



# CURVED PANEL TECHNICAL BULLETIN

## Option 1:

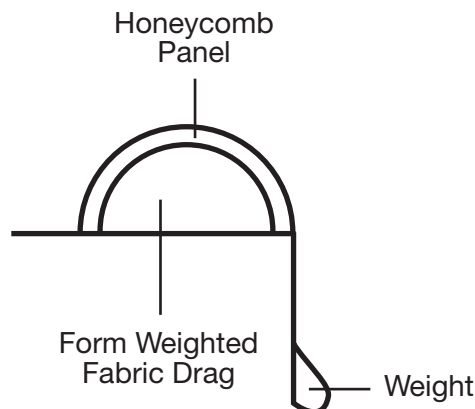
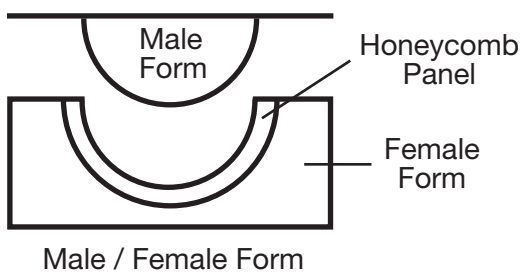
### Supplies and Tooling:

- Tricel Honeycomb
- Skin Material
- Adhesive
- Form or Mandrel
- Clamping Device (Vacuum bag, male/female forms, weighted fabric drag)

### Lamination Procedure:

1. Place one skin face down on form.
2. Apply adhesive to both sides of the honeycomb (Applying adhesive to honeycomb, you will reduce adhesive requirements).
3. Place honeycomb on first skin (Already on form).
4. Place second skin face up on honeycomb.
5. Apply pressure to lamination using vacuum bag, male/female form, or weighted fabric drag.
6. Depending on the cure time for your selected adhesive, you can expect cycle times to range from 1 hour to 6 hours
7. Check with your adhesive supplier for the specific cure time of your adhesive.

The simplest and lowest cost of clamping device is a weighted fabric drag. The weight required depends on the stiffness of your skin material.





Furniture & Cabinetry

# CURVED PANEL TECHNICAL BULLETIN

## Option 2:

### Supplies and Tooling:

- Tripanel (Pre-Laminated Panel)
- Skin Material
- Adhesive
- Form or Mandrel
- Clamping Device (Vacuum bag, male/female forms, weighted fabric drag)

### Lamination Procedure:

1. Cut saw kerfs (Cut through skin and honeycomb to opposite skin) close enough together to permit bending into the desired radius.
2. Trowel thickened epoxy into saw kerfs.
3. Apply pressure to lamination (Same as Option 1).



Furniture & Cabinetry

# CURVED PANEL TECHNICAL BULLETIN

## Option 3:

### Supplies and Tooling:

- Tripanel (Pre-Laminated Panel)
- Skin Material
- Adhesive
- Form or Mandrel
- Clamping Device (Vacuum bag, male/female forms, weighted fabric drag)

### Lamination Procedure:

1. Cut saw kerfs close enough together to permit bending into desired radius.
2. Apply adhesive to skin on kerfed side.
3. Place panel on form.
4. Place desired skin on top of form.
5. Apply pressure to lamination (Same as Option 1)