CPL is a continuous highly resistant laminate. It is a moldable product that can easily be applied to rounded edges and corners (a process that is carried out using a special piece of equipment, since heat is required for molding), to give the surface a lighter, more elegant appearance. On top of this, its profile is somewhat lighter and, therefore, the black line that is a characteristic of Formiline laminates is less apparent. It is made by impregnating successive layers of cellulosic materials (paper) with thermostable (melamine and phenolic) resins, to make a slurry which is then compressed using heat and high pressures.

CPL is 100% postforming and yields up to 20% more in the cut plane. It is obtained using a continuous press, with highly flexible dimensions (length and thickness), and may be supplied on bobbins or in sheets, in different patterns and finishes, thus speeding up production and reducing waste. CPL is also highly resistant to wear, heat and staining, making it a practical, durable product.

CPL Applications
CPL laminate can be applied as a covering for domestic, commercial, hospital, hotel and school furniture, on MDF (Medium Density Fiberboard), chipboard, plywood and Civil Construction substrates, as long as the following criteria are observed:

- The materials mentioned above must be of a high quality, with no flaws in their surfaces;
- They must be resistant to being glued to the laminates;
- Their surfaces must be free from humidity, dust, oil etc.

Main benefits
On top of the Formiline laminate benefits, CPL also offers:
- The versatility of postforming (if the proper techniques are used);
- Reduced thicknesses (from 0.2mm to 0.7mm) and different widths (up to 1.30m);
- Different lengths;
- Can be supplied on bobbins and/or in sheets;
- When supplied on bobbins, it requires less storage space;
- Possibility of better yield from the sheets (cut plane), reducing costs and waste.

Bobbins

<table>
<thead>
<tr>
<th>Dimensions</th>
<th>Thickness</th>
</tr>
</thead>
<tbody>
<tr>
<td>60 m / long</td>
<td>0.6 mm</td>
</tr>
<tr>
<td>1.30 m / wide</td>
<td></td>
</tr>
</tbody>
</table>
The first step is to cut the base (plywood, MDP, MDF), using a suitable saw. Then, work the edges with the help of a shaper, using the correct cutters.

Sandpaper down to remove burrs, taking care not to leave the base uneven, as this will jeopardize the quality of the adhesion to the CPL, because the laminate will take the shape of the surface it is being stuck to and will, therefore, also be as uneven as the substrate.

When applying CPL, it is necessary to use a wooden slat, with a rounded point, which has been wrapped with a soft cloth, or a rubber roller. This protection prevents the surface of the laminate from getting damaged.

Pressure must be applied to the CPL from the center to the edges in order to eliminate any air bubbles that may form. The postforming equipment used must be pre-heated, and have resistances that warm up the CPL, softening it and enabling it to be molded.

It is, however, always necessary to perform a bubble test before starting work, in order to find the ideal time for molding the CPL. To do this, put a small sample (10 x 20 cm) of the CPL on the equipment table, exposing it to the heat of the resistance, with the decorative surface face down. Measure the time it takes for a bubble to form in the laminate. The test may give different results as these can vary depending on the batch and the surrounding temperature.

The cut CPL should be the approximate size to the part, leaving a sufficient surplus to be molded on site.

Next, remove any dust residues and apply a uniform coat of Formiline Contact Adhesive to the surface of the wood and to the back of the laminate. Apply a greater amount of glue to the machined edges.

Note:
The glue’s drying time when applied to the laminate should be the same as usual (15 to 30 minutes). In the case of postforming, the drying time should be at least 6 and no more than 12 hours.

Note:
If the time taken for a bubble to form is under 10 seconds, we recommend reducing exposure to 4 - 5 seconds, or increasing the distance between the laminate and the resistance, to get a satisfactory time.
CPL (Continuos Press Laminate)
How to work with the product

Use the table above to determine the ideal postforming time. For example: if it takes 30s for the CPL to form a bubble, the material should be molded after 20s. Once the ideal time has been found, put the item to be molded into the equipment. If manual equipment is used, it will be the joiner that applies the pressure with the rubber roller or rounded wooden slat, which will always be protected as recommended earlier. A manual shaper, plane or file may be useful when finishing off the edges, but care must be taken not to scratch the surface of the item.

<table>
<thead>
<tr>
<th>Bubble time</th>
<th>Reduce by</th>
</tr>
</thead>
<tbody>
<tr>
<td>30 - 40 s.</td>
<td>10 s.</td>
</tr>
<tr>
<td>40 - 45 s.</td>
<td>12 s.</td>
</tr>
<tr>
<td>45 - 50 s.</td>
<td>15 s.</td>
</tr>
<tr>
<td>50 - 55 s.</td>
<td>17 s.</td>
</tr>
</tbody>
</table>

Note:
- Never use a wet cloth after molding, because the cold water may spoil the laminate, due to thermal shock.
- We recommend repeating the bubble test every 2 hours.

Storage
CPL must be stored in a covered place, which is protected against bad weather, keeping it away from wet areas and out of direct sunlight or other sources of heat. Sheets of the laminate must be stored horizontally on a flat surface with the decorated side facing upwards. Bobbins may be stored either horizontally or vertically, keeping the side protectors in place in the head of the bobbins.

Cleaning
As it has a non-porous surface, the laminate does not accumulate dirt, therefore making it difficult for fungi and bacteria to proliferate. It is, therefore, very easy to conserve: just wipe down with a damp cloth soaked in a household cleaning product that does not contain solvents or any highly aggressive cleaning agents, such as scouring powder. Wax (or silicone) must also not be used, because when applied to the surface of the laminate, it forms a greasy film that makes it difficult to clean and spoils its appearance. Do not use thinner, turpentine or kerosene for removing glue residues. Use Formiline Solvent.

How to manipulate the CPL Support

1- Unwrap the bobbin.
2- Run the axle of the support through the bobbin tube.
3- Remove the auxiliary bar.
4- Position the bar on the axle.
5- Fit the axle into the CPL support.
6- Lower the cutting guide.
7- Insert the Formiline into the cutting guide.
8- Slide the cutter down to the end of the table using the cutting guide.