ALT HPL Bending Guide

Welcome to a new era in decorative panels.

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Step-by-Step Process for gluing HPL on a curved substrate

1. Check the Minimum Radius

- For **0.7 mm non postformable HPL**, we typically specify **a minimum cold-bend radius of 150mm for DesignForm and SolidVelvet, and 200mm for MasterOak**
- Do not attempt tighter curves — the laminate will likely crack or delaminate.

2. Prepare the Substrate

- Use a **flexible substrate** (e.g., thin MDF, plywood, or bending-grade board) that matches the curve.
- Ensure the surface is clean, dust-free, and smooth.
- If the curve is tight, consider **kerf-cutting the substrate** (shallow saw cuts on the back side) to help it flex.

3. Apply Adhesive

- Spray **contact adhesive** evenly on both the **substrate** and the **back of the HPL**.
- Allow the adhesive to become **tacky (not wet)** before applying.
- Keep the coat thin but uniform — too much glue can cause bubbles.

4. Align and Fix the Laminate

- Start by fixing the **center of the HPL** to the substrate curve.
- Slowly press outward toward the edges, working the laminate around the curve.
- Use a **J-roller or a curved block** to apply even pressure — always roll **from the center outwards** to avoid trapping air.

5. Clamp and Cure

- Use form blocks or clamping jigs shaped to your curve to hold the laminate securely while the adhesive cures.
- Maintain pressure until the glue fully sets (check adhesive instructions, usually 1–2 hours).

Tips & Precautions

- Work at **room temperature** (cold environments make HPL more brittle).
- Always bend **with the decorative face outward** — the back face compresses more easily than the decorative side stretches.
- For very tight curves, test on a scrap piece first.