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Processing Information For Veneer Edgebands Roll & Strip Format

1. What is Veneer Edgebanding

Wood Veneer edge bands traditional single-layer and thick multilayer, offering great suitability for the economic application to high quality veneer boards. Offering a perfect finish to beautifully designed furniture and workpieces.

2. Veneer Edgeband Options

Automatic edgebanding

Defines the standard and is classic among veneer edges. Single layer processed with a nominal thickness of 0.6mm front side fine sanded, backside available pre glued with hot melt or fleece backed. Supplied in coils of 50, 100 or 200Mtrs

Thick edgebanding Rolls

Multiple layers of thick veneer ranging from 1.0 to 5.0mm's in thickness, front side sanded with a fine grit of 150/180 and the backside calibrated with a 40 grit for better adhesion. Supplied in coils of 100 or 200Mtrs

Thick edgebanding Strips

Multiple layers of thick veneer ranging from 1.0 to 25.0mm's in thickness, front side sanded with a fine grit of 150/180 and the backside calibrated with a 40 grit for better adhesion. Standard Strip length 3.10mm

Multiplex edgebanding Rolls

Beech or Birch veneer single layer or multiple layers are faced with a decorative multiplex top layer. Available in thickness from 0.6 – 3.0mm. Supplied in coils of 100 or 200Mtrs

Multiplex edgebanding Strips

Made to order offering virtually unlimited design possibilities. The combination and arrangement of two different veneer types / colours creates individualized designs and effects. The multiplex effect appears through the entire edge thickness. Thicknesses begining at 1.5mm and the standard length is 3.10mtrs.

Baz edgebanding

Baz edgebanding is comparable to thick veneer edgebanding rolls, however this has been specially developed to enable trouble free veneer edge processing on Baz machines. Supplied with residual wood moisture of 10 – 12% Baz edgebanding inhibits optimal processing parameters for modern processing centres.

3. Applications for Veneer Edgebands

There is an almost unlimited range of applications for Veneer edgebands - from kitchen, bedroom and office furniture to exhibition stand and shop fitting, general living areas and general interior design. The material formulation of veneer edge band, which is particularly suitable for machining and processing, means that it can be used in straight processing, as well as curved furniture items, on both internal and external radii, providing the correct thickness of material is chosen.

4. Veneer Edgebands

All our veneer edgebanding is calibrated with a 40 grit on the backside for better adhesion and sanded with a 150/180 grit on the front. Upon request we lacquer to match colour and gloss samples. Custom widths are also available on request.

5. Working with the Veneer edgebands

Veneer edgebands can be processed on all edgeband gluing machines (straight-processing and CNC machining centres) using hot melt adhesive techniques. Gluing, cross-cutting, milling and scraping can all easily be done to achieve the desired surface finish without any problems. To ensure a clean and permanently robust application of the edgeband, some major processing parameters must be adhered to, these being partly dependent on the materials used (edgebands, glue, boards/panels), the edgeband gluing machine and the ambient temperature. It is therefore recommended that trials be undertaken to determine the relevant optimum settings in each case. The guidelines issued by the manufacturers for the intended application in question should also be followed.

Suitable adhesives:

Veneer edgebands can be processed using any standard hot melt adhesives (EVA, PA, APAO, PUR).

Working temperature:

For best results when applying edgebands, boards or panels and the edgebands should be processed at room temperature (not below 18 °C). If the materials have been stored outdoors, they should be warmed up over night. If the boards or edgebands are too cold, the hot melt adhesive will set before the edgeband is applied to the board. For this reason draughts should also be avoided.

Wood moisture:

For processing, optimum wood moisture in the boards is between 7 and 10 %.

Feed rate:

The particular material formulation of venner edgebands is designed for feed rates both in low volume processing and in major manufacturing situations. Should an edge banding machine not offer the required feed speed, then it is possible to purchase primed veneer this will offer the necessary adhesion as an alternative.

Rates of glue application:

Please follow the adhesive manufacturer's instructions. The adhesive should be applied evenly and in sufficiently small quantities so that no beads of adhesive get pressed out from the edges of the freshly glued edgebands, and that any gaps in the wood of the boards or panels are filled. The amount of glue required depends on the density of the chipboard and the type of adhesive.

Milling:

For flush milling the general cutting speeds for woodworking apply.

Buffing / Sanding:

Veneer edges receive a standard finish with 150/180 grit. During the gluing process sanding the second time at the edgebanding machine is recommended to remove any possible marks on the edge surface.

Veneering after edgebanding

With Subsequent veneering after the edgebanding process, ensure that the moisture balance is achieved between the panel material and the edgebanding before flush milling. This ensures a close and tight edge.

Varnishing

Veneer edgebands can easily be varnished, stained or lacquered in the colour of your choice.

6. Storage

We pack standard veneer edges with residual wood moisture of approximately 10% or special edgebanding material (Baz application) with approximately 12%.

The packaging protects against moisture exchange and the influence of weather. Additionally we recommend storing in an enclosed environment or room with a relative humidity of 65 – 70%. Over dried veneer edges are very difficult to re-moisten and are difficult to process – especially for BAZ applications.

7. Disposal

Veneer edgeband remnants can be incinerated with other wood shavings in authorised plants.

8. Trouble-shooting: Tips and information for problems encountered in processing

Problem	Problem diagnosis and suggested solutions
1. Edgeband can be easily pulled away by hand. Hot melt adhesive remains on the chipboard. The grid pattern of the gluing roller is visible.	<ul style="list-style-type: none"> • Not enough glue applied • Room temperature too low • Edgeband material too cold (stored outdoors) • Hot melt adhesive temperature too low • Feed rate too low • Pressure exerted by the press rollers too low
2. Edgeband can be easily pulled away by hand. Hot melt adhesive remains on the chipboard. Hot melt adhesive surface smooth all over (edgeband slips off).	<ul style="list-style-type: none"> • Board and/or edgeband too cold -> Check hot melt adhesive type -> Check application of bonding agent
3a. Edgeband can be pulled away by hand. Hot melt adhesive remains on the edgeband for the most part.	<ul style="list-style-type: none"> • Temperature of the board material too high as a result of previous processing steps (e.g. veneering)
3b. Glue seam is not closed (edgeband gluing machine)	<ul style="list-style-type: none"> • Pressure exerted too low • Adhesive too cold -> Increase application temperature or preheat board or increase feed rate • Edgebands either have no pretensioning or pretensioning is askew
3c. Glue seam is not closed (machining centre)	<ul style="list-style-type: none"> • Pressure exerted is too low • Edgeband was fed in too cold and cannot be squeezed. • Restoring forces of edgeband material too high -> Increase heater power or reduce feed rate -> Increase geometry or use a thinner edgeband material • Material not suitable for use on machining centres – adhesion under heat too low • Adhesive does not set quickly enough -> Reduce adhesive application temperature
3d. Edgebands are only bonded at the edges	<ul style="list-style-type: none"> • Pressure exerted too low • Milled seam at the join on the board has gaps • Pretensioning of edgebands too high
4. Inadequate bonding of the glued edgeband at the front edge of the board, or the edgeband is split at the front edge.	<ul style="list-style-type: none"> • Not enough adhesive applied due to gluing roller being incorrectly laid out -> Increase adhesive application quantity
5. Milling marks are visible.	<ul style="list-style-type: none"> • Feed rate too high • Cutting speed of the cutters too low -> Post-process with scrapers and buffing -> Conventional milling -> Increase number of cutters on router -> Increase r.p.m.