

# Product & Technical Information



## GATOR-PLY® GATOR-PLY® HP GATOR-FLEX®

The original, specialty engineered wood-fiber veneers to back your business

### PRODUCT OVERVIEW

GATOR-PLY®, LUXCELL®, and SYN-PLY® comprise three unique product lines of specialty engineered, man-made wood-fiber veneers manufactured by 3A Composites USA. LUXCELL, the facer that can be painted or printed, is described in its own Product and Technical Information bulletin. SYN-PLY, the synthetic crossband material, is used specifically in five-ply composite construction and is described in its own Product and Technical Information bulletin.

**GATOR-PLY backers** have been used for more than 45 years to simplify the manufacturing process, improve furniture products, and cut manufacturing costs. Special cuts allow for less waste and greater yields with less labor costs. GATOR-PLY helps to prevent warping, provides a smooth, uniform appearance, has no splices or seams, and maintains high quality in your furniture application.

GATOR-PLY backers are low formaldehyde, specialty engineered wood-fiber veneers. They are impregnated with a proprietary resin system and possess certain characteristics that allow for successful use as a balancing medium in both three-ply and five-ply panel constructions. Although many panel producers attest to GATOR-PLY's effectiveness, it must be recognized that it is an impregnated product with its own special characteristics that are not the same as those of wood veneer or high-pressure laminate. GATOR-PLY is not to be used as a substitute for crossband material. GATOR-PLY can be used with either hot or cold press lamination operations. Testing has revealed no undersirable features with GATOR-PLY; however, caution should be observed when using particleboard and medium-density fiberboard cores of less than 5/8" thickness.

There are several GATOR-PLY product lines that have been developed to meet certain performance and environmental specifications:

**GATOR-PLY GREEN GATOR-BACKER™** is manufactured with an alternative resin system™ with no VOC or added formaldehyde. It is a GREENGUARD Gold Certified product for improved indoor air quality.

**GATOR-FLEX™** is a flexible synthetic backer designed for increased tensile and internal bond strength for use in two-ply veneer constructions. Flexible yet strong, it can be used in curved or flat applications and offers outstanding handling characteristics as well as enhanced tensile strength that results in ease of use, less breakage and superior performance. GATOR-FLEX is eco-friendly, produced with a No Added Formaldehyde (NAF) resin system and achieving GREENGUARD Gold Certification.

**NEW! GATOR-PLY HP** are high performance, wood-fiber veneer backers developed for improved overall performance and a low Water Vapor Transmissions Rate (WVTR). The sealed surface of GATOR-PLY HP backers provide enhanced product handling when used to back both HPL and finished wood veneer in three-ply and five-ply panel constructions. GATOR-PLY HP has achieved GREENGUARD Gold Certification.

### ADDITIONAL PRODUCT INFORMATION

- Product dimensional changes for rigid backer are equal to or less than 1% of gross dimension in both directions
- Density of products is 40 lbs per msf +/- 10%
- Weight per msf:
  - .016" thickness = 56.0 +/- 7.0 lbs/msf
  - .019" thickness = 66.5 +/- 6.5 lbs/msf
  - .020" thickness = 66.5 +/- 6.5 lbs/msf
  - .024" thickness = 86.0 +/- 7.0 lbs/msf
  - .026" thickness = 86.0 +/- 8.0 lbs/msf
  - .034" thickness = 104.0 +/- 7.0 lbs/msf
- GATOR-PLY may be requested with a grain orientation. Grain orientation is usually the long dimension of the sheet and is always denoted by the second dimension in the sheet size.  
Example: 48" x 96" = 96" is the grain direction.
- GATOR-PLY has a Class A Flame Spread rating
- GATOR-PLY products are available as FSC®-Certified on request (FSC-C074317)



NOVEMBER 2022

# Product & Technical Information



## GATOR-PLY® GATOR-PLY® HP GATOR-FLEX®

### PRODUCT AVAILABILITY

SKU #	Gauge	Color	Application	Standard Sizes
GATOR-PLY GREEN GATOR - 30419	.019" (.48mm) +/- .002"	Black	Hot / Cold	<b>Widths:</b> 31", 37", 49", 61", 98" <b>Lengths:</b> 50", 62", 97", 121", 145" Custom sizes available
GATOR-PLY GREEN GATOR - 30425	.019" (.48mm) +/- .002"	Brown	Hot / Cold	
GATOR-PLY - 30404	.020" (.50mm) +/- .002"	Black	Hot / Cold	
GATOR-PLY HP - 30404-HP	.020" (.50mm) +/- .002"	Black	Hot / Cold	
GATOR-PLY - 30405	.020" (.50mm) +/- .002"	Dark Brown	Hot / Cold	
GATOR-PLY HP - 30405-HP	.020" (.50mm) +/- .002"	Dark Brown	Hot / Cold	
GATOR-PLY - 30408	.020" (.50mm) +/- .002"	Tan	Hot / Cold	
GATOR-PLY GREEN GATOR - 30619	.024" (.60mm) +/- .002"	Black	Hot / Cold	
GATOR-PLY - 30105	.026" (.66mm) +/- .002"	Dark Brown	Hot / Cold	
GATOR-PLY HP - 30105-HP	.026" (.66mm) +/- .002"	Dark Brown	Hot / Cold	
GATOR-PLY - 30604	.026" (.66mm) +/- .002"	Black	Hot / Cold	
GATOR-PLY HP - 30604-HP	.026" (.66mm) +/- .002"	Black	Hot / Cold	
<b>NEW!</b> GATOR-PLY - 30204	.034" (.86mm) +/- .002"	Black	Hot / Cold	
<b>NEW!</b> GATOR-PLY HP - 30204-HP	.034" (.86mm) +/- .002"	Black	Hot / Cold	
<b>NEW!</b> GATOR-PLY - 30205	.034" (.86mm) +/- .002"	Dark Brown	Hot / Cold	
<b>NEW!</b> GATOR-PLY HP - 30205-HP	.034" (.86mm) +/- .002"	Dark Brown	Hot / Cold	
GATOR-FLEX - 30418	.016" (.40mm) +/- .002"	Tan	Hot / Cold	<b>Widths:</b> 49", 61" <b>Lengths:</b> 97", 121", 145" Custom sizes available
GATOR-FLEX - 11218	.017" (.45mm) +/- .002"	White	Hot / Cold	
GATOR-FLEX - 30618	.021" (.53mm) +/- .002"	Tan	Hot / Cold	

### USAGE INSTRUCTIONS

GATOR-PLY backers are convenient to use because they accommodate all normal lay-up, trimming and shaping operations commonly practiced in the furniture/cabinet industry. GATOR-PLY backers are **not** to be used as a substitute for crossband material used in five-ply panel applications.

GATOR-PLY works with either particleboard or medium-density fiberboard (MDF). For best results, core material should be thicker than 5/8".

### STORAGE

Ideally, GATOR-PLY should be stored in the same area as the cores and facers to allow each to reach equilibrium at the same relative humidity. This tends to minimize differences in expansion and contraction characteristics between panel components once they are combined. Storage areas should not have excessive temperatures (in either direction) or moisture. All GATOR-PLY products have an unlimited shelf life, but like all veneer type products, control of the above mentioned conditions is critical.

# Product & Technical Information



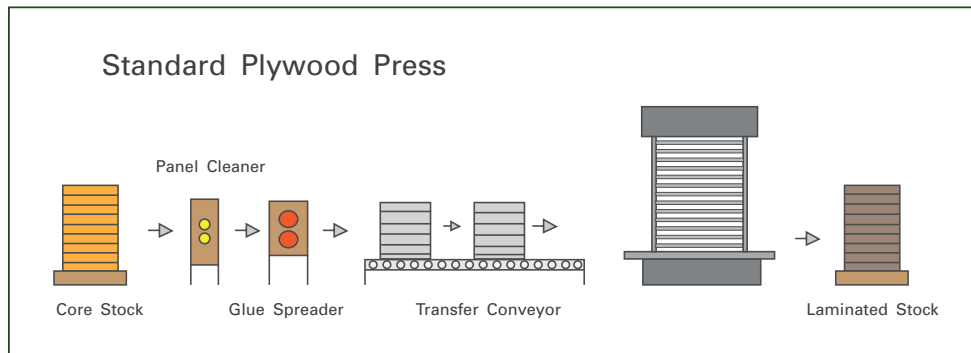
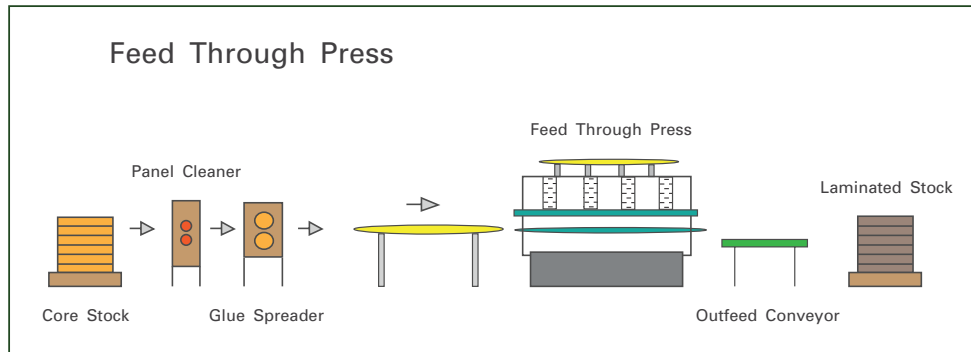
## GATOR-PLY® GATOR-PLY® HP GATOR-FLEX®

### LAMINATION

GATOR-PLY may be used with normal adhesives such as Urea Formaldehyde and PVA. For the best lamination results, adhesive should be laid down uniformly on each side of the core material. When working with GATOR-PLY HP, it is important to keep the coated side of the sheet facing out and away from the core material. We recommend the following parameters for maximum results:

#### HOT PRESS PARAMETERS

Solids:	U.F. 60-65% / PVA 45-55%
Glue Spread:	22 - 35 lbs/MSF/side
Lay-Up or Assembly Time:	5 - 45 minutes (adhesive dependent)
Stacking:	Face-to-face stacking is preferred but not always necessary
Press Temperature:	U.F. - 270° F short cycle; 240° F long cycle PVA - 240° F short cycle; 220° F long cycle
Press Pressure:	100 - 125 psi.
Press Time:	3/4 - 1 minute short cycle; 1-1/2 - 3 minutes long cycle
Cure Time:	24 hour minimum before finishing



The above recommendations were developed based on proven applications. There may be some cases where the recommendations do not apply.

# Product & Technical Information



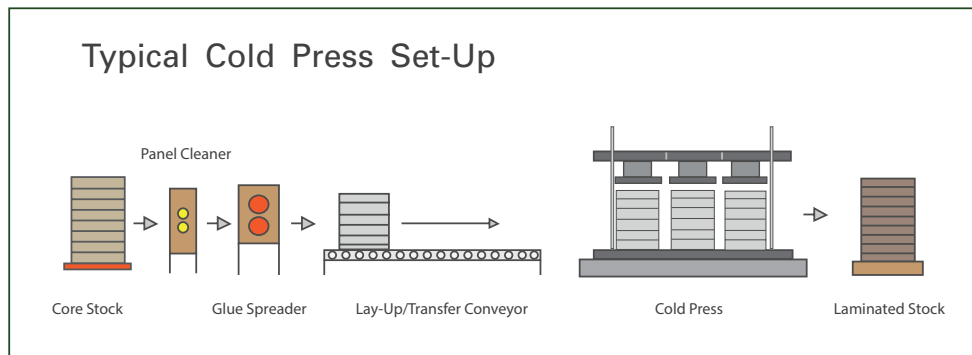
## GATOR-PLY® GATOR-PLY® HP GATOR-FLEX®

### LAMINATION

GATOR-PLY may be used with normal adhesives such as Urea Formaldehyde and PVA. For the best lamination results, adhesive should be laid down uniformly on each side of the core material. When working with GATOR-PLY HP, it is important to keep the coated side of the sheet facing out and away from the core material. We recommend the following parameters for maximum results:

#### COLD PRESS PARAMETERS

Solids:	45% minimum
Glue Spread:	22 - 30 lbs/MSF/side
Lay-Up or Assembly Time:	5 - 20 minutes (adhesive dependent)
Stacking:	Face-to-face stacking is preferred but not always necessary
Press Pressure:	25 - 150 psi. depending on components
Press Time:	30 minute minimum (adhesive dependent)
Cure Time:	24 hour minimum before machining



The above recommendations were developed based on proven applications. There may be some cases where the recommendations do not apply.

### TRIMMING AND SHAPING

GATOR-PLY backers are engineered to provide cleanly shaped edges on adequately cured cold- or hot-pressed panels; if trimmed edges should result in fuzz, the condition may be caused by:

- Inadequate glue-line cure time. Excess moisture from non-dried glue accumulated near the panel edges may temporarily soften the edges of GATOR-PLY preventing a clean blade cut.
- Dull trimming or shaping tools. Where saws or tool heads are excessively worn down, nothing can prevent chipping or fuzz on surface materials.
- "Oscillating" tools or "out of true" saws also contribute to uneven edges regardless of tool sharpness.

### BACKING PROPERTIES AND PANEL STABILITY

Industry experience indicates that two of the most important properties needed in a backing sheet are:

1. Mechanical tensile strength to help stabilize core stock in a multi-ply panel
2. Impedance of rapid moisture-level transmission to enable all panel components to reach equilibrium slowly, thus minimizing warping and cupping in the field.

# Product & Technical Information

---



## **GATOR-PLY® GATOR-PLY® HP GATOR-FLEX®**

For more details about our full line of GATOR-PLY backers, call 800-626-3365 (select "1" for customer service) to request printed product literature; or visit our website at [www.gatorply.com](http://www.gatorply.com) to view and/or download all available literature.

**3A Composites USA  
721 Jetton Street, Suite 325  
Davidson, NC 28036  
800.626.3365**

### LIMITED WARRANTY

Disclaimer of implied warranties and limitation of remedies: Except where seller has provided a written limited warranty for its product(s) seller warrants only that at the time of shipment the goods sold hereunder will be as described in the order. Seller makes no other warranties of any kind, express or implied, including without limitation, any implied warranty of merchantability or fitness for a particular purpose. Seller shall have no liability of any incidental or consequential damages. The sole and exclusive remedy provided by seller on account of any warranties or claims of any kind shall be limited to the replacement of the goods in question or at the seller's option, a credit to buyer of the purchase price paid. No person is authorized to make any representation of warranty on behalf of seller except as expressly set forth above and any such statement shall not be binding on seller.