

**Processing instructions**

Stand 18.02.2012

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**Processing instructions for tendermark surfaces on veneers  
and tendermark surfaces fitted on MDF carrier material, B1 collections**

**Storage:** Store veneers in dry location at temperatures above 0 degrees  
**Packaging:** Tendermark veneers are provided for the dimension of 2800mm x 1300mm. For better handling during fitting, the veneers come in oversize dimensions of 2820mm x 1320mm.

**a)packaging units for up to 10 sheets of veneer**

Veneers can be delivered, rolled onto a cardboard core and covered with protection foil, in a carton (1350x3050mm). Each carton can accommodate 10 sheets with a total weight of not more than 20kg per carton. Cartons can be stored vertically or horizontally. If stored horizontally, not more than three cartons may be stacked on each other.

**b)packaging units for up to 200 sheets of veneer**

Veneers are normally delivered stacked on pallets of the size of app. 1350mm x 3050mm. The stack of veneers on a pallet is protected by a board on top and another board at the bottom of the stack. The stack is secured against slip with tightening straps. The sides of the stack are protected with plastic film. 150 to 200 Veneers can be stacked on one pallet. The individual veneers are separated by layers of foamed plastic foil. A single veneer weights app. 2 kg. Pallets of veneers must not be stacked on top of each other.

**c)packaging for veneers fitted on 18mm MDF carrier material.**

veneers to be delivered fitted to carrier material 18mm MDF or the like will be individually packed in one carton each. The weight and the stability of the carrier material determine the conception of the carton. Project specific arrangements can be made. The carriers will be delivered on pallets of the size of app. 1350mm x 3050mm. A pallet can carry a maximum of 20 boards (18mm MDF). A single board weights app. 60kg. Pallets of boards must not be stacked on top of each other.

**Fitting/  
Pressing Surfaces:** Warm up veneers slowly to 16 to 20 °C and perform fitting/pressing onto carrier material at room temperature.

When pressing surfaces with a coarse structure in a pressing machine, make sure the surface is protected with foamed material mats of a thickness of 1cm and a density of 35kg/m<sup>3</sup>. Pressing will be executed at a lower range pressure of approximately 170bar.

The finer the surface, the thinner the foamed material mat may be. We advice the operator of the press to perform test so that from experience the right mat and the right pressure for the specific circumstances can be found.

Tendermark Veneers should as a rule be fitted with the hot-melt process

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**Fitting methods for non-absorptive sub-surfaces:**

## a) Hot Melt Method

Tendermark Veneers should always be fitted to carrier material in a "hot-melt" process.

## b) Adhesive Bonding Method

For fittings on small scale, also a spray adhesive (like DuroSpray DS45-P by Aartal Systemklebstoffe) may be used. In such cases fitting must be done using levelling material and without application of heat .

**Adhesive Bonding Products for absorptive sub-surfaces:**

## a) Brigatex K106

## b) Dorus FD033

## c) Collano FL330

Primer film on the carrier material should be as thin as possible. Circumstances can be very different in every individual case, therefore we recommend to the user to perform tests prior to the actual fittings.

Our own test showed good results with very thin (up to 0,5 mm) and with no primer film.

**Edge-Veneers:**

Tendermark-Edge-Veneers come with a smooth surface and are available in four different colours. The edges are 23mm wide.

Edge-veneers with other dimensions and with the texture of our surfaces are available on request

Otherwise, all leading edge-veneer producers can provide additional plastic edges that fit in colour to tendermark –veneers.

**Fitting  
of Edge-Veneers**

in case of mechanized edge fitting, the following instructions have to be observed:

- When using machines with a conveyor belt, position the tendermark-board with the coated side facing down.
- Turn off the scraper on the coated side
- Turn off the spraying device
- Turn off the buffing machine
- Forward Feed app. 13-18 m/min.
- Pressure less than 0,5 bar
- Make sure no adhesive is squeezed out
- Preferably use thin bandings
- Only rollers should be used on the coated side of the tendermark-board

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- Angular Joints** tendermark veneers can perfectly be processed for angular joints. To obtain the sharp edges that are required to provide clean joints, edges can be compressed with a folding tool.
- Postforming** the highly flexible veneers can be folded over edges in radiuses as small as slightly sanded right angles.
- Proper Disposal** the surface veneers of the collections "COLORS" , "CORROSION" and "CONCRETE" can be disposed in domestic waste.

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