

# Iron-On Veneering With BetterBond Heat Lock™

Required Items: - Veneer  
- Heat Lock™ adhesive  
- Paint brush, foam roller, or glue roller

Optional Items: - Masking tape  
- Scissors

Heat Lock™ is a superb adhesive that takes only a small amount of practice to master. It's best to experiment with veneer scraps before tackling your first project.

## Preparing the Substrate

Make sure the substrate (the area you want to veneer) is clean and lightly scuffed with 100 grit sandpaper. Heat Lock™ will work with a variety of substrate materials such as wood, plywood, MDF and particle board.

## Applying Heat Lock™

If you are using a straight-grained wood, it's a good idea to "dry iron" the veneer before applying the adhesive. This will pre-shrink the veneer to minimize any splitting.

Heat Lock™ can be applied with a paint brush, foam roller, or glue roller. Two or more coats of adhesive may need to be applied to the substrate if you use a paint brush or foam roller. However, a glue roller has the tendency to apply the adhesive a bit thicker (approx. 9/1000") and, therefore, is the ideal choice. Unlike contact cement, Heat Lock™ disperses no volatile organic compounds so it can be applied indoors.

Start by applying the adhesive in a zigzag pattern to the surface of the substrate. Be sure to cover the entire surface evenly. If the adhesive drips over the edges, it can be cleaned up (while wet) with a damp rag.

Next, apply the adhesive to the veneer in the same manner as the substrate. The best method is to cut the veneer slightly oversized and tape the edges down to a scrap board. This will prevent the glue from getting on the veneer face during application. If the adhesive gets on the face of the veneer, a clean finish will be difficult.

The surface of the substrate and veneer should appear evenly covered after drying. To achieve this, a second coat of adhesive on the veneer is frequently necessary.

## Clean Up

The uncured adhesive will clean up with warm water. Rinse off the roller or brush immediately after use. The adhesive begins drying quickly, so do this now while the veneer and substrate are setting up.

## Bonding the Veneer

When the glue on the veneer and substrate has dried, turn the clothes iron on and set it to medium/high. Allow a minute or two for the iron to heat up. Now is a good time to use scissors or a razor knife to trim off the edges where the veneer was taped over.

Place an old cotton or flannel shirt over the veneer face and begin ironing from the center. Work toward the edges while applying even downward pressure. Give the entire veneer area ample time to heat up, reactivate, and bond. Be sure to keep the iron moving at all times. If the veneer is wavy, buckled or high in moisture, a spritz of veneer softener on the surface will give it some flexibility.

Allow an additional 1 to 3 hours for full bond strength.

## Inspection

After the veneer has cooled off, check the surface for any areas that feel uneven. You can re-heat any areas that did not properly bond. These are areas where the glue was not fully heated.

Lastly, check the edges of the veneer for loosening. Moderate upward pressure with your fingernail should not lift the edges. If it does, re-heat the veneer and check it again.

Don't forget to turn off the clothes iron when you are finished!

## Finishing the Veneer

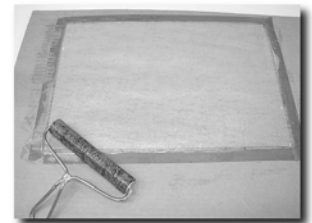
Lightly sand the completed panel. Do this carefully to avoid sanding through the veneer face. It's best to let the adhesive fully harden before staining/finishing the veneered surface. Since Heat Lock™ cures to a rigid glue line, practically any stain or finish can be applied.



Glue applied to substrate



Application of glue to veneer



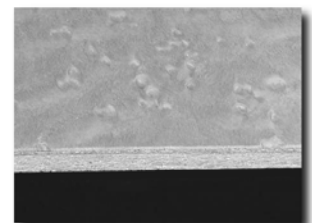
Glue drying on veneer



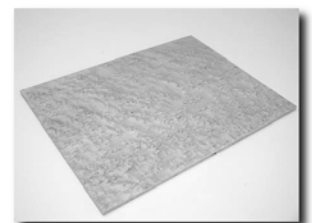
Cut off the veneer edges



Iron the veneer face



Check for a good bond



Finish the panel