to protect eyes and hands from sparks or sharp edges.

8. Care and Maintenance: Decorative Laminates should be cleaned with a particle free, clean, non-abrasive, damp cloth. Mild soap and water or mild liquid detergent can be used. **Do not use:** Solvents, abrasive cleaners, steel wool, powder soap, harsh chemicals, acids or alkaline cleaners. These products may cause scratching and/or surface discoloration.

9. **Ghosting**: Richwood Industries' Magnetic Dry-Erase Laminates and Richwood Industries' regular Dry-Erase Laminates are produced using a unique Dry-Erase formulation which makes our Dry-Erase Laminate the highest quality non-ghosting Dry-Erase surface on the market.

10. Material Warranty: Richwood Industries Inc. warrants that its products are reasonably free of defects, when properly used in accordance to the standards set forth by NEMA LD-3. This warranty is valid for a period of one year from purchase date and is limited to the value of the material purchased. This warranty is extended to the original buyer, and shall not be transferable to any person or entity. Richwood Industries does not assume liabilities arising from the sale, installation, furnishing or repair of finished goods. This warranty does not include damages resulting from accidents, abuse, lack of care, or improper use and installation.