

Dear Valued Customer,

As the cooler mornings are now with us again, we would like to take the opportunity to remind our customers that it may be necessary to adjust edgebander settings and factory conditions to allow for the colder conditions and ensure the best possible edgebanding results.

Colder air temperature along with colder board and edging surfaces create more challenging conditions for hotmelt adhesives to do their job.

We would like to offer some suggestions which might assist in achieving optimum bonding during the winter months.

- **Edgebanding Machines:** always refer to recommended settings from your machine supplier. Generally speaking in colder conditions, hotmelt adhesives will perform better when operating at a slightly higher temperature (provided the adhesive is also suitable for that temperature).
 - **Glue Pot:** the actual glue temperature within the glue pot should be checked periodically using an independent temperature probe, to ensure the temperature gauge reading is correct.
 - **Machine Location:** avoid the possibility of cold breezes flowing onto the machine (near open doors etc) as this can have a negative effect on the performance of the adhesive.
- **Hotmelt Adhesives:** always refer to the Technical Data Sheets and recommendations made by your Adhesive supplier and use a Hotmelt adhesive suitable for your machine. Operating temperatures are generally relative to the machine speed, so please also refer to this information on the TDS for your Adhesive.
- **Edgebanding:** rolls should ideally be stored in closed cabinets or at least off cold concrete floors. The edgebanding rolls should ideally be warmed prior to application to promote optimum bond. This is generally achieved by hot air, heated fence or heat lamps near the infeed on the machine.

If possible and practical, schedule edgebanding processing for later in the day when temperatures have generally increased.

Should you have any questions or problems with edgebanding or adhesion, please do not hesitate to contact your Surteco Area Sales Manager who will be happy to assist.

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Edgebanding Trouble Shooting Guide

The following information suggests possible causes and solutions to some of the general edgebanding problems that may occur during processing.

Issue	Trouble-shooting Suggestions
<p>The edging can be easily removed by hand. Adhesive transfers to the board face but not to the edging surface. The grid pattern from the adhesive application roll is visible.</p>	<p>Room temperature may be too low or there may be a draught in the zone between the application of adhesive and contact pressure roll. Edging material may be too cold. Glue-pot temperature may be too cold. Rate of feed is too slow for type of adhesive. Not enough contact pressure of application / spreader roll. Action: Check ambient temperature, board, edging and glue-pot. Check feed speed is suitable for adhesive being used. If not, opt for higher grade adhesive - check with your Surteco Area Sales Manager for recommended type and range.</p>
<p>The edging can be easily pulled off by hand. Adhesive remains on the board. Surface of adhesive is completely smooth (no grid pattern).</p>	<p>Board and/or edging was too cold during application. Primer may be at fault or incorrect type used. Action: Check temperature of board, edging and air. Board and edging should ideally be around room temperature. Check with your Surteco Area Sales Manager for edging/adhesive recommendations.</p>
<p>Edging can be pulled off by hand. Majority of adhesive remains on the edging, lesser amount on the board.</p>	<p>Board material may be retaining too much residual heat (e.g. after the preceding veneering / lamination press). Adhesive may be running too hot thus lowering viscosity & allowing the adhesive to 'soak' into board edge. Adhesive may be incorrect grade for machine/speed. Action: Reduce adhesive temperature in pot (and roller if separate control). Consider higher heat resistant hotmelt adhesive (consult TDS or with Surteco for technical assistance).</p>
<p>No bonding of edging at the front end of the board or the edging has splintered off a few millimetres in the front.</p>	<p>Adhesive application/spreader roll is protruding too far into the line of board. No adhesive applied at the leading edge of board due to strong springback of the roll at the front edging of board. Action: Adjust roller alignment and other associated settings.</p>
<p>Milling furrows visible.</p>	<p>Feed rate too low. Cutting speed too low. Scrapers are taking too much off. Action: Rework with scrapers and/or buffers. Re-adjust trimmers and back off scrapers.</p>
<p>The Colour tone at the milling area is slightly lighter in the case of thick edgebands (stress-whitening).</p>	<p>Cutting speed too low. Cutters blunt or caked with residue build-up. Edging too cold. Action: Increase speed, heat and/or remove residue.</p>

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Note: Stress Whitening is a characteristic of thermoplastic edgings (ABS, PVC etc). Natural colour is quickly regained by presence of heat.

Action:

Add hot air stations.

Add on-line buffing or secondary processing off-line.

The information contained herein is offered in good faith and is intended as a general guide only. Please consult your machinery supplier and/or Surteco for specific Technical Support.

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