

CENTURY TILE

LAMINATE FLOORING It's all in the Layers.

Step 1: Stacking

The process begins with the assembly of the 4 layers of raw materials in large sheets.

This typically takes place on a production line, where modern technology enables each layer to be stacked on top of one another with incredible accuracy and precision.

How precise? Most manufacturers use sophisticated electronic calibrating equipment and digital camera systems to keep the sheets in perfect alignment.

The backing layer is first on the line, with the core board placed directly on top of that.

Next, the printed decorative layer is stacked on top of the core board. The final layer to be stacked on is the wear layer.

Step 2: Pressing

Once the 4 layers have been stacked, they are ready for pressing.

The presses used to create laminate flooring have hydraulic rams that apply tremendous pressure to the stacks.

The stacks of layers are pressed at high temperatures reaching 400 degrees Fahrenheit, with up to 600 pounds per square inch of pressure for 20 to 30 seconds.

Manufacturers carefully monitor the time and temperature when pressing the layers to successfully cure and bond the stacks into a single sheet of finished decorative laminate.

If the laminate that is being manufactured is designed to have a textured surface, the press has specialized plates that imprint the textured pattern onto the sheets, creating more natural looking planks or tiles.

Step 3: Cooling off

After the sheets are pressed, they are left to cool to ensure that they fully cure and to prevent any surface imperfections.

Then the sheets are stacked and stored for a time so that they can continue to acclimate, thereby enhancing the stability of the boards.

Step 4: Cutting, milling and profiling

Once the boards are fully acclimated, they are milled, or cut into planks.

The freshly cut planks then move on to be profiled. Multiple profiling saws create the tongue and groove edges on the sides of the planks that enable the floor to lock together with ease.

The blades on the profiling saws use electronic and laser systems that produce incredibly accurate edges for a perfect fit—further assurance of the precision of your floor.

The finished planks then go through a quality inspection and are checked for color, texture, finish, size and correct interlocking capabilities.

Once approved, the planks are stacked, packaged and loaded onto trucks for distribution to Century Tile, where we will help you select the perfect laminate floor you—one that you'll love for many, many years to come.