

FORMICA ENVISION™



TECHNICAL DATA

GENERAL PURPOSE GRADE D4, D5, COMPACT GRADE S6, S7

PRODUCT DESCRIPTION

Melamine-impregnated decorative surface papers are combined with phenolic-treated kraft paper and consolidated in a press at high pressures.

COLORS AND FINISH

Formica Envision™ is a unique surface art on our high performance laminate using customers design, photography, logo illustration or painting. Sheets are available in Matte-58 finish. Sheets are also available in Gloss-90 finish in a 4'x8' sheet only

RECOMMENDED APPLICATION

GRADE D5/ HGS

Formica® Brand Laminate – Grade D5/HGS is intended for application to interior horizontal or vertical surfaces where design, appearance, quality, durability, resistance to stain, and resistance to heat from ordinary sources are important considerations.

GRADE D4/ VGS

Formica® Brand Laminate – Grade D4/VGS is intended for application to interior vertical surfaces where design, appearance, quality, durability, resistance to stain, and resistance to heat from ordinary sources are important considerations.

GRADE S6, S7

Formica® Brand Compact-Grade S6, S7 are intended for partitions, wall panels, casework, lockers and areas where high impact strength and moisture resistance are needed.

FABRICATION AND ASSEMBLY GRADES D4, D5

LIMITATIONS

Formica Envision™ custom laminate is non forming and is designed for interior use only. Do not adhere directly to plaster, drywall, (gypsum board), or concrete.

Do not use in areas exposed to temperatures exceeding 275°F (135°C) or for exterior applications. When using Grade D4, finished panel widths should not exceed 24" (610mm) maximum, unless the adhesive system is a rigid set adhesive like PVA (wood glue). We do not recommend contact adhesive for Grade D4 panels wider than 24" (610mm).

MACHINING LOW SHEEN LAMINATE SHEETS

Formica Brand Laminate with low sheen surfaces are subject to marring. Fabricating with peel coat on surface (if applicable) is recommended. Router base should be clean and free of burrs and debris. Table saws should be clean, flat, and free of burrs.

STORAGE

Formica Brand Laminate should be stored horizontally, with a caul board or other protective sheet placed on top to protect the material from possible damage. The material should be protected from moisture, and should never be stored in contact with the floor or an outside wall. Optimum conditions for storage are approximately 75°F (24°C), and 45% to 55% relative humidity.

PRECONDITIONING

Prior to fabrication, allow laminate sheet and substrate to acclimate for at least 48 hours at the same ambient conditions. Optimum

conditions are approximately 75°F (24°C), and relative humidity of 45% to 55%. Provisions should be made for the circulation of air around the materials.

SUBSTRATES

Formica® Brand Laminate sheet should be bonded to an appropriate substrate, such as #45 density particleboard (ANSI A208.1 - 1999), or Medium Density Fiberboard (MDF). Due to the potential for stress cracking, shrink-back, and surface telegraphing problems, the use of plywood is strongly discouraged and not recommended. The substrate should be sanded smooth, and should be clean, free of oil or grease, and uniform in thickness.

Formica® Brand Laminate sheet (grade D5/HGS) can be bonded to metal substrates using contact adhesive (see recommendations below, under Adhesives). Refer to Formica® Laminate Brief - Veneered to Metal Substrates for General Information, Materials, Conditions and Methods. Formica Corporation does not warranty this particular application.

ADHESIVES

Contact, semi-rigid (PVAc), or rigid (urea, resorcinol) adhesives may be used. Follow the adhesive manufacturer's recommendations. Certain combinations of finish, substrate, and adhesive can cause telegraphing.

When bonding Formica® Brand Laminate sheet (grade D5/ HGS) to metal substrates using contact adhesive, use Formica brand flammable solvent-based #155 or non-flammable solvent-based #120M contact adhesives. Do not use water-based or SBR types of contact adhesive when bonding laminate sheets to metal substrates.

ASSEMBLY

Material, equipment, and workmanship should conform to the Formica Corporation recommended standard practices, conditions, procedures, and recommendations as specified by ANSI/ NEMA LD3-2005, Architectural Woodwork Quality Standards and ANSI 161.2-1998 Standards.

Formica® Brand Laminate sheets (grade 10, 12, and 20) can be sawed, drilled, routed, and fabricated using standard carbide tipped cutting tools.

Holes for screws or bolts should be drilled oversized.

Panel assemblies should be laminated with the appropriate backing sheet to minimize warpage. Formica® brand backing sheets (grade 91/BLK or C2/BKH) are recommended for less critical applications. Optimum balancing is obtained by bonding the same surface laminate on both sides of the assembly with the same adhesive. Always align sanding marks in the same direction.

All inside corners of cutouts must be radiused as large as possible, 1/8" (3.18mm) minimum, to avoid stress cracking. The edges and corners should be routed, sanded, or filed smooth and free of chips or nicks. Panels fabricated using metal substrates, which are more dimensionally stable than wood-based materials, should be installed in a framing system, which captures the perimeter of the panel yet allows for the normal dimensional movement of the laminate. This is to protect the panel edge and prevent edge lifting or separation from the substrate, which can occur under dry conditions.

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FABRICATION AND ASSEMBLY GRADES S6, S7

All the general recommendations for the fabrication of thin laminates also apply to Compact™ laminate and they should be treated in the same manner as double sided composite boards. The following additional recommendations should also be observed.

GENERAL

The increased thickness of Compact™ laminates imposes greater demands on cutting tools and causes greater wear. Slower feed-speeds than those generally used for cutting HPL-faced composite boards are required. The degree of feed speed reduction will depend on the thickness of the laminate and the quality of finish required. Tool manufacturers should be consulted as to the type and quality of tungsten carbide tipping to provide the best performance. Where long production runs are contemplated and where a high quality finish is required, it is worth considering PCD (Polycrystalline Diamond) tooling. In all machine processes, localized heating caused by poorly maintained saws and cutters must be avoided. For optimum flatness the longest dimension of the panel should always be cut to coincide with the longest dimension of the Compact™ sheet.

SAWING

Saw blades normally used for cutting double sided composites are generally suitable for cutting Compact™ grades. Saws of less than 2 mm in thickness are not recommended. Breakout on the underside and poor cutting of Compact™ sheets can be reduced by various methods.

1. By the use of a pre-scoring blade on the underside.
2. Using a base-board of plywood or hardboard beneath the Compact™ sheet.
3. Altering the exit angle of the saw blade by adjusting the height setting.
4. Triple chip designs have shown to provide good cut quality. Hook - +15°.
5. Rate of advance of the cutter ("chip load") should be .001"-.002".

NOTE: The higher the saw blade the better the top cut and the worse the bottom cut and vice versa. The feed speed essentially governs the quality of the saw cut when sawing Compact™ laminates having two decorative faces

PROFILE CUTTING AND EDGE FINISHING

It is not necessary to apply edging strips or edge sealants to Compact™ panels and for many applications clean sawn edges are sufficient.

A hand router may be used to achieve a superior finish or a profiled edge. Rough cut panels to approximately 1/16" before finish routing. Two-flute carbide straight cutting bits work well for trimming double-sided panels. Although it is not possible to achieve complete freedom from cutter marks, they can be minimized by feeding the work at a constant controlled speed. Care should be taken to avoid pausing during cutting and profiling, as burn marks may result which are difficult to remove.

A CNC router cutting sequence is determined by the type of machining required. A good starting point for machining is:

- Spindle Speed — 16,000-18,000 rpms
- Feed Rate — 200-900 in/min

Where it is desirable for edges to be completely free from cutter marks, a further sanding and scraping operation is necessary. Edges may be further enhanced by buffing with steel wool and applying silicone-free oil. A use of an orbital sander in multi-step finishing sequence like Solid Surface can be achieved

MATTE FINISH	SATIN FINISH	SEMI-GLOSS FINISH
100μ	100μ	100μ
80μ	80μ	80μ
60μ	60μ	60
		1000 Abralon
1000 Abralon	1000 Abralon	2000 Abralon

Chamfering or profiling the edges of Compact™ panels will reduce the risk of edge impact damage.

DRILLING

The most suitable drills for use on Compact™ laminates are those designed for plastic sheet materials. These drills have a point angle of 60°- 80° instead of the normal 120° for drilling metal.

To avoid breakout on the reverse side, the feed speed of the drilling head and the pressure applied should be gradually re-duced approaching the point of breakthrough. Working on a firm underlay, such as plywood or chipboard, will also reduce the risk of breakout.

For blind boring into the face, the depth of the hole should be such that at least 1/16 mm of material remains between the bot-tom of the hole and the other side of the sheet. TCT lip and spur drills will produce clean flat bottomed blind holes, with less risk of point penetration on the reverse side. This will allow maximum depth of material to be used for fixings. Compact™ sheets less than 3/8" thick are not considered suitable for blind fixing. When drilling parallel to the surface (edge drilling) at least 1/8" of mate-rial must remain on either side of the hole. Threaded holes can be produced using engineers screw cutting taps. Self-tapping screws or threaded brass inserts may also be used.

INSTALLATION

In the planning of any installation, it is essential to take into account the dimensional movement that can occur with Compact™ laminates and allowances must be made in the design, fabrication and installation processes. Movement in the length direction of the sheet is about half of that in the width direction.

Typical dimensional movement values resulting from extreme change in relative humidity are as follows:

Transverse direction of the sheet: 0.3in per 10ft

Longitudinal direction of the sheet: 0.1in per 10ft

Compact™ panels used for wall cladding may be fixed by screwing directly through the face, or by hanging on a rigid supporting timber or metal framework with 'Z' clips. Thinner grades, 1/4" or

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less, may be bonded to a wood-based framework with heavy duty building adhesives. Scuffing the back of the Compact™ panel with 220 grit sand paper is advised. The chosen method of attachment will depend on the installation, board thickness and visual design criteria. In all applications the panels must be fixed to a rigid, secure system of horizontal supports at not more than 2' centers, with vertical support members at the joints appropriate to the detailing. Fixing clips should also be at maximum 2' centers. It is recommended that panels of less than full board width are used, both for ease of handling and reducing dimensional movement.

Compact™ panels should not be fixed to freshly constructed block work (CMU) or brickwork until adequate drying has taken place, nor should they be fixed to damp external walls without the protection of a damp-proof membrane.

NOTE: When cladding outside walls Formica recommends metal furring strips or channel. Do not use particleboard or MDF as lacks structural integrity.

Adequate ventilation/air circulation must be provided behind the panels either by notching the support members or packing them off the wall. Typical minimum ventilation access at the top and bottom of the panels should be 3in²/10ft² of panel area.

DIRECT FACEFIXING

Thru fixing holes should be at least 1.5 times the outside diameter of the screw being used and should be a minimum of 3/4" from the edge of the panel. Soft plastic bushes should be used to ensure correct centering of the screw in the hole, thus still allowing for movement. Countersunk screws should not be used.

ATTACHING FIXING DEVICES

'Z' clips and other secret fixing devices may be attached to the back of panels with 'Taptite' self-tapping screws or threaded brass expansion inserts. Screws and bolts with slow threads provide better resistance to working loose than those with fast threads. In all cases a blind pilot hole of the correct size must first be bored in the back of the panel. The depth of the hole should be at least 1/32" greater than the penetrating depth of the screw, and should leave at least 1/4" of material between the bottom of the hole and the face of the panel.

Rigid items, such as 'Z' clips and fixing angles, fixed to Compact™ panels, should have oversize holes to accommodate differential movement. A slip foil between the two components is also recommended. Expansion fasteners should not be used in edge-drilled holes (i.e. parallel to the surface).

EDGE TO EDGE JOINTING

Edge-to-edge joints may be either tongued and grooved, or simply grooved and a loose spline inserted. Whichever method is chosen, the wall thickness of the groove should be greater than the width of the groove. The depth of the groove should be no greater than the thickness of the board and the length of the tongue/spline should be such as to accommodate the maximum anticipated movement. Compact™ laminates less than 3/8" thick are not suitable for edge grooving.

EDGE RETAINING PROFILES

Edge retaining profiles of steel or aluminum should be used in situations where some movement of adjoining panels is anticipated, such as in vehicle construction.

ATTACHING LAMINATE TO COMPACT™

Solvent-based contact adhesive can be used to bond laminate sheets to Compact™ sheets. Do not use water-based contacts for this application. Scuff up surface of Compact™ with 220 grit sandpaper.

THERMOFORMING

Compact™ S2 at 1/8" thickness can be thermoformed.

Product is heated to 325°F using a convection or radiant oven. Depending on oven type, trials needs to be preformed to determine time to heat the sheet thru its core. Temperatures in excess of 375°F may cause blistering. After heating, clamp the mold and let cool to room temperature. Sheets will form to a 6" mold radius but there will be some spring back to a larger radius after cooling depending on sheet size and grain direction.

APPLICATION

In common with all high-pressure decorative laminates Compact™ laminates undergo a certain amount of dimensional movement when subjected to changes in humidity. In order to minimize the risk of bow occurring as a result of this movement, the following points should be observed:

1.) In new buildings, or where excessive moisture conditions are present, it is recommended that, prior to fixing Compact™ laminates, a process of pre-conditioning be carried out to ensure the sheets reach an equilibrium within the site conditions.

This can usually be achieved by laying the Compact™ sheets on a pallet, neatly and flat, face to face and back to back, using care-fully aligned spacer sticks (1" x 1") between the sheets at 12' centers across the full area of the wallboards, in the area where they are to be used, (or in another area having identical conditions), for 7 to 10 days prior to installation.

2.) Panels should be cut with the long edge parallel to the length of the sheet. Dimensional movement across the width of the sheet is twice as great as it is along the length, so cutting panels with the long dimension running across the width of the sheet will greatly increase the risk of bowing.

3.) As far as possible, the ambient conditions should be the same on each side of the panel, as it is important that both sides gain or lose moisture at roughly the same rate. Where panels are mounted on a wall or enclose a vanity unit or Integrated Plumbing System (IPS), adequate ventilation must be provided to ensure that temperature and humidity conditions at the backs of the panels are essentially the same as those at the front.

4.) Fixing centers should be sufficiently close to prevent excessive freedom of movement. Shower cubicle doors greater than 60" high should have three hinges.



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LIMITATIONS

Compact™ sheets are suitable for interior horizontal or vertical surfaces. Compact™ sheets, 1/4" (6.4mm) or less, are not recommended for adherence directly to plaster, gypsum board, or concrete. They can be attached to particleboard, MDF or hardwood faced particleboard. Compact™ greater than 1/4" should be attached using mechanical fixing systems (see above). Do not use in areas exposed to temperatures exceeding 275°F

(135°C). Compact™ sheets should not be used in wet wall applications where one side is exposed to a higher humidity than the other. Areas in bathrooms such as toilet, urinal and shower room partitions are fine since both sides are exposed to equal moisture. They should not be used in shower stalls. Compact™ sheets are not recommended for exterior applications.

TECHNICAL DATA GRADES D4, D5

Performance compliance of Formica® Brand Laminate General purpose grade D5 and Post-forming grade D4.

ANSI/NEMA STANDARDS PUBLICATION – LD3-2005

PHYSICAL PROPERTIES	LD3 TEST	D5/HGS
Appearance	3.1	No ABC Defects
Light Resistance	3.3	Slight
Cleanability	3.4	20 (max.)
Stain Resistance Regents 1-10 Regents 11-15	3.4	No Effect Moderate
Boiling Water Resistance	3.5	No Effect
High Temperature Resistance	3.6	Slight
Ball Impact Resistance in. mm	3.8	50(min.) 1270 (min.)
Radiant Heat Resistance	3.10	125 (min.)
Dimensional Change Machine Direction - % Cross Direction - %	3.11	.05 (max.) .09 (max.)
Wear Resistance	3.13	400 (min.)

ANSI/NEMA STANDARDS PUBLICATION – LD3-2005

PHYSICAL PROPERTIES	LD3 TEST	D4/VGS
Appearance	3.1	No ABC Defects
Light Resistance	3.3	Slight
Cleanability	3.4	20 (max.)
Stain Resistance Regents 1-10 Regents 11-15	3.4	No Effect Moderate
Boiling Water Resistance	3.5	No Effect
High Temperature Resistance	3.6	Slight
Ball Impact Resistance in. mm	3.8	50(min.) 1270 (min.)
Radiant Heat Resistance	3.10	125 (min.)
Dimensional Change Machine Direction - % Cross Direction - %	3.11	.05 (max.) .09 (max.)
Wear Resistance	3.13	400 (min.)

TECHNICAL DATA GRADES S6, S7

Performance compliance of Formica® Compact™:

ANSI/NEMA STANDARDS PUBLICATION - LD3-2005

PHYSICAL PROPERTIES	LD3 TEST	COMPACT™
Appearance	3.1	No ABC Defects
Light Resistance	3.3	Slight Effect
Cleanability	3.4	20 (maximum)
Stain Resistance Reagents 1 – 10 Reagents 11 – 15	3.4	No Effect Moderate Effect
Boiling Water Resistance	3.5	Slight Effect
High Temperature Resistance	3.6	Slight Effect
Ball Impact Resistance (in.) – in – mm	3.8	75 (minimum) 1905 (minimum)
Radiant Heat Resistance (sec.)	3.10	250 (minimum)
Dimensional Change Machine Direction – % Cross Direction – %	3.11	0.30 (maximum) 0.70 (maximum)
Wear Resistance – cycles	3.13	400 (minimum)

ASTM MECHANICAL PERFORMANCE PROPERTIES

MECHANICAL PROPERTIES*	ASTM TEST	COMPACT™
Flexural Strength Ultimate Modulus	D790-84a	2.12 x 10 ⁴ psi 1.91 x 10 ⁶ psi
Tensile Strength Ultimate Modulus	D638-84	1.97 x 10 ⁴ psi 2.07 x 10 ⁶ psi
Bond Strength	D952-8	1.460 x 10 ⁴ psi
Bearing Strength	D953-84a	1.650 x 10 ⁴ psi

STANDARD COMPACT™ FIRE TEST DATA - ASTM E-84

GRADE/FORMICA® BRAND PRODUCTS (FACED MATERIAL)	ADHESIVES	FLAME	SMOKE	CLASS
S6/Compact (1/2" Thick Phenolic)	Unbonded	30	110	B
S7/Compact (3/4" Thick Phenolic)	Unbonded	30	110	B

FIRE RATED COMPACT™ FIRE TEST DATA - ASTM E-84

UL CLASSIFIED BUILDING PRODUCTS - FILE R22111

TESTED IN ACCORDANCE WITH UL723/ASTM E-84

THICKNESS	FLAME	SMOKE	CLASS
1/4" to 1" (6.35 mm to 25.4 mm)	10	165	A

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FIRE TEST DATA – ASTM E- 84

Formica Corporation conducts and maintains an active fire testing program to provide code regulators, architects, and designers with current information on a variety of panel assemblies. Fire test data using Formica® Brand Laminate sheets (grades D4 VGS, D5 HGS, S6, S7 are available upon request). Contact Formica® Corporation Technical Services at 1-800-FORMICA™ (option 3) or 513-786- 3578 for assistance.

CODES AND SPECIFICATIONS

FORMICA® BRAND LAMINATE

(GRADE D5 / HGS / HORIZONTAL APPLICATION)

NSF Standard 35

Greenguard Certification

FORMICA® BRAND LAMINATE

(GRADE D4 / VGP / VERTICAL APPLICATION)

NSF Standard 35

Greenguard Certification

FORMICA® BRAND COMPACT

Greenguard Certification

SIZES

D4, D5

Sheet widths: 36" (914mm), 48" (1219mm), 60" (1524mm)

Sheet lengths: 96" (2438mm), 120" (3048mm), 144" (3658mm)

S6, S7

Sheet widths: 48" (1219mm)

Sheet lengths: 96" (2438mm),

THICKNESS

	TYPICAL THICKNESS	NEMA THICKNESS RANGE
Grade D5/HGs	.041" (1.0mm)	.037"–0.45" (1.0mm–1.1mm)
Grade D4/HGP	.030" (0.9mm)	.026"–.034" (0.7mm–0.9mm)
Grade S6	.500" (7.7mm)	NA
Grade S7	.750" (19mm)	NA

WEIGHT PER SQUARE FOOT

Grade D5/HGS: 0.324 pounds

Grade D4/HGP: 0.180 pounds

Grade S6/CGS: 4.0 pounds

Grade S7/CGS: 6.0 pounds

USE AND CARE

Refer to Formica® Brand Laminate Use and Care Guide – Formica® Brand Laminate sheet may be cleaned with a damp cloth and mild detergent.

If in doubt about the suitability of a particular cleaner or detergent, check with its manufacturer. Use of abrasive cleaners, powders, scouring pads, steel wool, sandpaper, etc., can damage the finish of the decorative surface and are not recommended.

Acid or alkaline-based cleaners, compounds, etc., will mar, etch, corrode, and permanently discolor the decorative surface of laminate. Never use these materials on laminate, nor allow bottles, rags, etc., contaminated with them to contact the surface. Accidental spills or splatters from these harsh materials should be wiped off immediately with a damp cloth.

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LIMITED WARRANTY

Formica Corporation expressly warrants that, for a period of one (1) year from the date of first sale, these products will be reasonably free of defects in materials and workmanship, and that when properly handled and fabricated, will conform, within accepted tolerance, to applicable manufacturing specifications. Colors subject to dye lot variations. This limited warranty only applies to Formica® Brand Laminate which is stored, handled, fabricated and installed in the manner recommended by Formica Corporation. Due to the variety of uses and applications to which Formica® Brand Laminate may be put, FORMICA CORPORATION CAN MAKE NO WARRANTY THAT THIS PRODUCT IS SUITABLE FOR ANY PARTICULAR PURPOSE AND CAN MAKE NO OTHER WARRANTIES, EXPRESS OR IMPLIED, OTHER THAN THOSE SET FORTH ABOVE.

DISCLAIMER OF WARRANTIES

THE WARRANTIES SET FORTH HEREIN OR IN FORMICA CORPORATION'S WARRANTY DOCUMENTS WITH RESPECT TO A PRODUCT ARE THE ONLY WARRANTIES MADE BY FORMICA CORPORATION IN CONNECTION WITH THESE PRODUCTS, AND ARE EXPRESSLY IN LIEU OF ANY OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING WITHOUT LIMITATION, ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. PRODUCTS SOLD BY FORMICA CORPORATION ARE SOLD ONLY TO THE SPECIFICATIONS SPECIFICALLY SET FORTH BY FORMICA CORPORATION IN WRITING. FORMICA CORPORATION'S SOLE OBLIGATION FOR A REMEDY TO BUYER SHALL BE REPAIR OR REPLACEMENT OF NON-CONFORMING PRODUCTS, OR AT THE OPTION OF FORMICA CORPORATION, RETURN OF THE PRODUCT AND REFUND OF THE PURCHASE PRICE. BUYER ASSUMES ALL RISK WHATSOEVER AS TO THE RESULT OF THE USE OF THE PRODUCTS PURCHASED, WHETHER USED SINGLY OR IN COMBINATION WITH OTHER SUBSTANCES.

LIMITATION OF LIABILITY

No claim by buyer of any kind, including claims for indemnification, whether as to quality or amount of products delivered or for non-delivery of products, shall be greater in amount than the purchase price of the products in respect of which damages are claimed. IN NO EVENT SHALL FORMICA CORPORATION BE LIABLE TO BUYER FOR ANY SPECIAL, INDIRECT, INCIDENTAL, RELIANCE, EXEMPLARY, OR CONSEQUENTIAL DAMAGES OR COVER, OR LOSS OF PROFIT, REVENUE OR USE, IN CONNECTION WITH, ARISING OUT OF, OR AS A RESULT OF, THE SALE, DELIVERY, SERVICING, USE OR LOSS OF USE OF THE PRODUCTS SOLD HEREUNDER, OR FOR ANY LIABILITY OF BUYER TO ANY THIRD PARTY WITH RESPECT THERETO. BUYER SHALL INSPECT FOR NONCONFORMITY PROMPTLY UPON RECEIPT. Failure by buyer to give Formica Corporation written notice of claim within 30 days from date of delivery or, in the case of non-delivery from the date fixed for delivery, shall constitute a waiver by buyer of all claims in respect of such products.

This limited warranty gives purchaser of Formica® Brand Laminate specific legal rights. Other rights may be available and vary from state to state.

Any information or suggestion concerning application, specifications or compliances with codes and 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 of specific application.

MANUFACTURER

Formica® Brand Laminate sheets are manufactured by Formica Corporation.

TECHNICAL SERVICES

Technical assistance may be obtained through your local Formica® Brand Products Distributor or from Formica Corporation trained representatives in sales offices throughout the country. To assist these representatives, Formica Corporation maintains a sales and technical services staff in Cincinnati, Ohio. For technical assistance, contact your distributor or sales representative; write the company directly at Formica Corporation Technical Services Department, 10155 Reading Road, Cincinnati, OH, 45241; call (513) 786-3578 or 1-800-FORMICA™; or fax (513) 786-3195. In Canada, call 1-800-363-1405. In Mexico, call (525) 530-3135.

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