

# SIBU TRENDS

OVERVIEW 1.4

GB

**SIBU**  
DESIGN



# SIBU TRENDS

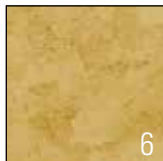


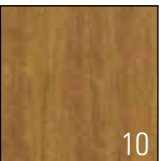


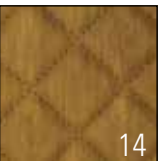
OVERVIEW 1.4

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# LEATHER-LINE

						
6	8	10	10	12	14	14
LL ANTIGUA Gold	LL LACE Black/Platin	LL OXY Steel	LL OXY Terra	LL QUADRO Luxury Bronze	LL ROMBO 40 Antigua Gold	LL ROMBO 40 Oxy Terra

# SIBUGLAS

					
16	18	18	20	20	22
SG FLEUR Black/Gold AR+	SG LUXURY Gold AR+	SG LUXURY Bronze AR+	SG LACE White/Vintage Brown AR+	SG LACE Black/Platin AR+	SG ANTIGUA Gold AR+

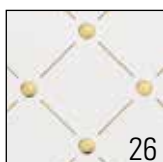
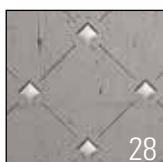
# STRUCTURE-LINE



24

SL LINEA 104x62  
Old Platin

# PUNCH-LINE 3D

	
26	28
PL 3D H-10-30 Pearl White PF/Gold	PL 3D Q-10-30 Old Platin/Silver

# DECO-LINE

	
30	30
DM LUXURY Bronze	DM LUXURY Gold

# LL ANTIGUA

**LL ANTIGUA Gold**  
2600x1000x1,9 / **NA** 17828 / **SA** 17852



## PRODUCT CHARACTERISTICS

	NA	SA
<b>Base material</b>	HIPS	
<b>Surface material</b>	PU-leather/Print	
<b>Material thickness</b>	1,9 mm	2,03 mm
<b>Temperature stability</b>	up to 60 °C	up to 60 °C
<b>Wet room suitability</b>	●●●○	
<b>Rolled packable</b>	✓	✓

## EXTRA EQUIPMENT

	NA	SA
<b>Format options (from 20 m²)</b>		
<b>max. length</b>	3000 mm	3000 mm
<b>max. width</b>	1250 mm	1220 mm
<b>Further thicknesses</b>	—	
<b>Cuttings</b>	✓	✓
<b>Magnetic</b>	from 3 sheets	—
<b>PUR/PVA pre-treatment</b>	✓	—

## PROCESSING

	NA	SA
<b>Cutting, punching</b>	✓	✓
<b>Drilling</b>	✓	✓
<b>Sawing</b>	✓	—
<b>Laser cutting</b>	✓	✓
<b>Hot bending</b>	✓	—
<b>PUR/PVA compressible</b>	✓	—
<b>min. bending radius</b>	150 mm	150 mm

## ACCESSORIES

<b>SIBUKLE</b>	Spatula A1
<b>Profile groups</b>	1 / 2 / 3 / 5
<b>Profile recommendation</b>	2 / 5

## SPECIAL COLORS

—
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2600



1000



# LL LACE

## LL LACE Black/Platin

2600x1000x1,5 / **NA** 17823 / **SA** 17844



## PRODUCT CHARACTERISTICS

	NA	SA
<b>Base material</b>	HIPS	
<b>Surface material</b>	PET/Print	
<b>Material thickness</b>	1,5 mm	1,63 mm
<b>Temperature stability</b>	up to 60 °C	up to 60 °C
<b>Wet room suitability</b>	●●●○	
<b>Rolled packable</b>	✓	✓

## PROCESSING

	NA	SA
<b>Cutting, punching</b>	✓	✓
<b>Drilling</b>	✓	✓
<b>Sawing</b>	✓	–
<b>Laser cutting</b>	✓	✓
<b>Hot bending</b>	✓	–
<b>PUR/PVA compressible</b>	✓	–
<b>min. bending radius</b>	150 mm	150 mm

## EXTRA EQUIPMENT

	NA	SA
<b>Format options (from 20 m²)</b>		
<b>max. length</b>	3000 mm	3000 mm
<b>max. width</b>	1250 mm	1220 mm
<b>Further thicknesses</b>	–	
<b>Cuttings</b>	✓	✓
<b>Magnetic</b>	from 3 sheets	–
<b>PUR/PVA pre-treatment</b>	✓	–

## ACCESSORIES

<b>SIBUKLE</b>	Spatula A1
<b>Profile groups</b>	1 / 2 / 3 / 5
<b>Profile recommendation</b>	2 / 5

## SPECIAL COLORS

LL LACE Black/Gold, LL LACE White/Vintage Brown
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**NA** non-adhesive **SA** strongly adhesive





2600



1000





# LL OXY



**LL OXY Steel**  
2600x1000x1,9 / **NA** 17826 / **SA** 17847



**LL OXY Terra**  
2600x1000x1,9 / **NA** 17827 / **SA** 17848



Photo: GARANTline

## PRODUCT CHARACTERISTICS

	NA	SA
<b>Base material</b>	HIPS	
<b>Surface material</b>	PU-leather/Print	
<b>Material thickness</b>	1,9 mm	2,03 mm
<b>Temperature stability</b>	up to 60 °C	up to 60 °C
<b>Wet room suitability</b>	●●●○	
<b>Rolled packable</b>	✓	✓

## PROCESSING

	NA	SA
<b>Cutting, punching</b>	✓	✓
<b>Drilling</b>	✓	✓
<b>Sawing</b>	✓	—
<b>Laser cutting</b>	✓	✓
<b>Hot bending</b>	✓	—
<b>PUR/PVA compressible</b>	✓	—
<b>min. bending radius</b>	150 mm	150 mm

## EXTRA EQUIPMENT

	NA	SA
<b>Format options (from 20 m²)</b>		
<b>max. length</b>	3000 mm	3000 mm
<b>max. width</b>	1250 mm	1220 mm
<b>Further thicknesses</b>	—	
<b>Cuttings</b>	✓	✓
<b>Magnetic</b>	from 3 sheets	—
<b>PUR/PVA pre-treatment</b>	✓	—

## ACCESSORIES

<b>SIBUKLE</b>	Spatula A1
<b>Profile groups</b>	1 / 2 / 3 / 5
<b>Profile recommendation</b>	2 / 5

## SPECIAL COLORS

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2600



1000



# LL QUADRO



**LL QUADRO Luxury Bronze**  
2612x1000x4,8 / **NA** 17831 / **SA** 17851



## PRODUCT CHARACTERISTICS

	NA	SA
<b>Base material</b>	HIPS, PE-foam	
<b>Surface material</b>	PU-leather/Print	
<b>Material thickness</b>	2,8 mm	3,04 mm
<b>Max relief height</b>	4,8 mm	5,04 mm
<b>Temperature stability</b>	up to 60 °C	up to 60 °C
<b>Wet room suitability</b>	● ● ● ○	
<b>Rolled packed*</b>	✓	✓

## EXTRA EQUIPMENT

	NA	SA
<b>Format options</b>	—	
<b>Further thicknesses</b>	—	
<b>Cuttings</b>	✓	✓
<b>Magnetic</b>	—	—
<b>PUR/PVA-Processing</b>	—	—

## PROCESSING

	NA	SA
<b>Cutting, punching</b>	✓	✓
<b>Drilling</b>	✓	✓
<b>Laser cutting</b>	✓	✓
<b>Hot bending</b>	—	—
<b>PUR/PVA compressible</b>	—	—
<b>min. bending radius</b>	300 mm	300 mm

## ACCESSORIES

<b>SIBUKLE</b>	Spatula A2
<b>Profile groups</b>	4 / 5

## SPECIAL COLORS

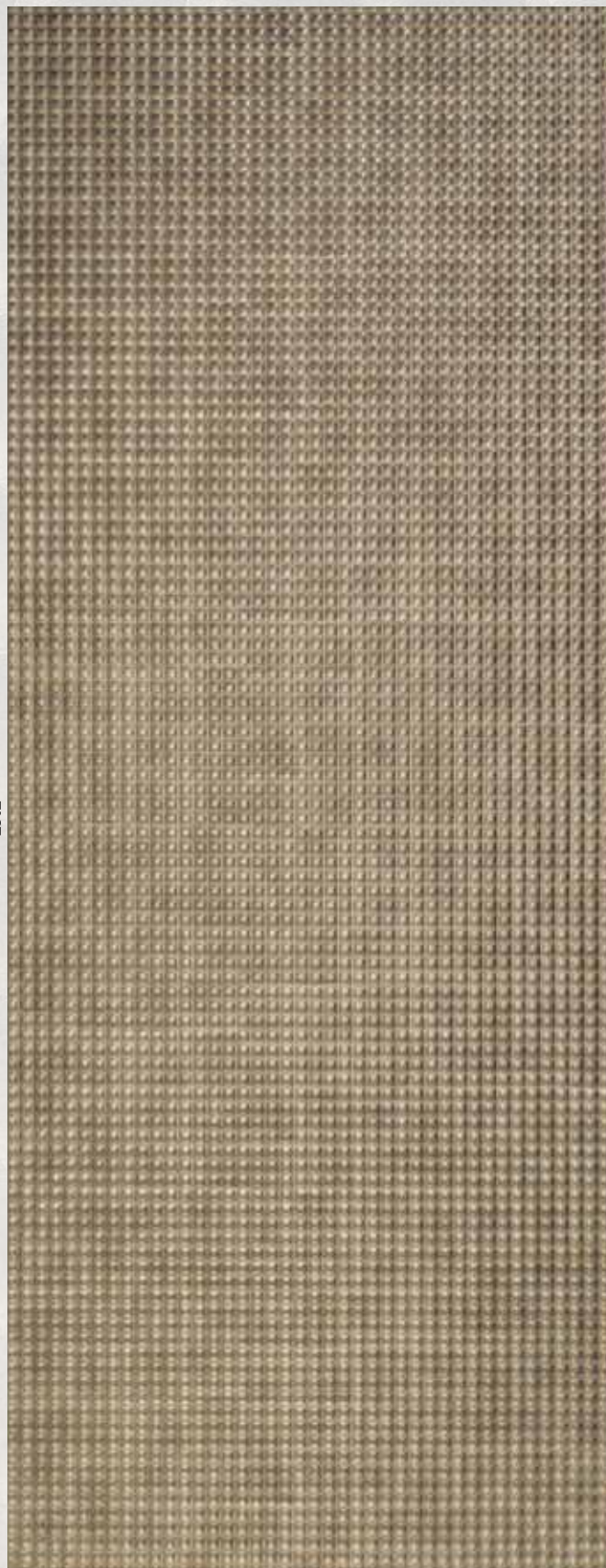
possible
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\* Design sheets to be rolled with the decor side outwardly (both – NA and SA version).  
We recommend rolling not more than 3 sheets per carton (480x480 mm).

**NA** non-adhesive **SA** strongly adhesive



2612



1000



# LL ROMBO 40

## LL ROMBO 40 Antigua Gold

2612x1000x5 / **NA** 17829 / **SA** 17849

## LL ROMBO 40 Oxy Terra

2612x1000x5 / **NA** 17830 / **SA** 17850



## PRODUCT CHARACTERISTICS

	NA	SA
<b>Base material</b>	HIPS, PE-foam	
<b>Surface material</b>	PU-leather/Print	
<b>Material thickness</b>	3,8 mm	4,04 mm
<b>Max. relief height</b>	5 mm	5,24 mm
<b>Temperature stability</b>	up to 60 °C	up to 60 °C
<b>Wet room suitability</b>	● ● ● ○	
<b>Rolled packable*</b>	✓	✓

## PROCESSING

	NA	SA
<b>Cutting, punching</b>	✓	✓
<b>Drilling</b>	✓	✓
<b>Laser cutting</b>	✓	✓
<b>Hot bending</b>	—	—
<b>PUR/PVA compressible</b>	—	—
<b>min. bending radius</b>	300 mm	300 mm

## EXTRA EQUIPMENT

	NA	SA
<b>Format options</b>	—	
<b>Further thicknesses</b>	—	
<b>Cuttings</b>	✓	✓
<b>Magnetic</b>	—	—
<b>PUR/PVA pre-treatment</b>	—	—

## ACCESSORIES

<b>SIBUKLE</b>	Spatula A2
<b>Profile groups</b>	4 / 5

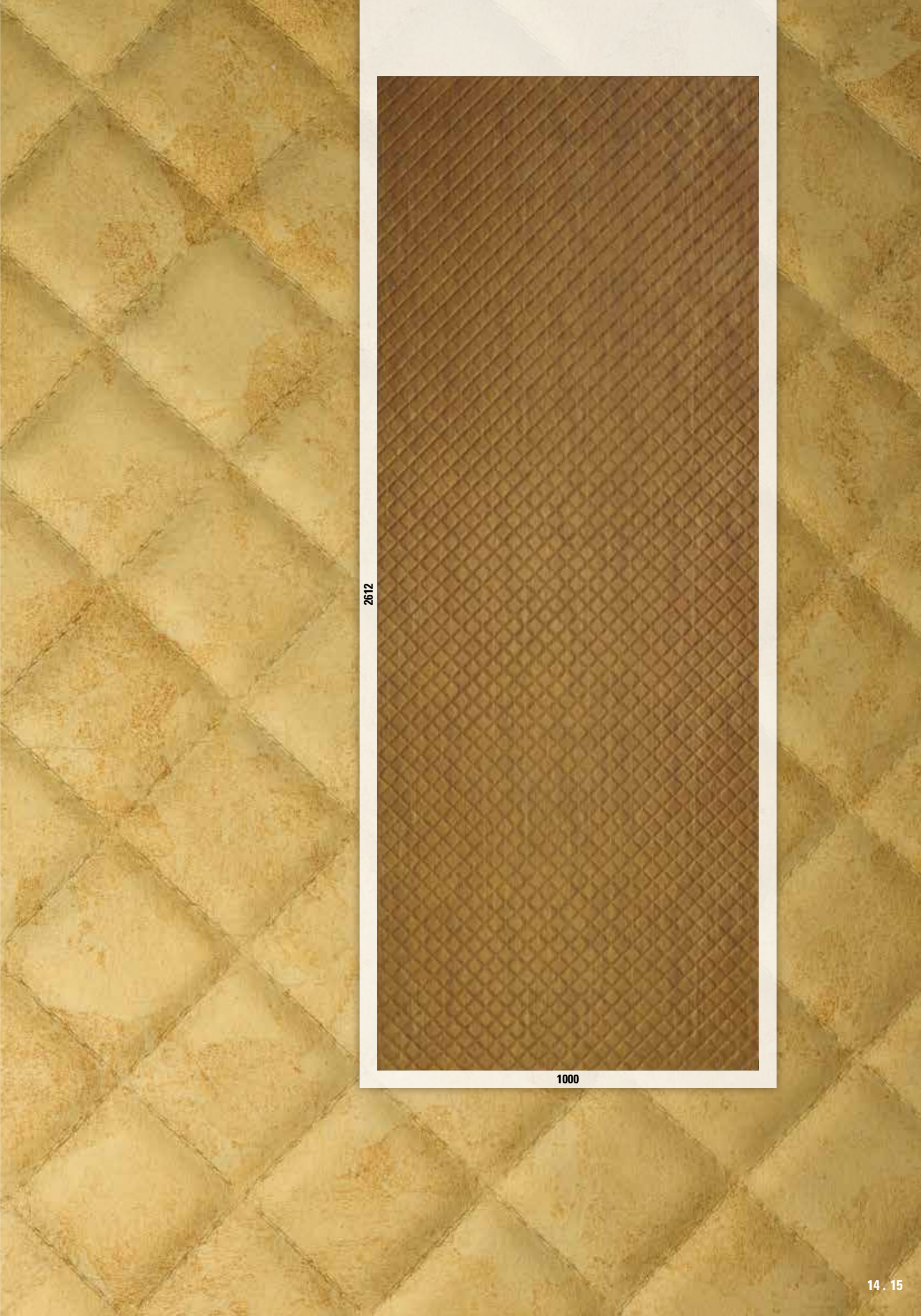
## SPECIAL COLORS

possible
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\* Design sheets to be rolled with the decor side outwardly (both – NA and SA version).  
We recommend rolling not more than 3 sheets per carton (480x480 mm).

**NA** non-adhesive **SA** strongly adhesive





2612



1000



# SG FLEUR

P

## SG FLEUR Black/Gold

2600x1000x1,8 / NA 17946 / SA 17953

## SG FLEUR Black/Gold AR+

2600x1000x2,7 / NA 17821 / SA 17842



SG FLEUR Black/Gold AR+

## PRODUCT CHARACTERISTICS

	NA	SA
Surface material	PMMA	
Back side material	PET / Print	
Material thickness	1,8 mm	1,93 mm
Temperature stability	up to 60° C	up to 60° C
Wet room suitability*	●●●●	
Customary abrasion resistance	●●●○○○	
Abrasion resistance after polishing	●●●●○	
Rolled packable (up to 40 °C)***	✓	

## AR+

	NA	SA
Surface material	PMMA	
Back side material	PET / Print	
Material thickness	2,7 mm	2,83 mm
Temperature stability	up to 60° C	up to 60° C
Wet room suitability*	●●●●	
Customary abrasion resistance	●●●●●●●●	
Abrasion resistance after polishing	—	
Rolled packable (up to 40 °C)***	—	

## PROCESSING

	NA	SA
Cutting, punching	—	—
Drilling	✓	✓
Sawing (supported by a panel)	✓	✓
Laser cutting	✓	✓
Hot bending	✓	—
PUR/PVA compressible	✓	—
Min. bending radius	240 mm	240 mm

## AR+

	NA	SA
Cutting, punching	—	—
Drilling	✓	✓
Sawing (supported by a panel)	✓	✓
Laser cutting	✓	✓
Hot bending	—	—
PUR/PVA compressible	✓	—
Min. bending radius	1000 mm	1000 mm

## EXTRA EQUIPMENT

	NA	SA
Format options	—	
Further thicknesses	on request	
Cuttings	✓	
Magnetic**	from 3 sheets	—
PUR/PVA pre-treatment	—	

## AR+

	NA	SA
Format options	—	
Further thicknesses	—	
Cuttings	✓	
Magnetic**	from 3 sheets	—
PUR/PVA pre-treatment	—	

## ACCESSORIES

	NA	SA
SIBUKLE	Spatula A2	
Profile groups	2 / 3 / 5	
Profile recommendation	2 / 5	

## AR+

	NA	SA
SIBUKLE	Spatula A2	
Profile groups	3 / 5	
Profile recommendation	3 / 5	

## SPECIAL COLORS (from 40 sheets)

possible
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\* For application in wet area it is important to seal the cutting edges with silicone (suitable for acrylic glass).

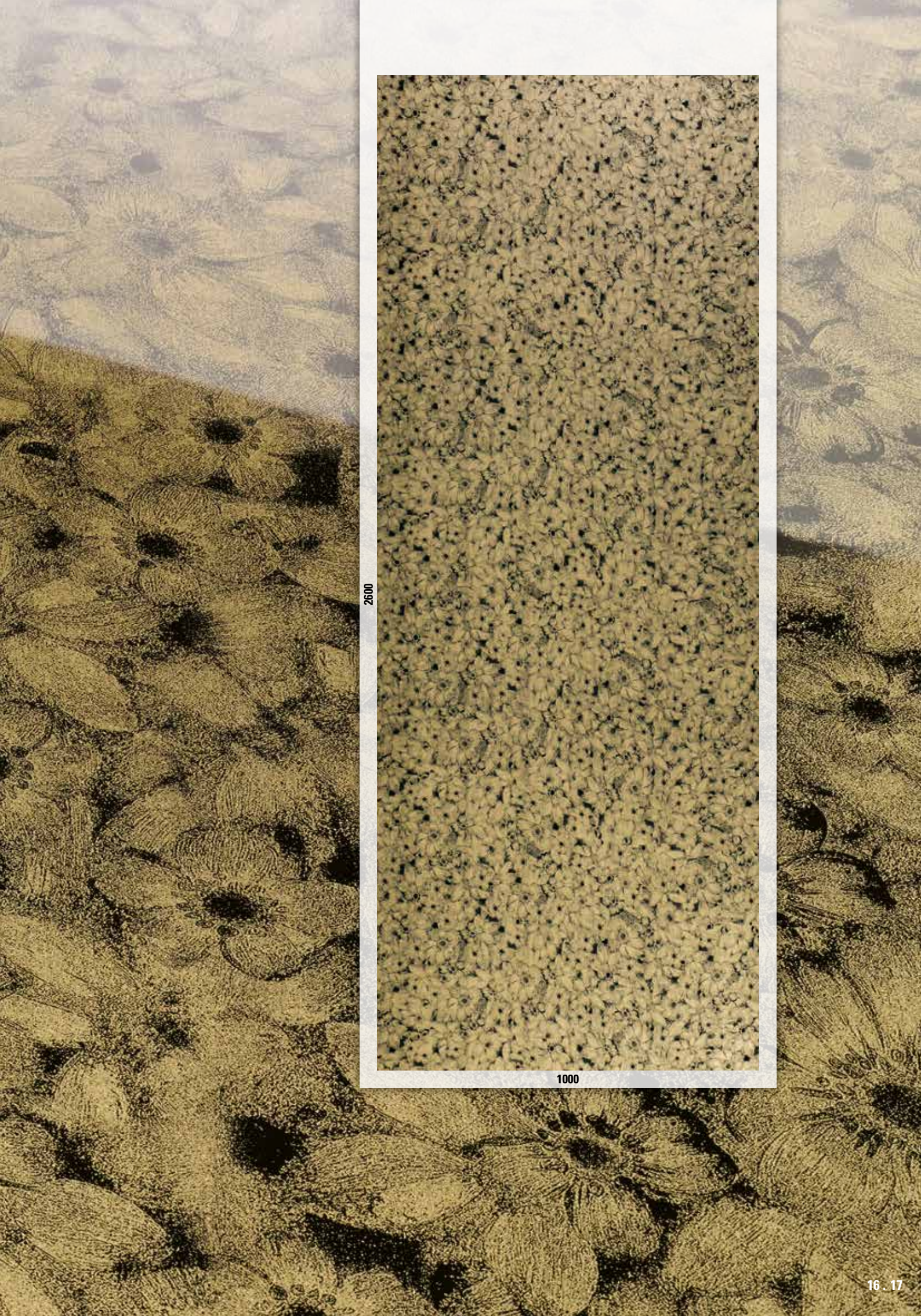
\*\* Ground must be real metal or a SIBU metal foil SA (ref. 17637, self adhesive).

\*\*\* Design sheets to be rolled with the decor side outwardly (both – NA and SA version). We recommend rolling not more than 3 sheets per carton (480x480 mm).

**AR+** SibUGlas AR+ products have an excellent abrasion resistance

**NA** non-adhesive **SA** strongly adhesive **P** Unpolished standard SG products are easily printable





2600



1000



# SG LUXURY

## SG LUXURY Gold

2600x1000x2,2 / **NA** 17944 / **SA** 17951

## SG LUXURY Gold AR+

2600x1000x3,1 / **NA** 17819 / **SA** 17840

## SG LUXURY Bronze

2600x1000x2,2 / **NA** 17945 / **SA** 17952

## SG LUXURY Bronze AR+

2600x1000x3,1 / **NA** 17820 / **SA** 17841



## PRODUCT CHARACTERISTICS

	NA	SA
Surface material	PMMA	
Back side material	PU-leather / Print	
Material thickness	2,2 mm	2,33 mm
Temperature stability	up to 60° C	up to 60° C
Wet room suitability*	●●●●	
Customary abrasion resistance	●●●○○○	
Abrasion resistance after polishing	●●●●●○	
Rolled packable (up to 40 °C)***	✓	

## AR+

	NA	SA
Surface material	PMMA	
Back side material	PU-leather / Print	
Material thickness	3,1 mm	3,23 mm
Temperature stability	up to 60° C	up to 60° C
Wet room suitability*	●●●●	
Customary abrasion resistance	●●●●●●●●	
Abrasion resistance after polishing	—	
Rolled packable (up to 40 °C)***	—	

## PROCESSING

	NA	SA
Cutting, punching	—	—
Drilling	✓	✓
Sawing (supported by a panel)	✓	✓
Laser cutting	✓	✓
Hot bending	✓	—
PUR/PVA compressible	✓	—
Min. bending radius	240 mm	240 mm

## AR+

	NA	SA
Cutting, punching	—	—
Drilling	✓	✓
Sawing (supported by a panel)	✓	✓
Laser cutting	✓	✓
Hot bending	—	—
PUR/PVA compressible	✓	—
Min. bending radius	1000 mm	1000 mm

## EXTRA EQUIPMENT

	NA	SA
Format options	—	
Further thicknesses	on request	
Cuttings	✓	
Magnetic**	from 3 sheets	—
PUR/PVA pre-treatment	—	

## AR+

	NA	SA
Format options	—	
Further thicknesses	—	
Cuttings	✓	
Magnetic**	from 3 sheets	—
PUR/PVA pre-treatment	—	

## ACCESSORIES

	NA	SA
SIBUKLE	Spatula A2	
Profile groups	2 / 3 / 5	
Profile recommendation	2 / 5	

## AR+

	NA	SA
SIBUKLE	Spatula A2	
Profile groups	3 / 5	
Profile recommendation	3 / 5	

## SPECIAL COLORS (from 40 sheets)

possible
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\* For application in wet area it is important to seal the cutting edges with silicone (suitable for acrylic glass).

\*\* Ground must be real metal or a SIBU metal foil SA (ref. 17637, self adhesive).

\*\*\* Design sheets to be rolled with the decor side outwardly (both – NA and SA version). We recommend rolling not more than 3 sheets per carton (480x480 mm).

**AR+** SibUGlas AR+ products have an excellent abrasion resistance

**NA** non-adhesive **SA** strongly adhesive **P** Unpolished standard SG products are easily printable



2600



1000



# SG LACE



**P**

**SG LACE White/Vintage Brown**  
2600x1000x1,8 / **NA** 17943 / **SA** 17950

**SG LACE White/Vintage Brown AR+**  
2600x1000x2,7 / **NA** 17818 / **SA** 17839



**P**

**SG LACE Black/Platin**  
2600x1000x1,8 / **NA** 17942 / **SA** 17949

**SG LACE Black/Platin AR+**  
2600x1000x2,7 / **NA** 17817 / **SA** 17838



Photo: GARANTline

## PRODUCT CHARACTERISTICS

	NA	SA
Surface material	PMMA	
Back side material	PET / Print	
Material thickness	1,8 mm	1,93 mm
Temperature stability	up to 60° C	up to 60° C
Wet room suitability*	●●●●	
Customary abrasion resistance	●●●○○○	
Abrasion resistance after polishing	●●●●●○	
Rolled packable (up to 40 °C)***	✓	

## AR+

	NA	SA
Surface material	PMMA	
Back side material	PET / Print	
Material thickness	2,7 mm	2,83 mm
Temperature stability	up to 60° C	up to 60° C
Wet room suitability*	●●●●	
Customary abrasion resistance	●●●●●●●●	
Abrasion resistance after polishing	—	
Rolled packable (up to 40 °C)***	—	

## PROCESSING

	NA	SA
Cutting, punching	—	—
Drilling	✓	✓
Sawing (supported by a panel)	✓	✓
Laser cutting	✓	✓
Hot bending	✓	—
PUR/PVA compressible	✓	—
Min. bending radius	240 mm	240 mm

## AR+

	NA	SA
Cutting, punching	—	—
Drilling	✓	✓
Sawing (supported by a panel)	✓	✓
Laser cutting	✓	✓
Hot bending	—	—
PUR/PVA compressible	✓	—
Min. bending radius	1000 mm	1000 mm

## EXTRA EQUIPMENT

	NA	SA
Format options	—	
Further thicknesses	on request	
Cuttings	✓	
Magnetic**	from 3 sheets	—
PUR/PVA pre-treatment	—	

## AR+

	NA	SA
Format options	—	
Further thicknesses	—	
Cuttings	✓	
Magnetic**	from 3 sheets	—
PUR/PVA pre-treatment	—	

## ACCESSORIES

	NA	SA
SIBUKLE	Spatula A2	
Profile groups	2 / 3 / 5	
Profile recommendation	2 / 5	

## AR+

	NA	SA
SIBUKLE	Spatula A2	
Profile groups	3 / 5	
Profile recommendation	3 / 5	

## SPECIAL COLORS (from 40 sheets)

possible
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\* For application in wet area it is important to seal the cutting edges with silicone (suitable for acrylic glass).

\*\* Ground must be real metal or a SIBU metal foil SA (ref. 17637, self adhesive).

\*\*\* Design sheets to be rolled with the decor side outwardly (both – NA and SA version). We recommend rolling not more than 3 sheets per carton (480x480 mm).

**AR+** SibUGlas AR+ products have an excellent abrasion resistance

**NA** non-adhesive **SA** strongly adhesive **P** Unpolished standard SG products are easily printable





2600



1000





# SG ANTIGUA

P

## SG ANTIGUA Gold

2600x1000x2,2 / **NA** 17947 / **SA** 17954

## SG ANTIGUA Gold AR+

2600x1000x3,1 / **NA** 17822 / **SA** 17843



## PRODUCT CHARACTERISTICS

	NA	SA
Surface material	PMMA	
Back side material	PU-leather / Print	
Material thickness	2,2 mm	2,33 mm
Temperature stability	up to 60° C	up to 60° C
Wet room suitability*	●●●●	
Customary abrasion resistance	●●●○○○	
Abrasion resistance after polishing	●●●●●○	
Rolled packable (up to 40 °C)***	✓	

## AR+

	NA	SA
Surface material	PMMA	
Back side material	PU-leather / Print	
Material thickness	3,1 mm	3,23 mm
Temperature stability	up to 60° C	up to 60° C
Wet room suitability*	●●●●	
Customary abrasion resistance	●●●●●●●●	
Abrasion resistance after polishing	—	
Rolled packable (up to 40 °C)***	—	

## PROCESSING

	NA	SA
Cutting, punching	—	—
Drilling	✓	✓
Sawing (supported by a panel)	✓	✓
Laser cutting	✓	✓
Hot bending	✓	—
PUR/PVA compressible	✓	—
Min. bending radius	240 mm	240 mm

## AR+

	NA	SA
Cutting, punching	—	—
Drilling	✓	✓
Sawing (supported by a panel)	✓	✓
Laser cutting	✓	✓
Hot bending	—	—
PUR/PVA compressible	✓	—
Min. bending radius	1000 mm	1000 mm

## EXTRA EQUIPMENT

	NA	SA
Format options	—	
Further thicknesses	on request	
Cuttings	✓	
Magnetic**	from 3 sheets	—
PUR/PVA pre-treatment	—	

## AR+

	NA	SA
Format options	—	
Further thicknesses	—	
Cuttings	✓	
Magnetic**	from 3 sheets	—
PUR/PVA pre-treatment	—	

## ACCESSORIES

	NA	SA
SIBUKLE	Spatula A2	
Profile groups	2 / 3 / 5	
Profile recommendation	2 / 5	

## AR+

	NA	SA
SIBUKLE	Spatula A2	
Profile groups	3 / 5	
Profile recommendation	3 / 5	

## SPECIAL COLORS

—
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\* For application in wet area it is important to seal the cutting edges with silicone (suitable for acrylic glass).

\*\* Ground must be real metal or a SIBU metal foil SA (ref. 17637, self adhesive).

\*\*\* Design sheets to be rolled with the decor side outwardly (both – NA and SA version). We recommend rolling not more than 3 sheets per carton (480x480 mm).

**AR+** SibUGlas AR+ products have an excellent abrasion resistance

**NA** non-adhesive **SA** strongly adhesive **P** Unpolished standard SG products are easily printable



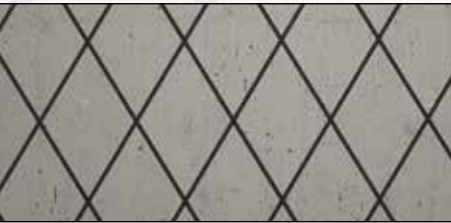
2600



1000



# SL LINEA



**SL LINEA 104x62 Old Platin**  
2600x1000x1,5 / **NA** 17835 / **SA** 17853

**P**



## PRODUCT CHARACTERISTICS

	<b>NA</b>	<b>SA</b>
<b>Base material</b>	HIPS	
<b>Surface material</b>	Print	
<b>Material thickness</b>	1,5 mm	1,63 mm
<b>Temperature stability</b>	up to 60 °C	up to 60 °C
<b>Wet room suitability</b>	●●●○	●●●○
<b>Abrasion resistance</b>	●●●●●○	●●●●●○
<b>Rolled packable</b>	✓	✓

## PROCESSING

	<b>NA</b>	<b>SA</b>
<b>Cutting, punching</b>	✓	✓
<b>Drilling</b>	✓	✓
<b>Sawing, milling</b>	✓	–
<b>Laser cutting</b>	✓	✓
<b>Hot bending</b>	✓	–
<b>PUR/PVA compressible</b>	✓	–
<b>min. bending radius</b>	150 mm	150 mm

## EXTRA EQUIPMENT

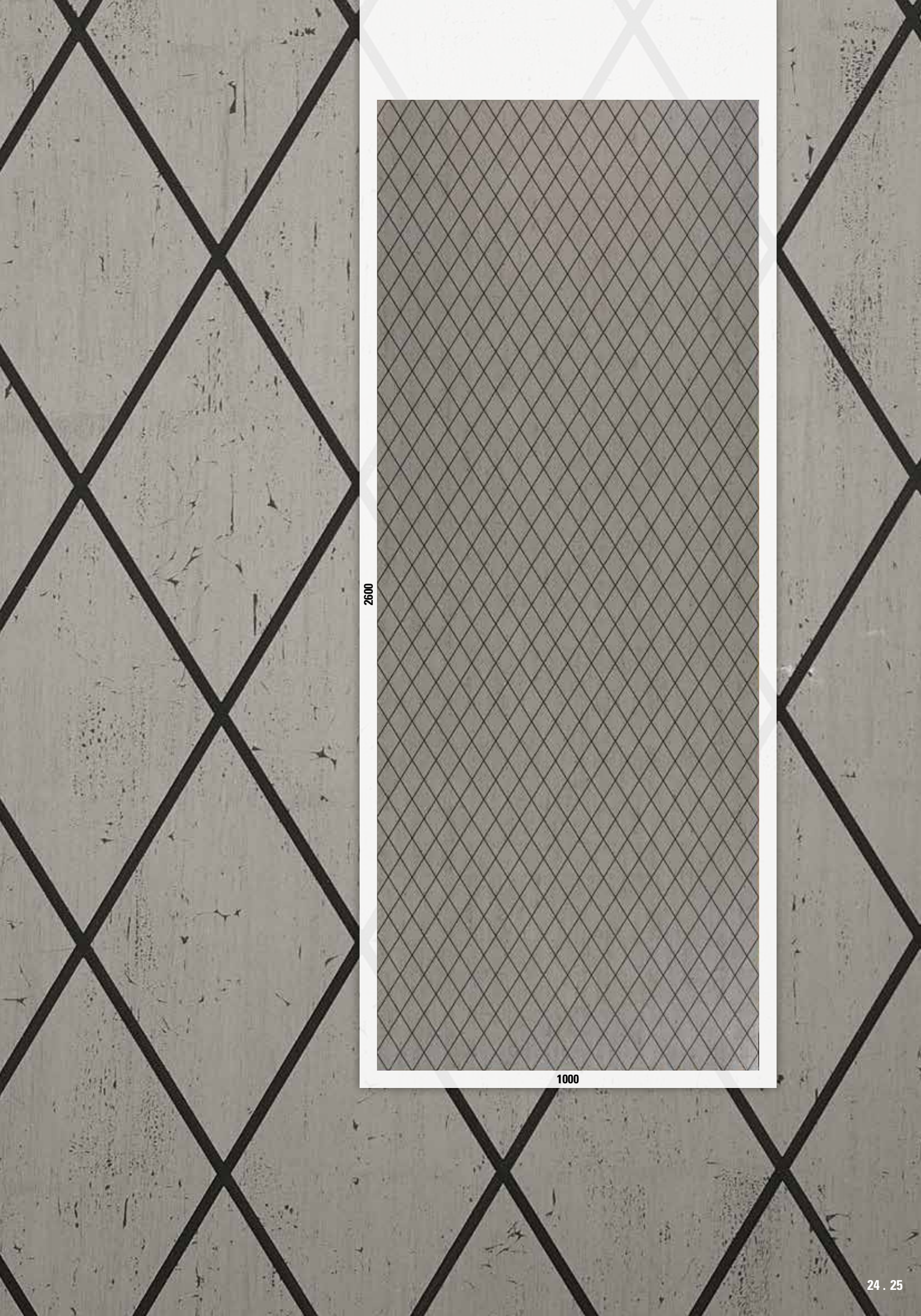
	<b>NA</b>	<b>SA</b>
<b>Format options</b>	–	
<b>Further thicknesses</b>	2 & 3 mm	
<b>Cuttings</b>	✓	✓
<b>Magnetic</b>	from 3 sheets	–
<b>PUR/PVA pre-treatment</b>	✓	–

## ACCESSORIES

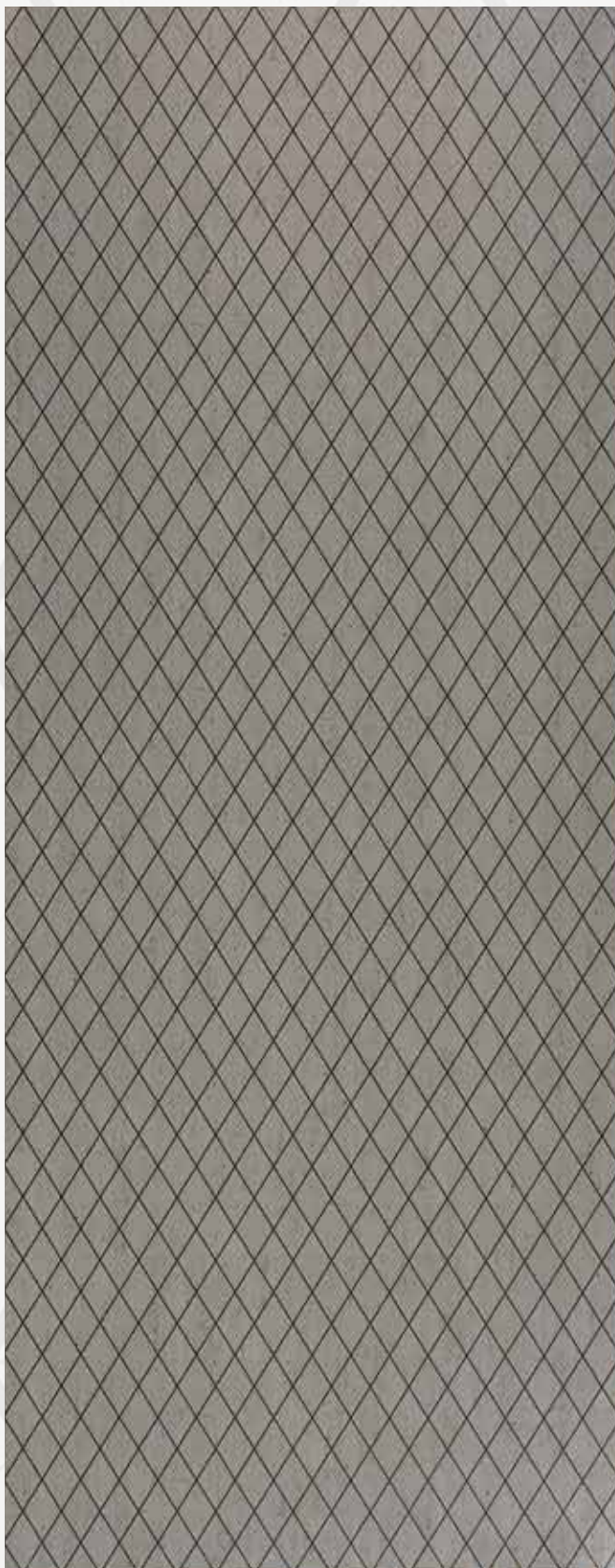
<b>SIBUKLE</b>	Spatula A2
<b>Profile groups</b>	1 / 2 / 3 / 5

## SPECIAL COLORS

possible
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2600



1000

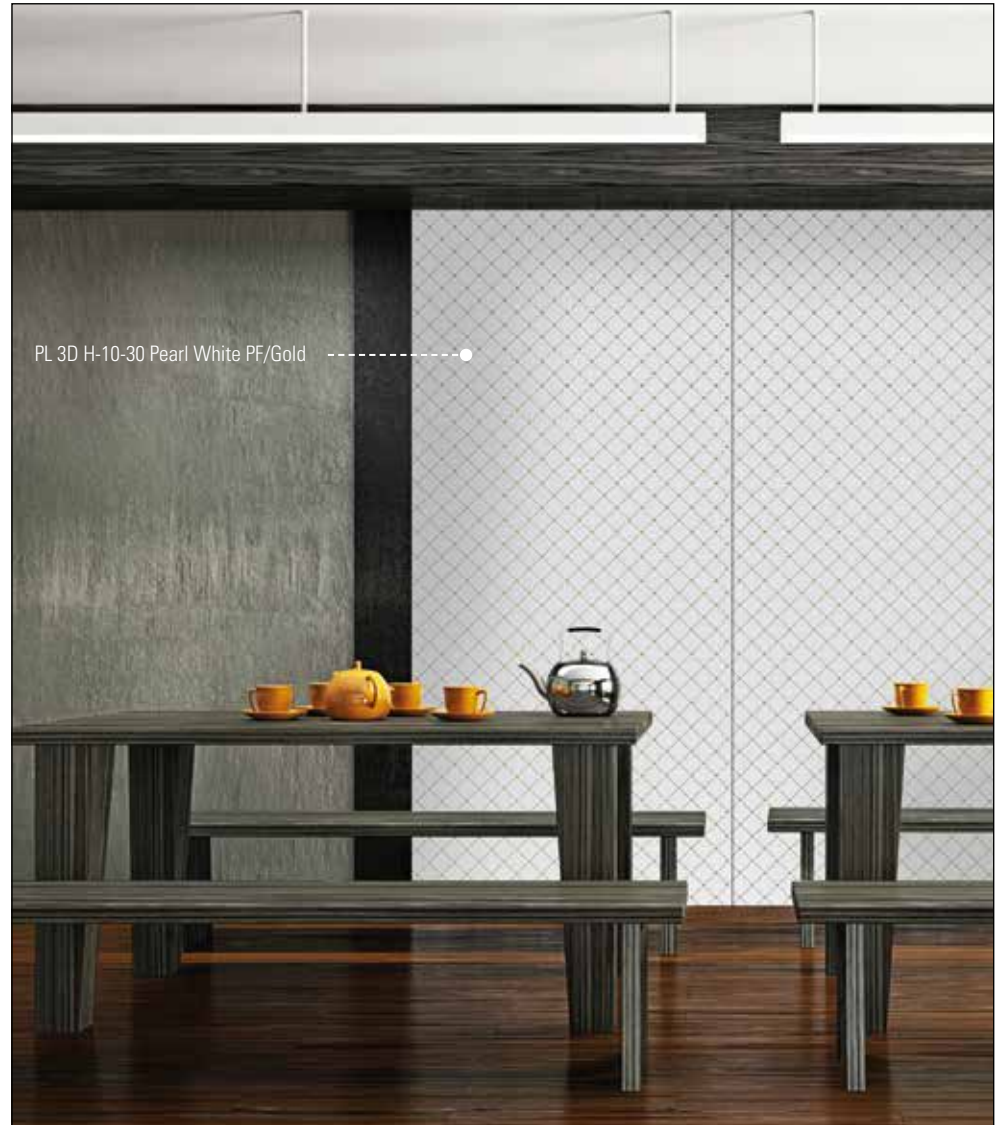


# PL 3D H-10-30



**PL 3D H-10-30 Pearl White PF/Gold**  
2600x1000x1,3 / **NA** 17832 / **SA** 17856

**P**



PL 3D H-10-30 Pearl White PF/Gold

## PRODUCT CHARACTERISTICS

	NA	SA
<b>Base material</b>	HIPS	
<b>Surface material</b>	Print	
<b>Material thickness</b>	1,3 mm	1,43 mm
<b>Temperature stability</b>	up to 50 °C, up to 50 °C	
<b>Wet room suitability</b>	●●●○	
<b>Abrasion resistance</b>	●●●●●●	
<b>Rolled packable (up to 40 °C)</b>	✓	✓

## PROCESSING

	NA	SA
<b>Cutting, punching</b>	✓	✓
<b>Drilling</b>	✓	✓
<b>Sawing, milling</b>	✓	—
<b>Laser cutting</b>	✓	✓
<b>Hot bending</b>	✓	—
<b>PUR/PVA compressible</b>	—	—
<b>min. bending radius (up to 40 °C)</b>	300 mm	300 mm

## EXTRA EQUIPMENT

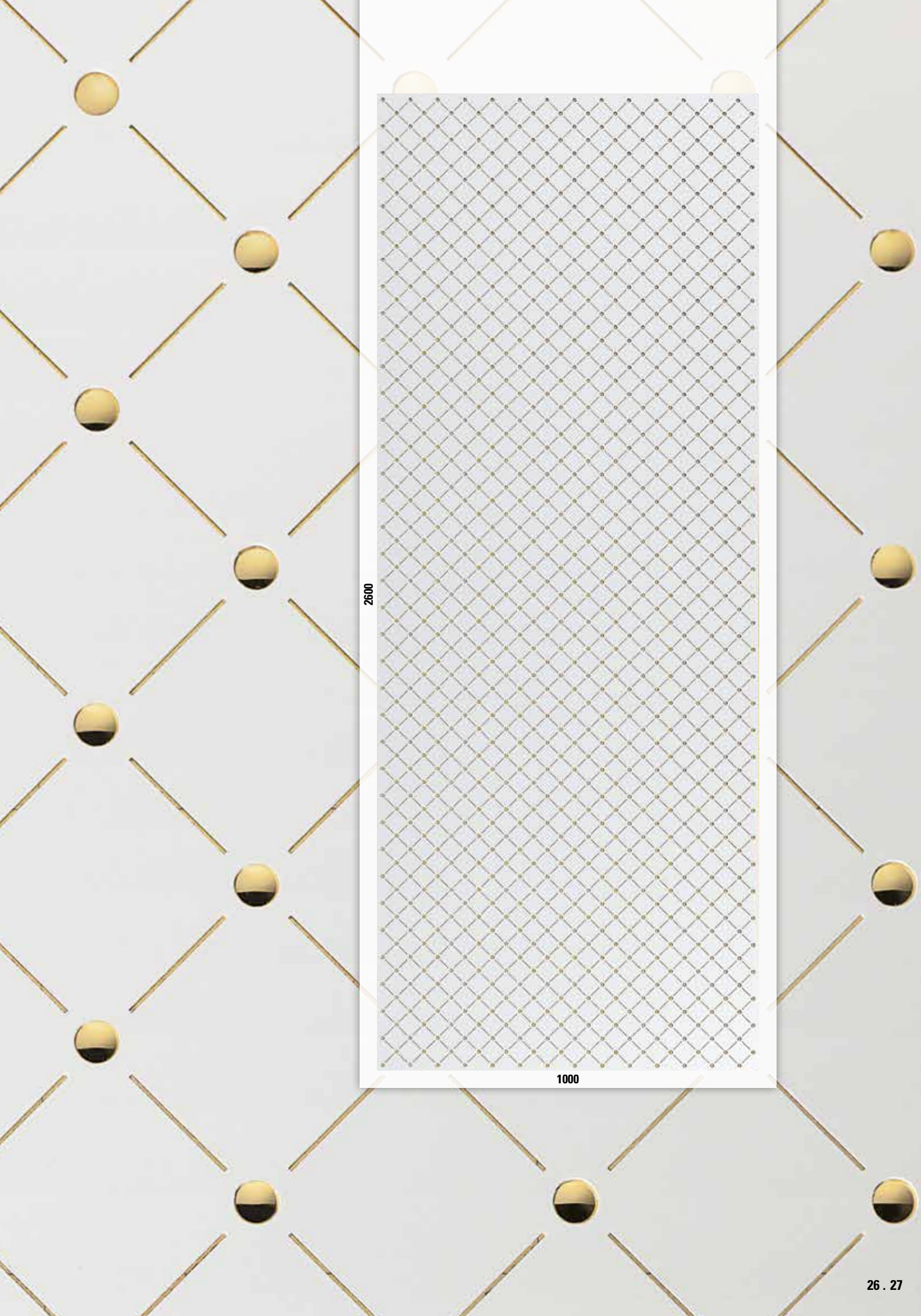
	NA	SA
<b>Format options</b>	—	
<b>Further thicknesses</b>	—	
<b>Cuttings</b>	✓	✓
<b>Magnetic</b>	from 3 sheets	—
<b>PUR/PVA pre-treatment</b>	—	—

## ACCESSORIES

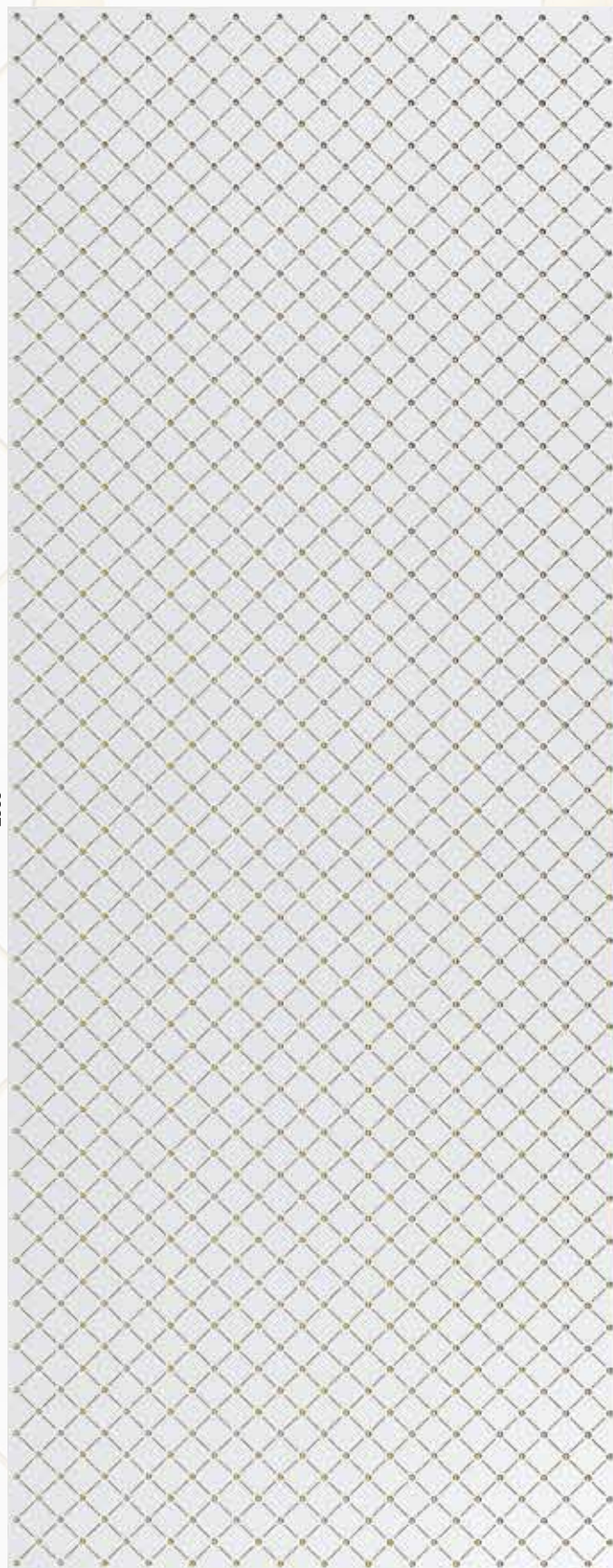
<b>SIBUKLE</b>	—
<b>Profile groups</b>	1 / 2 / 3 / 5

## SPECIAL COLORS

possible
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2600



1000

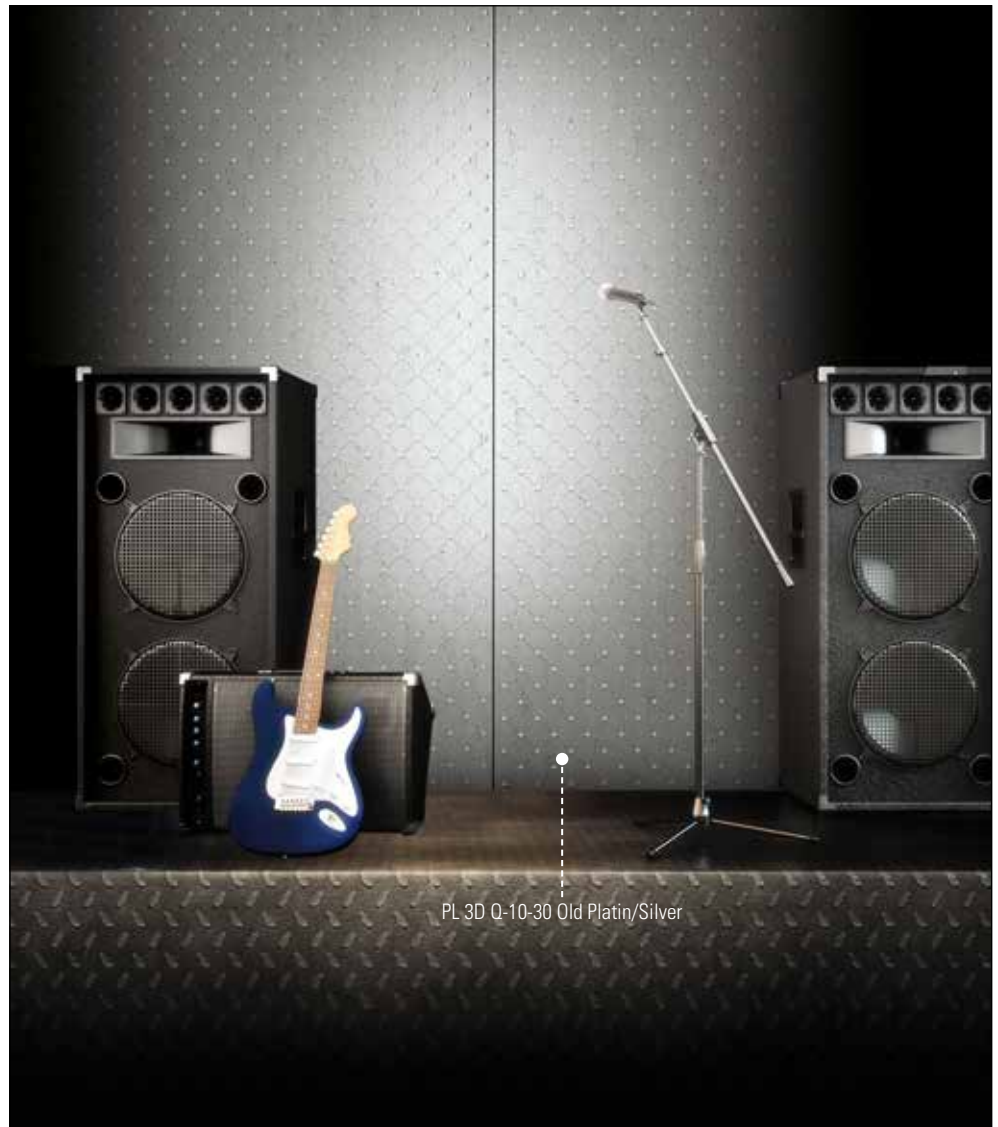


# PL 3D Q-10-30



**P**

**PL 3D Q-10-30 Old Platin/Silver**  
2600x1000x1,3 / **NA** 17833 / **SA** 17857



PL 3D Q-10-30 Old Platin/Silver

## PRODUCT CHARACTERISTICS

	NA	SA
<b>Base material</b>	HIPS	
<b>Surface material</b>	Print	
<b>Material thickness</b>	1,3 mm	1,43 mm
<b>Temperature stability</b>	up to 50 °C	up to 50 °C
<b>Wet room suitability</b>	●●●○	
<b>Abrasion resistance</b>	●●●●●○	
<b>Rolled packable (up to 40 °C)</b>	✓	✓

## PROCESSING

	NA	SA
<b>Cutting, punching</b>	✓	✓
<b>Drilling</b>	✓	✓
<b>Sawing, milling</b>	✓	–
<b>Laser cutting</b>	✓	✓
<b>Hot bending</b>	✓	–
<b>PUR/PVA compressible</b>	–	–
<b>min. bending radius (up to 40 °C)</b>	300 mm	300 mm

## EXTRA EQUIPMENT

	NA	SA
<b>Format options</b>	–	
<b>Further thicknesses</b>	–	
<b>Cuttings</b>	✓	✓
<b>Magnetic</b>	from 3 sheets	–
<b>PUR/PVA pre-treatment</b>	–	–

## ACCESSORIES

<b>SIBUKLE</b>	–
<b>Profile groups</b>	1 / 2 / 3 / 5

## SPECIAL COLORS

possible
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2600



1000

# DM LUXURY



**DM LUXURY Bronze**  
2600x1000x1 / **NA** 17825 / **SA** 17846



**DM LUXURY Gold**  
2600x1000x1 / **NA** 17824 / **SA** 17845



## PRODUCT CHARACTERISTICS

	NA	SA
<b>Base material</b>	HIPS	
<b>Surface material</b>	Print	
<b>Material thickness</b>	1,0 mm	1,13 mm
<b>Temperature stability</b>	up to 60 °C	up to 60 °C
<b>Wet room suitability</b>	●●●○	
<b>Abrasion resistance</b>	●●●●●○	
<b>Rolled packable</b>	✓	✓

## PROCESSING

	NA	SA
<b>Cutting, punching</b>	✓	✓
<b>Drilling</b>	✓	✓
<b>Sawing</b>	✓	–
<b>Laser cutting</b>	✓	✓
<b>Hot bending</b>	✓	–
<b>PUR/PVA compressible</b>	✓	–
<b>min. bending radius</b>	150 mm	150 mm

## EXTRA EQUIPMENT

	NA	SA
<b>Format options (from 100 m²)</b>		
<b>max. length</b>	3000 mm	3000 mm
<b>max. width</b>	1250 mm	1220 mm
<b>Further thicknesses</b>	✓	
<b>Cuttings</b>	✓	✓
<b>Magnetic</b>	from 3 sheets	–
<b>PUR/PVA pre-treatment</b>	✓	–


## ACCESSORIES

<b>SIBUKLE</b>	Spatula A1
<b>Profile groups</b>	1 / 2 / 3 / 5
<b>Profile recommendation</b>	2 / 5

## SPECIAL COLORS

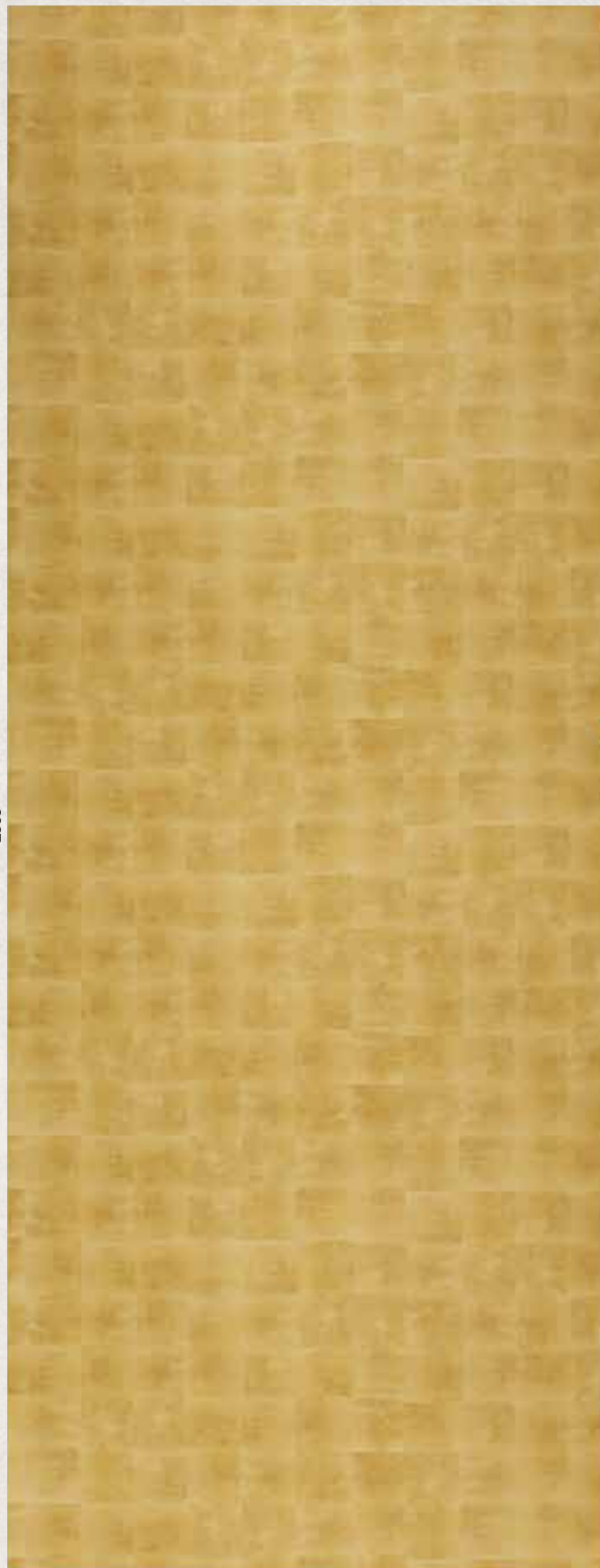
–
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**NA** non-adhesive **SA** strongly adhesive  NA version available in flame-retardant finish

 easily digital printable



2600



1000

# PRODUCT CHARACTERISTICS

To answer your questions as quickly as possible, our team has worked out a technical table with product characteristics, extra equipment and much more for each of our products:

## BASE MATERIAL

As a base material we use a specially developed, highly impact resistant polystyrene type (HIPS).

HIPS distinguishes particularly by robustness, high impact and a very low weight. For the cutting on site a standard wallpaper knife is effectual.

For our ACRYLIC-LINE we use as a base material ABS with acrylic surface. With PUNCH-LINE 3D products we use HIPS with background foil from A-PET.

## SURFACE MATERIAL

In a changeable world we focus on lastingness and high standards by using 100% PVC-free surfaces. We make a distinction between:

- Polyurethane synthetic leather surfaces (PU)
- Polyester imitation fur surfaces (PET)
- Metallized surfaces (PET)
- Special coloration (PET-varnish)
- Printed surfaces (Print)
- Acrylic surfaces (PMMA)

All variations are optically outstanding and also fascinate by their unique haptics. They correspond to the highest demands and they are suited especially for the interior area.

## MATERIAL THICKNESS

The given material thicknesses refer to the stock program in non-adhesive (NA) and strongly adhesive (SA) version.

## SA - STRONGLY ADHESIVE

SA means that the design sheet is equipped with adhesive at the back. For this we use high-quality acrylic adhesive substance or synthesis rubber (PUNCH-LINE 3D, MultiStyle). Strongly adhesive design sheets (SA) can be stuck on absorbent as well as non absorbent grounds.

Our base material polystyrene is a thermoplastic material, therefore a slight expansion of the design sheet is to be considered (see processing instructions).

## MAX. RELIEF HEIGHT

With the given data we define the highest position of the respective design in non-adhesive (NA) and adhesive (SA) version.

## TEMPERATURE STABILITY

We supply to more than 70 countries in the world and have nearly everywhere special climate situation. Therefore we test our material under the hardest conditions. Already during development stage our SIBU design sheets are tested in special thermo-containers stuck on ground as well as unstuck with high temperatures and high air humidity. Only the very best qualities correspond to our strict directives. The given data of the temperature stability refer to the lasting application of the product stuck on different grounds and to the long-term using temperature also without adhesion.

## WET ROOM SUITABILITY

An exposure of SIBU design sheets to humid areas is given when a design sheet is subjected to short term humidity condition. This humidity condition can occur by reason of high air humidity or by direct sprinkling water. SIBU design sheets are not suited for the direct wet space area as well as for long-term wet influence.

●●●● Wet room suitability   ●●●○ Wet room suitability, but material reacts more sensitively to sprinkling water → removing of moisture is recommended.

## ABRASION RESISTANCE

Products with marked abrasion resistance show an extremely scratch resistant surface. Our technology team already tests the products during development process to be able to offer the matching product for each of your demands.

●●●●●● excellent abrasion resistance	●●●○○○ normal abrasion resistance
●●●●●○ very good abrasion resistance	●●○○○○ low abrasion resistance
●●●●○○ good abrasion resistance	

## PRINTING

The surfaces of SIBU design sheets are printable by means of screen or digital printing which give them a very special and individual appearance. All products marked with **P** are easily printable. We offer original samples for tests. Info sheets on demand.

## ROLLED PACKABLE


Basically our design sheets are packed flat on pallets. However, in order to dispatch small consignments as favourably as possible, we have developed a packaging carton in which many of our design sheets can be packed rolled as well. Design sheets in non-adhesive (NA) version are rolled with the decor side outwardly and design sheets in strongly adhesive version (SA) are rolled with the glue side outwardly. We recommend rolling maximum 3 pieces from product group LEATHER-LINE per carton (480x480 mm) and for all other decors maximum 6 pieces per carton (480x480 mm).

After receipt, rolled goods should be laid out flat for around 24 hours at room temperature and if necessary, subjected to additional weight.

# EXTRA EQUIPMENT

We are aware of the fact that not always you can use our standard stock articles for your intended application and offer for you special extra equipment.

## FIRE CLASSIFICATION

The products from the stock program correspond to the fire safety regulations according to DIN 4102 B2, excluded products ACRYLIC-LINE (standard UL 94). NA versions of the marked products  are available in flame retardant version on request, on a different carrier material. Certificate of the following norm is given: EN 13501-1. Info sheets on demand!

## FORMAT OPTIONS

In addition to the standard sizes given in the OVERVIEW we offer with pleasure individually adapted product dimensions.

## FURTHER THICKNESSES

Responding to your request we produce our DECO-LINE and PUNCH-LINE in thicknesses between 0.8 and 4.0 mm.

## CUTTINGS

You want to get customized sheets or cuttings? Please contact us that we can offer the best possible solution to you. With a cutting length up to 3,2 meter and a punching and sawing length up to 3 meter we are able to meet your requirements and needs promptly.

## MAGNETIC

All SIBU design sheets are available with a magnetic back from 3 pieces onwards. Exception - all LL ROMBO, LL QUADRO and CR CRISTAL ROMBO.

SIBU magnetic foils are suitable on different metallic grounds and on magnetic colours. The exchange of design sheets thereby becomes a child's play! The application fields for the new SIBU DESIGN magnetic program are nearly unlimited – for shop-window decoration, shop fitting and fair design or in the furniture area, decoration field and for all kinds of displays.

Our SIBU decoration mirror DM Silver in magnetic version is available from stock in two sheet sizes 2600x1000x1,5 and 2000x1000x1,5:

- DM Silver Magnetic 2600x1000x1,5 (Art.No. 15903)
- DM Silver Magnetic 2000x1000x1,5 (Art.No. 15904)

Temperature stability: up to 50 °C

Cutting: The cut has to be carried out always from the decor side.

Fire rating class B2 (DIN 4102).

## PUR/PVA PRE-TREATMENT

In order to be suited to PUR/ PVA bonding, SIBU design sheets have to be pre-treated according to material thickness on the reverse side either by an additional production process or customer-sided grinding (using sandpaper - granulation 80).

Being able to carry out this pre-treatment for you in our factory, we absolutely need this information together with your order.

# PROCESSING

Please note that SIBU design sheets always have to be processed from the decor side.

## SURFACE PROTECTION

A protective film protects our surfaces against damages. This protective film should be removed only after the application of our design sheets.

## CUTTING

SIBU DECO-LINE sheets with less than 2 mm thickness can be easily cut with a wallpaper knife. Simply notch the surface and break along the edge. For all other product lines and for DECO-LINE sheets up to 3 mm thickness the cutting pressure has to be increased. After cutting and breaking our strongly adhesive (SA) design sheets as well as 3D PUNCH-LINE designs (NA + SA) the foil on the back side has to be cut separately. Always use well sharp knives.

## PUNCHING

Band steel cutting is recommended for design sheets in thickness from 1 up to 1,5 mm.

## DRILLING

All SIBU design sheets can be drilled from the decor side.

## SAWING

For material up to 1 mm thickness: HW 280x3,2 / 2,2x30 Z60 / 12,46-18,08 WZ

For more than 1 mm thickness: HW 250x3,2 / 2,2x30 Z40 / 19,63 WZ

HW 250x3,2 / 2,2x30 Z40 / 19,63 FZ/TZ

Rotation speed 6000 rpm – progressive feed up to 25 m/min

For LEATHER-LINE: HW 255x2,8 / 2,0x30 Z80 / 10,01 FZ WZ

Rotation speed 6000 rpm – progressive feed up to 10 m/min

With LEATHER-LINE the best result is achieved with MDF increment (4 mm) below and on top, low progressive feed and high rotation speed.

## MILLING

For material up to 2 mm thickness: cutter with 3 mm diameter, rotation speed from 12000 up to 24000 rpm, progressive feed up to 20 m/min.

Decor side on top: single-edged cutter - left turn

Decor side below: double-edged cutter - right turn

For material with more than 2 mm thickness reduce progressive feed and use a cutter with bigger diameter (6 mm).

## LASER CUTTING

All SIBU design sheets can be processed with standard lasers.

The cutting speed conforms to the watt power of the laser.

## MAX. BENDING RADIUS

The given data refer to the maximum bending radius for concave or convex fixing. For all design sheets – with the exception of MultiStyle – all sheet edges must be fixed mechanically in any case! For MultiStyle there is no need for mechanical fixing!



# PROCESSING

## HOT BENDING

Heat up the SIBU design sheets from the backside – for both, internal and exterior angles.

Approximate parameters for material in 1 mm thickness: Wire temperature: approx. 200 °C      Heating time: approx. 6 seconds

For ACRYLIC-LINE, PUNCH-LINE, DECO-LINE and STRUCTURE-LINE design sheets hot bending is outwardly (decor outside) possible – hot bending inwards (decor inside) is possible only with plain designs or with fine structures.  
For deeper structures - no exact internal angle.

Hot bending with LEATHER LINE design sheets is possible outwardly (decor outside), inwards (decor side inside) only with plain LEATHER-LINE. Using structured leather designs it can happen that wrinkles may appear along the internal angles.

## THERMOFORMING

For products with PET or PET/varnish surfaces a light tension of the surface by thermoforming is possible by using smooth and not sharp-edged tools (avoid sharp contours, use a bigger radius!).

All the other versions like PU-leather surfaces and printed surfaces are usually suited for thermoforming. For any new moulding tools self tests are recommended. The tool has to be adapted to the material.

Heating parameter: Approximate temperature: 160 - 210 °C by using upper heating and under heating. Processing period: between 20 to 40 seconds.

Original samples are available for tests.

## PUR/PVA-PRESSING

### PUR/PVA-BONDING

Non-adhesive design sheets from our DECO-LINE, LEATHER-LINE, STRUCTURE-LINE and ACRYLIC-LINE series (with a few exceptions) are compressible with commercial PVA adhesives. The ground must be absorbent (MDF, chipboard, etc.).

As a result of this type of processing, standard edges of plastic, aluminium or wood can be used! The PVA adhesive prevents the usual expansion of our design sheets due to the effect of increased temperature!

In order to be suited to PUR/PVA bonding, SIBU design sheets have to be pre-treated according to material thickness on the reverse side either by an additional production process or customer-sided grinding (using sandpaper - granulation 80).

### PUR/PVA-PRESSING

When pressing structured design sheets (STRUCTURE-LINE, ACRYLIC LINE and LEATHER-LINE), a medium-hard sponge rubber mat with a thickness of approx. 5 mm should be used between the pressing sheet and the patterned side of the design sheet. This provides uniform pressure distribution and prevents undesirable crushing spots caused inadvertently by particles of dirt between the pressing sheet and the design sheet.

When using DECO-LINE sheets in 1 mm thickness in a press it is better to press without the sponge rubber mat. The mat could cause irregular optics in the mirror surface. If you want to have a perfect mirror result, ask us for design sheets in 2 mm thickness.

Should by reason of transport or stock conditions the design sheet not have a crease-free protective film, the film should be removed prior to pressing process. The pressure applied should amount to 2 kg/cm<sup>2</sup> (0,2 N/mm<sup>2</sup>), the temperature to approx. 45 °C and the pressing time to around 10 minutes. The bonding of the balancing material and the design sheet should be done in a single working process. Standard HPL sheets are suited as a balancing material. During pressing onto an untreated particle-board with a thickness of 16 mm the best results were achieved with a 1 mm polystyrene sheet for balancing.

Following pressing allow the sheets to cool in a stack over night (about 16 hours). Cover the stack with a 19 mm plate so that the uppermost sheet also remains flat.



# ACCESSORIES

## PROFILES

For a perfect edging of SIBU design sheets or to cover necessary expansion gaps of the products, we offer technically and optically adjusted profiles. These profiles are divided into 5 groups, please consider our recommendations for your selected design sheets.

## SIBUKLE D22HV – solvent-free dispersion adhesive

The best suitable spatula size A1 or A2 is given for each product.

Applications: SIBUKLE D 22 HV is highly suitable for the bonding of SIBU products onto absorbent, flat surfaces such as wood, plywood, particleboard, gypsum plasterboard, concrete or smooth brickwork.

WARNING: SIBUKLE D 22 HV is entirely unsuitable for non-absorbent surfaces such as tiles, plastics, metals, glass, etc.

## ACRYLIC POLISHING-KIT

With the polishing-kit you are able to repair marks of consumption or scratches appearing on the acrylic surface.

At the same time the polishing creates protection of the surface. Set includes: • polishing paste • sponge • polishing cloth

# SPECIAL COLORS

You like our design - but it is not available in your color? In the rubric “special colors” we have listed up for you the additional surfaces, which can be specially produced for you in low quantity.

# STORAGE / TRANSPORT

## STORAGE INSTRUCTIONS

SIBU design sheets must always be kept in indoor stock, no storage outside! Following instructions are to be considered:

- Design sheets to be stored flat, rolled packed design sheets should be unpacked and laid out flat and - if necessary - subjected to additional weight to improve flatness (Use carton underlay and weigh down the entire sheet in order to prevent damage.)
- Store the uppermost plate in the pile with decor side down.
- Protect SIBU products from UV rays.
- Do not expose SIBU products to moisture or humidity.
- Protect material from dirt, dust and mechanical damages.
- A permanent storage of more than 3 months at a temperature less than 0 °C or more than + 30 °C may impact the quality of our design sheets and should be avoided.

## TRANSPORT INSTRUCTIONS

In general, for the transport of SIBU products pay attention to protect them from dirt, UV radiation, moisture and mechanical damages.

- Use stable, flat pallets with carton bedding, the pallet should be longer than the design sheets.
- Place the uppermost design sheet on the pallet with the decor side face down. This uppermost design sheet should be protected in addition by a carton and a board (e.g., chipboard, HDF ...).
- The design sheets should be protected from shifting.
- The edges and sides must be also protected (edge protection, PE foil ...)
- Avoid temperatures below - 35 °C or more than + 50 °C.
- Structured sheets to be transported on pallets with the patterns running in same direction.
- Basically, the transport of SIBU design sheets in rolled condition is possible. LL ROMBO 12, LL ROMBO 40, LL ROMBO 85, LL QUADRO as well as CR CRISTAL ROMBO 85 are excluded.
- SIBU products must be acclimatized prior to processing; ideal processing temperature is approx. + 10 °C to + 30 °C.
- Before any processing of the design sheets read the attached processing instructions which you can also find on the SIBU website!
- SIBUKLE D 22 HV should not be long-time stored below + 5 °C and must be protected from frost during transportation.

## CLEANING / DISPOSAL

### CLEANING

DECO-LINE, STRUCTURE-LINE, ACRYLIC-LINE, PUNCH-LINE, PUNCH-LINE 3D: in case of light dirt by means of soft cleaning cloth (it should be free of dust and free of dirt). In case of heavy dirt by means of standard plastic or window cleaner (spray cleaners not onto the material surface, but sparingly onto the cleaning cloth).

**Do not use abrasive cleaners, solvent cleaners or pure alcohol!**

**LEATHER-LINE:** Clean leather surfaces by means of standard liquid soap and then remove the soap with a humid cloth.

**Imitation fur surfaces:** In case of light dirt clean LL Savanna, LL Marabu, LL Reggae , LL Eleganza with a vacuum cleaner, in case of heavy dirt clean with a humid cloth.

### DISPOSAL

The keeping of healthy environment has high priority for us! We check all raw materials used for their environmental compatibility. Because not everyone has its own plastic disposal container, we pay special attention in development of new products to use only high-quality materials: materials, which may be disposed safely with the domestic waste. On demand we are pleased to provide LGA certificates for all SIBU design sheets.



# PROCESSING INFORMATION

## GROUND PREPARATION FOR GLUING

The ground should be dry and flat, free from loose parts, dust, dirt, grease, wax and silicone. To achieve a maximum adhesion, non-absorbent surfaces should be cleaned with alcohol (ethanol, isopropyl alcohol).

Strongly adhesive (SA) sheets are suitable for both, absorbent and non-absorbent surfaces, although non-absorbent surfaces are recommended.

Before using MultiStyle (MS) on a porous or highly absorbent surface, e.g. brickwork, gypsum plasterboards or untreated chipboards, we recommend undercoating the ground. Alternatively you can use our SIBUKLE D22 HV dispersion adhesive as a suitable first coat.

We also recommend SIBUKLE D22 HV dispersion adhesive when using non-adhesive STRUCTURE-LINE (SL) and DECO-LINE (DM) sheets on porous or highly absorbent grounds, e.g. brickwork or gypsum plasterboards and untreated chipboard.

In case of non-absorbent grounds surface tension should be at least 38 dyn (industrial info!). For application on convex or concave grounds all sheet edges must be fixed mechanically.

## BONDING

Ideal processing temperature ranges from + 10 °C up to + 30 °C. The design sheets should be acclimatized, i.e. they should be brought to room temperature prior to processing (avoidance of condensation on the gluing surface).

A temperature increase of 10 °C will cause our products to expand by approx. 0,7 mm over a length of 1 meter. As a rule, expansion gap of approx. 2 - 3 mm should be kept at each sheet edge!

In case of high surroundings temperature or major temperature-fluctuations the expansion gap should be increased or the sheet format should be chosen smaller. Avoid blistering (air inclusions); use a medium-hard hand rubber roller with a width of approx. 170 mm.

Remove the backing cover step-by-step from strongly adhesive design sheet (SA), do not touch gluing surface and press the sheet onto the ground as firmly as possible. The final adhesion power will be reached at room temperature after 24 hours.

## PROCESSING SIBUKLE

**Application:** SIBUKLE D 22 HV is best suited for the gluing of SIBU products onto absorbent flat grounds like wood, plywood, chipboard, gypsum plasterboard, concrete or smooth brickwork.

ATTENTION: SIBUKLE D 22 HV is not suited for non-absorbent grounds such as tiles, plastics, metals, glass, etc.

**Processing:** Apply exclusively on the entire cleaned ground by means of fine spatula (spatula toothing is given for every product).

At a surroundings temperature between 20 °C and 35 °C the adhesive should then be left to air for 20 - 50 minutes.

The higher the surroundings temperature is the shorter is the airing time.

Finger test: After application with the spatula the maximum airing time is reached as soon as the glue no longer sticks to the fingers!

**Storage:** In the original airtight containers the adhesive can be stored up to 12 months from delivery date. Store always above freezing point. Protect from frost, otherwise the glue cannot be used anymore!

# SIBUGLAS DECORATIVE SHEETS + SIBUGLAS BACKING SHEETS

for gluing and pressing onto absorbent wood materials such as MDF or particle board!

SIBUGLAS currently offers a vast range of applications whether for home-furniture, shop windows, bars, hotels or trade fair stands.

SIBUGLAS is a multi-layer sheet consisting of PMMA, PU-leather and a special synthetic fibre, which can be bonded onto absorbent surfaces using PVA white glue. In order to ensure optimum flatness, we also deliver an accompanying, technically matching backing sheet.

## SIBUGLAS / SIBUGLAS AR+ WITH SCRATCH-RESISTANT SURFACE INCL. SIBUGLAS BACKING SHEET

A **major processing advantage** of our SIBUGLAS (SG) sheets is provided by a **special synthetic fibre on the reverse side (on decorative sheet + backing sheet)**. Using a roller with PVA white glue, these completely saturated fibres are applied as evenly and as quickly as possible on both sides of the absorbent wooden base sheet. This composite is then placed in a press.

The saturated, synthetic fibres compensate for any small surface irregularities or fine, overseen particles of dirt. **As a result, perfect, high-gloss surfaces can be simply created.**

## SG DESCRIPTION / STRUCTURE

### SG decorative sheet

- PE protective film
- Scratch-resistant surface, only in the **AR+** version
- Transparent, UV-resistant, UV-impermeable and chemical-resistant PMMA layer
- PU-leather/decorative layer, special synthetic fibre
- PVA white glue

### Wooden base sheet,

minimum thickness 16 mm!

### SG backing sheet

- PVA white glue
- PU-leather/single colour, special synthetic fibre
- PMMA sheet
- PE protective film

SG decorative sheets that are glued and pressed in this manner can be processed simply and efficiently with the majority of woodworking machines and tools. During processing, the PE protective film must remain on the surface. The employment of suitable and sharp tools prevents damage.

Prior to production tests are recommended to determine individually optimum machine parameters, tool settings and cutting speeds.

## SIBUGLAS DECORATIVE SHEET - PRODUCT STRUCTURE

SIBUGLAS is a compound material consisting of the following individual components. The characteristics of the various materials and correct processing are of decisive importance for the overall quality of components/decorative elements using SIBUGLAS.

### Structure: SIBUGLAS

1,1 mm transparent layer  
0,8 - 1,3 mm decorative layer  
Fabric

### Material: SIBUGLAS

PMMA acrylate  
PU-leather  
Special synthetic fibre



**Structure: SIBUGLAS AR+**

2,0 mm transparent layer  
 0,8 – 1,3 mm decorative layer  
 Fabric

**Material: SIBUGLAS AR+**

**Scratch-resistant surface coating** on PMMA acrylate  
 PU-leather  
 Special synthetic fibre

The 1,1- and 2,0 mm-thick, highly transparent layer lends SIBUGLAS a genuine glass appearance with outstanding product characteristics with regard to bonding with the respective wooden base material such as particle or MDF board.

## SIBUGLAS BACKING SHEET - PRODUCT STRUCTURE

**Structure: SG backing sheet**

1,1 mm transparent layer  
 or  
 2,0 mm transparent layer for **SG AR+**  
 0,8 mm single-colour, decorative layer  
 Fabric

**Material: SG backing sheet**

PMMA acrylate  
 PMMA acrylate  
 PU-leather  
 Special synthetic fibre

A **technically matching backing sheet is required** for the glued and pressed composite (surface + wooden base sheet + backing sheet), which is ideally attuned to the characteristics of the materials used. This virtually excludes warping caused by heat, cold or fluctuating humidity levels.

# SIBUGLAS (SG) PRODUCT CHARACTERISTICS

## STEP-BY-STEP BONDING INSTRUCTIONS FOR SIBUGLAS SHEETS WITH PVA WHITE GLUE

**Glue application: only process flat, wooden base sheets!**

Conditioned SG decorative and SG backing sheet, as well as the wooden base sheet, should be laid out adjacent to one another on a straight, clean and sufficiently large work table. The cut wooden base sheet must be roughly 10 mm larger than the SG sheets.

**Both SG sheets should first be generously coated with PVA glue using a roller.** Owing to the highly absorbent SG reverse side, the consumption of PVA white glue is considerable and amounts to approx. 200 - 300 g/m<sup>2</sup>.

**Shortly before bonding, the synthetic fibres should have a wet, sticky shine.** Subsequently, both SIBUGLAS sheets are positioned as quickly as possible on the middle of the wooden base sheet.

**Warning! Glue should not be applied directly to the wooden base sheet, as this can have a negative effect on evenness!**

**Pressing: only process flat, wooden base sheets!**

The composite sheet is now placed in the press for approx. 15 minutes at 30 °C. Do not apply excessive pressure and take into account both your know-how and the values gained from personal experience.

**Important!** As soon as the sheets are removed from the press, they must be stored **under stacking pressure for at least 12 hours** in a **FLAT** position. A genuinely even surface is extremely important for the flatness of the composite sheet.

A second option for small quantities is press bonding the sheets in the machine overnight at 20 °C. There is no need for stacking pressure for that type of processing.

**Warning! Always clean the press thoroughly prior to processing SG!** The cleanliness of the sheet press will be mirrored by the structured surface!

**Wooden base sheets with minimum warping (exception):** If from the outset the wooden base sheets are not exactly flat, the backing sheet should always be glued onto the hollow side (inner radius) and the decorative sheet onto the side with the outward warp (outer radius). This facilitates further processing and installation.

**Edging application:** As usual, any standard edging can be mounted in the familiar manner!

**Cutting to length/edge trimming and other work phases:** At the earliest, complete this work 24 hours after gluing/pressing!

# FURTHER MECHANICAL PROCESSING

PMMA starts to melt at approx. 110 °C, therefore feed in carefully and slowly!

## **Basic rule! High speed – slow feed!**

**Sawing/edge trimming:** In order to optimise cut quality, we suggest the use of narrow, unset, carbide tipped circular saw blades for plastic and laminate surfaces with as many alternate and/or hollow teeth as possible. The saw blade should have a minimum speed of at least 2800 rpm. The sheets should be sawn individually and scoring may not be employed. Ideally, the saw blade should not protrude by more than 10 - 20 mm.

**A saw blade tip:** Leitz, Art. No. 58453, diameter: 250 mm, width: 2,4 / 1,6 mm, number of teeth: 30, alternate teeth Z80/9.82. The alternate teeth are bevelled on the outside (bevelling: 0,3 mm, 45 °C) and must also always be sharpened. **For a clean cut edge it is important that the saw blade is really sharp!**

**Important!** Do not use set-up circular saw blades!

**Milling:** As is the case with sawing, high processing temperatures should be avoided wherever possible. PMMA starts to melt at approx. 110 °C, therefore use high speeds and careful and slow feeding!

As a rule, the machinery and tools employed for woodworking are suitable for the processing of our SIBUGLAS sheets bonded onto wooden base sheets.

Narrow milling edges can be subsequently improved optically with a scraper or emery paste.

**For a clean-cut edge, it is important that the tools are always well sharpened!**

**Drilling:** Use a wood drill!

Hinge drillings and processing using a Forstner bit are no problem.

**Cleaning SIBUGLAS:** SIBUGLAS possesses an excellent optical depth effect.

Liquid cleaning agents and water are extremely well suited to the cleaning of chemical-resistant SIBUGLAS surfaces. Dirty cloths and abrasive cleaning agents are to be avoided.

**Cleaning SIBUGLAS AR+:** The SIBUGLAS AR+ surface has additionally a high-quality, glossy, scratch- and abrasion-resistance coating. Mechanical cleaning processes using, e.g. razor blades, knives or scrapers may not be used. Liquid cleaning agents and water are ideal for the cleaning of chemical-resistant SIBUGLAS sheets. In addition, SIBUGLAS AR+ is particularly chemical-resistant!

## **Suitable for cleaning are:**

- Lukewarm water with a small amount of washing up liquid
- Isopropanol (2-Propanol)
- Pure light petrol (benzine)
- Soft, damp viscose sponge
- Soft, damp, fluff-free cloth
- Sponge cloth
- Window leather
- Glove lining
- Cotton tea towel
- Shower scraper with soft rubber lip
- Moist micro-fibre cloth for finishing (e.g. Vileda Microclean)



**i** To the best of our knowledge, the information provided corresponds with our current know-how and experience. Nonetheless, it is to be regarded as non-binding. The information is based on practical experiences, test results as well as on in-house testing and corresponds to our today's state of knowledge. The right to make changes in the course of technical progress and further developments is retained. The recipient is not released from an obligation to undertake a careful examination of the functions and application possibilities of the product by qualified personnel. This shall also apply with regard to the protective rights of third parties. Detailed information sheets are available on request. No liability is accepted for misprints, norm errors and mistakes.

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SIBU DESIGN GmbH & CoKG  
Jupiterstraße 8, 4452 Ternberg, Austria / Tel.: +43 (0)7256.6025.0  
Fax: +43 (0)7256.7020 / E-mail: [info@sibu.at](mailto:info@sibu.at) / [www.sibu.at](http://www.sibu.at)