

DECOLEATHER® RECYCLED LEATHER VENEER BY FORMICA GROUP



FABRICATION GUIDE

PRODUCT DESCRIPTION

dECOLeather® by Formica Group is a recycled leather veneer made from pulverized leather fibers extracted from car seats and leather tanneries. dECOLeather thickness is comparable to veneer and laminate at 0.8 mm or 1/32".

COLORS AND FINISH

dECOLeather is available in 4ft. by 8 ft. sheets in 12 standard and 6 made to order colors, 3 finishes, and 1 thickness (0.8mm). Actual size of sheet is slightly larger, approximately 49.5inch by 97.5inch. Custom colors are available with a 8 sheet minimum order and longer lead times. dECOLeather is a natural product, therefore slight color variance may occur from sheet to sheet.

RECOMMENDED APPLICATION

dECOLeather veneer can be used on light-duty horizontal or vertical applications, including but not limited to casework of restaurants, bars, retail kiosks, coffee shops, and hotel reception desk surfaces.

PACKAGING

dECOLeather can be packaged in a box or a pallet. Small quantities (5 or less) can be packaged in a double walled box rated at a minimum of 50lbs burst strength. Recommended box dimensions are 8"W x 8"H x 50"L. The sheets should be rolled with the face of the sheet on the inside. The maximum number of sheets per box is 5. Larger quantities of dECOLeather sheets (50+) should be packed on a pallet or crate. Use a maximum of 300 sheets of dECOLeather per pallet or crate to avoid damage to the texture.

HANDLING

dECOLeather recycled leather veneer sheets must be handled with care. Two people are needed when handling the sheets. Sheets must be handled by sliding when possible. When lifting the sheets, each person should hold opposite corners, tensing the sheets straight, creating a "U" shape.

FABRICATION AND ASSEMBLY

dECOLeather sheets rely on adhesive for installation. If dECOLeather sheets are rolled in a shipping carton they should be removed and laid flat. dECOLeather and the substrates should be acclimated in the same environment for 72 hours in a room between 55°F and 90°F prior to installation with stable humidity levels. Both the dECOLeather and substrate must be smooth, clean, dry and free of grease, dirt, dust, oil or any other foreign matter. The best way to apply dECOLeather to a substrate is in a cold press at 35 to 50psi using water based PVC adhesive. Vacuum forming capability would need to be determined by each fabricator shop. If press equipment is not available, high quality contact cement such as Formica® brand F-150 is recommended. Use 100% coverage on both the back of the dECOLeather and face of substrate. Allow adequate time for contact cement to "tac-up". Tac-up takes about 40 minutes for water based contacts and 10 minutes for solvent based contacts. Trapped gases can lead to bubbling or delamination of surface if not allowed to tac-up completely. Full pressing or nip rolling full panels is best. dECOLeather can be wrapped to tight 1/4 inch radius. A 2 inch under wrap is necessary to prevent abuse of edge exposure. In

most cases it is best to encapsulate the edges with metal, wood, plastic framing, or edge banding and corner protection.

PANEL BALANCING

As with any wood based substrate surfacing product there will need to be a balancing sheet on the back for certain applications where a panel is not bound (i.e. doors, signage, cabinets etc.). The best balance is achieved using the same product on both sides using the same adhesive and bonded at same time. For less critical applications Formica Group recommends a backer in grade 91 or C2.

LIMITATIONS

dECOLeather recycled leather veneer is designed for light duty horizontal and vertical applications for interior use only. Do not adhere directly to plaster or concrete. Do not use in areas exposed to temperatures exceeding 275°F, or areas of high humidity. dECOLeather can puncture or tear so avoid sharp object impact or scuff. Exposed edges can "fluff" when abraded, thus edges need to be encapsulated in metal, wood, plastic framing, or edge banding.

MACHINING

dECOLeather can be cut with a straight edge and razor knife. Routing edges can result in burrs and fuzzing so panels should be cut oversized and trimmed at the saw using triple chip blade configurations. CNC preferred settings are a speed of 200 in/min using a 4 flute 450 downward cutter. Recommended saw blades are an ATB alternate bevel cross cut with a scoring blade.

SUBSTRATE

dECOLeather veneer should be bonded to MDF, particleboard or good hardwood plywood substrates. All materials should be acclimated for 72 hours in the same environment. Substrates should be sanded smooth and cleaned of all debris.

PERFORMANCE CHARACTERISTICS

ANSI / NEMA STANDARDS PUBLICATION — LD3 -2005

PHYSICAL PROPERTIES		LD3 TEST
Surface Finish Gloss	3.2	5.0
Light Resistance	3.3	No Effect
Cleanability	3.4	21
STAIN RESISTANCE		
Reagents 1-10	3.4	No Effect
Reagents 11-15		No Effect
Boiling Water Resistance	3.5	No Effect
Radiant Heat Resistance -sec	3.10	66 sec
Dimensional Change	3.12	
Machine Direction - 10		0.04
Cross Direction - 15		0.41
ASTM E84 Flame 165 Smoke 200 Class C (Bonded to FRPB using PVA adhesive)		
ASTM D5053 Crocking 4.5 or Slight to Negligible		

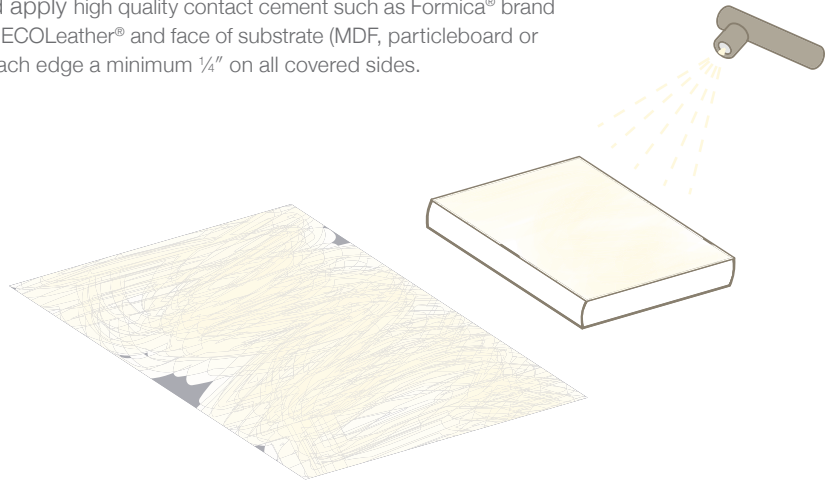
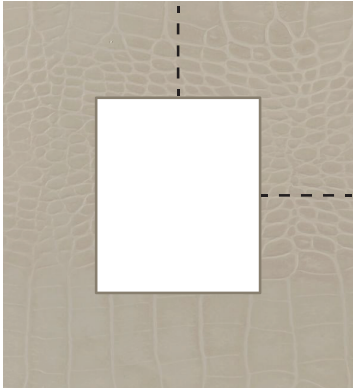
DECOLEATHER® RECYCLED LEATHER VENEER BY FORMICA GROUP



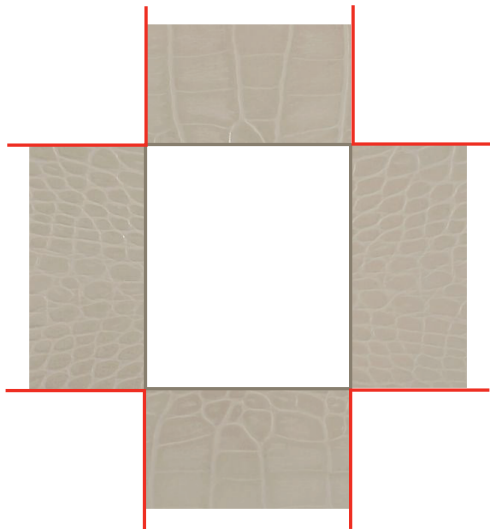
FABRICATION GUIDE

How to wrap panels with DECOLEATHER® RECYCLED LEATHER VENEER

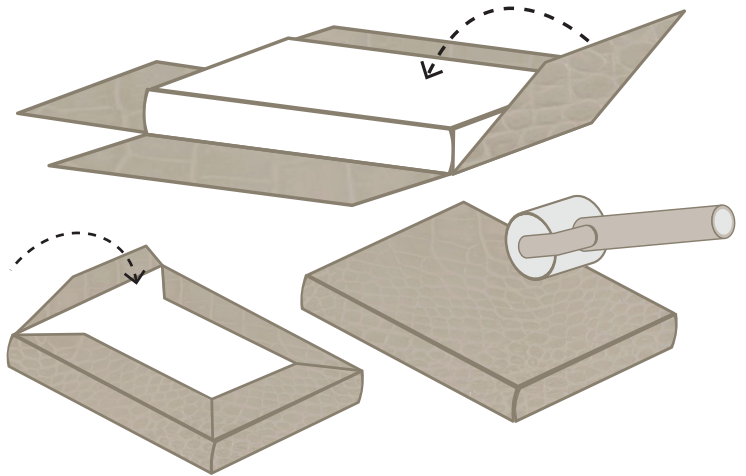
- 1 Lay up the panel in the center of the sheet and apply high quality contact cement such as Formica® brand F-150. Use 100% coverage on both the back of the dECOLeather® and face of substrate (MDF, particleboard or good hardwood plywood recommended). Radius each edge a minimum 1/4" on all covered sides.



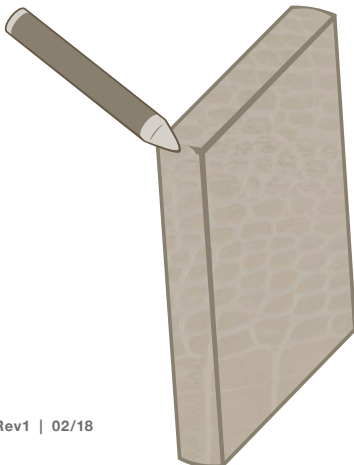
- 2 Laminate the front surface and cut-out the outside corners as shown



- 3 Wrap the leather around the panel, applying pressure with hand roller on all surfaces. Cut out excess material.



- 4 If there are gaps apply a fill stick crayon of matching color to fill the edge on the corner for a cleaner look



- 5 The end results gives you a clean-edge panel on all five sides. Radius each edge a minimum 1/4" on all covered sides.



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FABRICATION GUIDE

OUTSIDE CORNER PROTECTION WITHOUT CORNER GUARDS

dECOLeather® can puncture or tear so avoid sharp object impact or scuff. Exposed edges can “fluff” when abraded, thus edges need to be encapsulated in metal, wood, plastic framing, edge banding, or edge protectors.

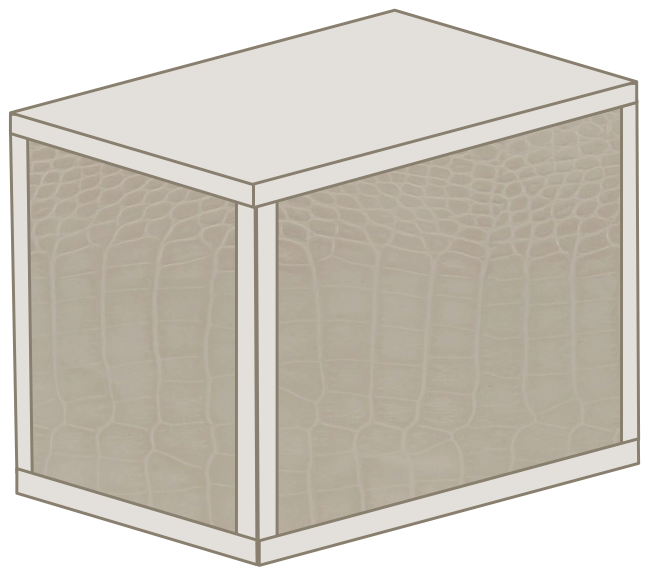
OPTION 1 — INSERT IN BETWEEN THE EDGES

Have a protruding piece of plastic/metal/wood of a matching color between the two panels or sides of leather. The piece can be protruding by $\frac{1}{16}$ " and be integrated in the design element of the panels



OPTION 2 — INVERTED “L” SHAPE BRACKET

Have a piece of metal trim inserted over the leather in between the panels of the countertop. The metal piece is an “L” shape with an inside corner placed between the two panels — the “wings” of the L protrude from the outside by $\frac{1}{16}$ " on each of the panels.



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HOW TO SPECIFY

Surface (and appropriate backing sheet) shall be Formica® Brand Laminate by Formica Group, Cincinnati, Ohio.

COLOR NUMBER
COLOR NAME
FINISH

USE AND CARE

We recommend the use of a damp, well-wrung terry cloth as the first and easiest option to maintain dECOLeather® recycled leather veneer. Should you need to use additional cleaning products, we recommend using only pH-neutral cleaners, such as Bona Kemi Wood Floor Cleaner, designed for polyurethane pre-finished materials.

TECHNICAL SERVICES

Full copies of a specific test report can be obtained by calling 1-800-FORMICA™ (option 2). All reports from independent research organizations and test labs apply only to the actual specimen or specimens studied and not to any similar materials or product nor to any production run of such material or products. Any information or suggestion concerning applications, specifications or compliance with codes or standards is provided solely for your convenient reference and without any representation as to accuracy or suitability. Formica Corporation disclaims any legal responsibility. The user must verify and test the suitability of any information or products for their own particular purpose or specific application.

LIMITED WARRANTY

Formica Corporation expressly warrants that, for a period of (1) one year from the date of first sale, Formica® Brand dECOLeather® products will be reasonably free of defects in materials and workmanship, and that when properly handled and fabricated, will conform to applicable manufacturing specifications. Colors are subject to sheet to sheet variations. This limited warranty only applies to Formica® Brand dECOLeather® which is stored, handled, fabricated and installed in the manner recommended by Formica Corporation. The warranty does not cover damage caused by improper installation, improper lamination, excessive humidity or use of a non-recommended adhesive. Mistreatment of any kind, including mechanical impact, scuffing caused by hard objects, water damage, plumbing leaks, fire damage, inadequate maintenance, or improper usage will void this Limited Warranty. Mistreatment or improper usage includes damage from moving heavy objects across the surface without adequate protection, rotating vacuum cleaners or brushes, and dropping heavy or sharp objects onto the recycled leather. Further excluded are problems due to extreme temperatures, heat or cold, sunlight, stains, rips, tears, gouges or indentations.

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