

Nature, Human and Space

LG Hausys

3D Press Manual

deco foil

1. This manual is to serve as an guide line to LG deco foil (for 3D press) users and provides examples of various machines to LG deco foils.

2. The press settings varies from machine/location/adhesive and this manual provides examples of settings by these variables and also has comparison examples by competitors.

3. Main Guide Line

- **The main setting point are the Press Temp and Time , especially the pre-heat time and Press time is an important factor.**
- **When pressing with a membrane, the surface of the sheet should maintain 70~75 °C and if the temperature is low, the sheet will break and the corners of the foil will turn white.**
- **Plenty of Pre-Heat is required to soften the sheet so that the sheet and the MDF will bond.**
- **On flat areas of the MDF, spray thin glue however spray enough glue to the edges and deep NC areas of the MDF. If the glue is not sprayed properly throughout these areas a delamination may occur.**
- **Some bulb Type Vacuum press machines do not have switch boards to control the heat therefore take caution when using these machines.**



- **Press Machine : Wemhöner**
- **Foil : LG 3D deco foil 0.4mm**

Mode	Membrane	Without Membrane
T0	0.1 Sec	-
T1	25 Sec	50 Sec
T2	5 Sec	5 Sec
T3	30 Sec	40 Sec
T4	15 Sec	-
T8	7 Sec	-
Pressing pressure	4 bar	-
cooling pressure	2 bar	2 bar
Heating plate Temp	125 °C	110 °C
Bottom Temp	50 °C	50 °C
Membrane	105 °C	-



- **Press Machine : Wemhöner**
- **Foil : LG 3D High Glossy deco foil 0.5mm**

Mode	Membrane	Without Membrane
T0	4 Sec	-
T1	25 Sec	120 Sec
T2	5 Sec	5 Sec
T3	30 Sec	40 Sec
T4	15 Sec	-
T8	-	-
Pressing pressure	5 bar	-
cooling pressure	2 bar	2 bar
Heating plate Temp	115 °C	130 °C
Bottom Temp	50 °C	50 °C
Membrane	95 °C	-



Glue Spray condition

Index	Glue Spray (Recommend)
Surface	50 ~ 60g/m²
Edge	< 150g/m²
N/C	< 150g/m²

