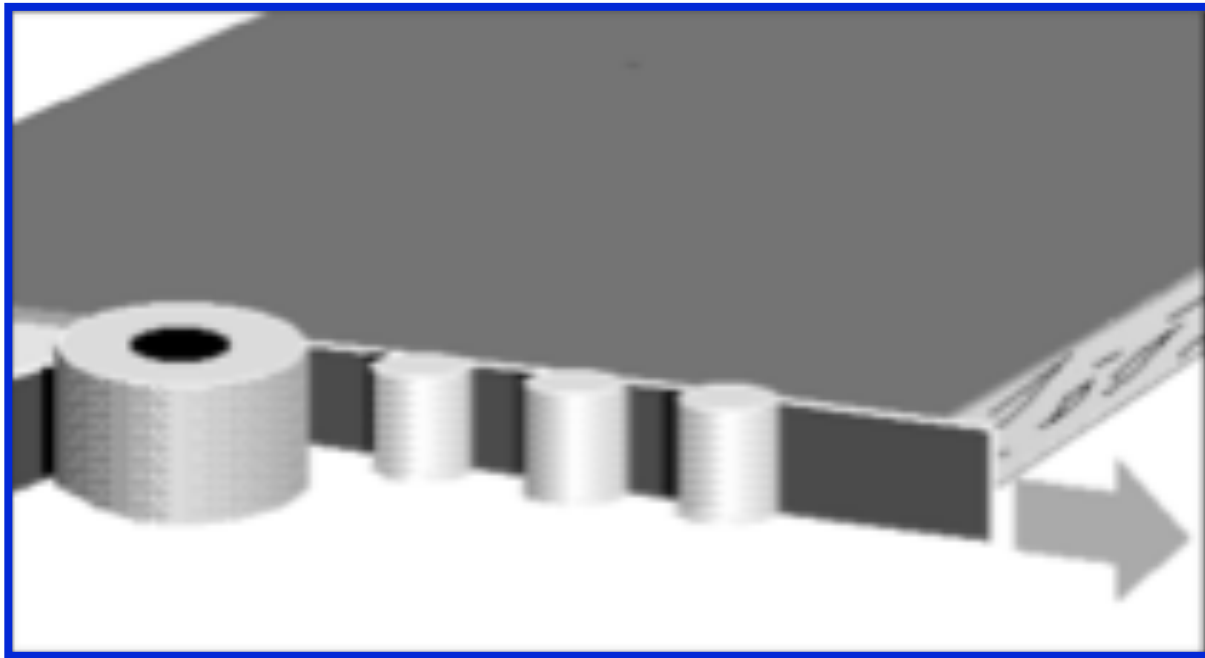


# Edgebanding Technical Training

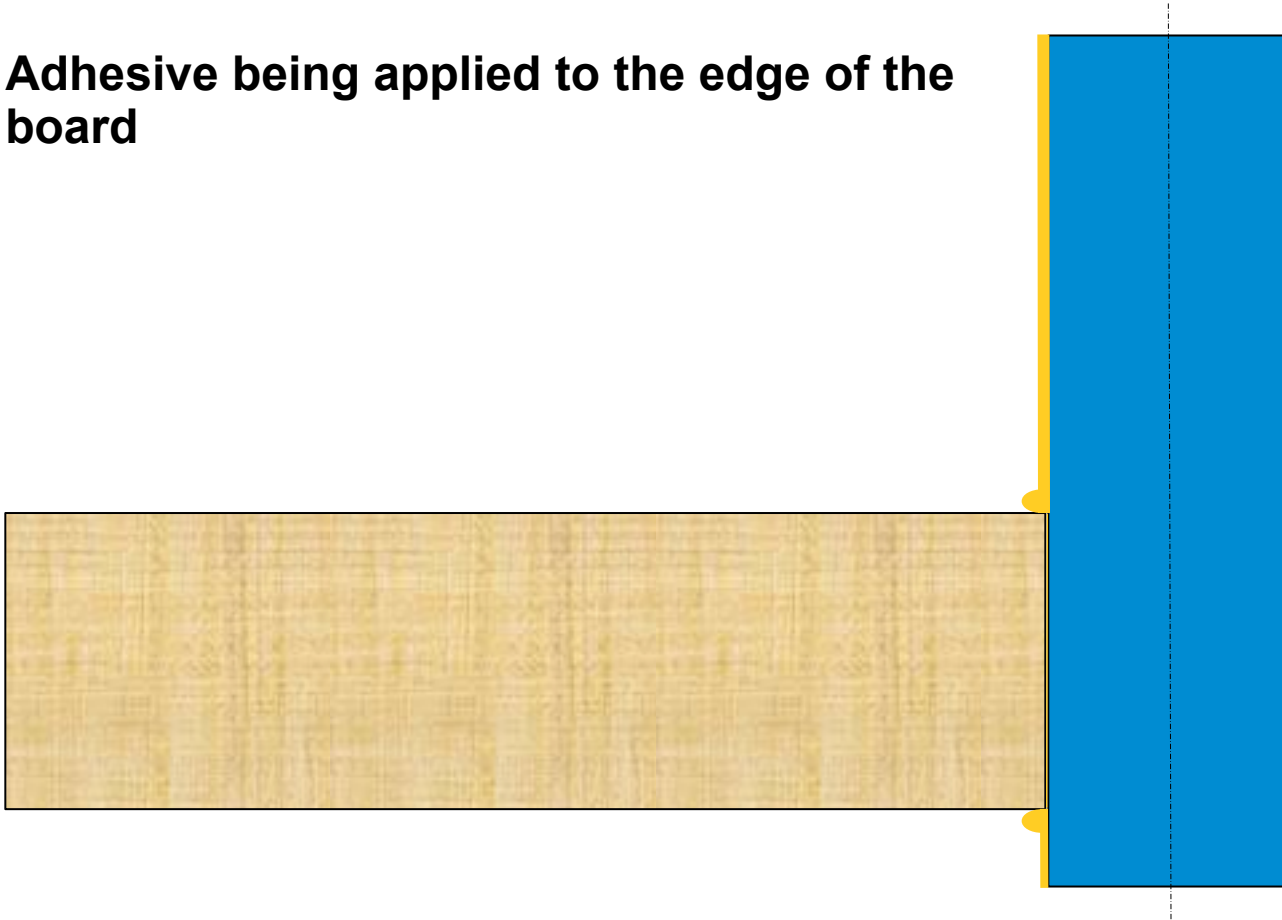


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# Edge Banding

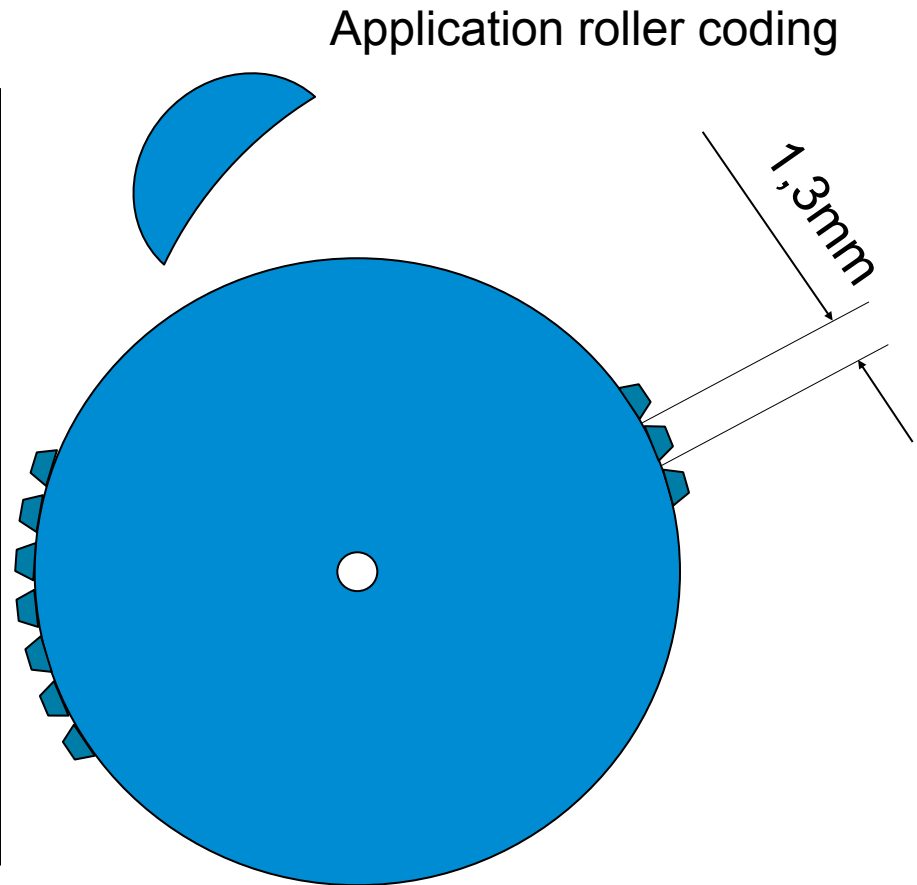
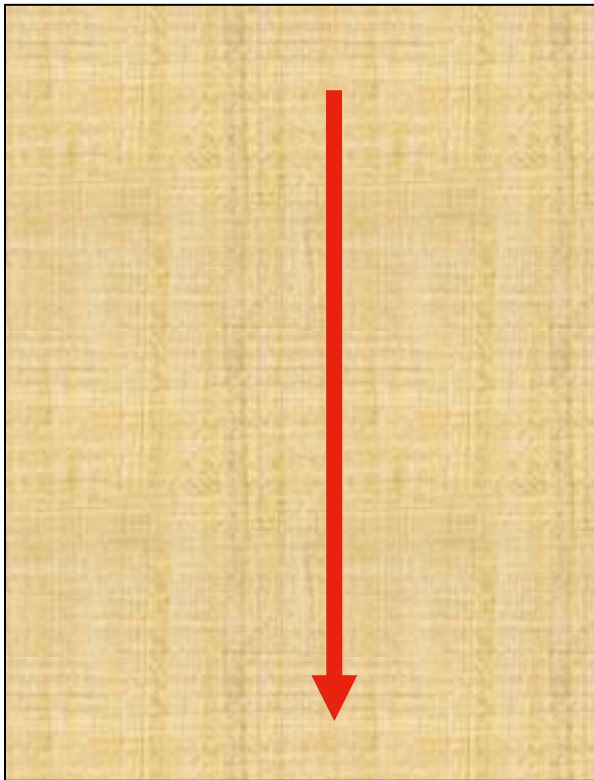
## Roller Coater

Adhesive being applied to the edge of the board



# Edge Banding

Roller Coater - coding



# Edge Banding

## Roller Coater – guide plate setting

Set the guide plate so that the roller is 0,1 – 0,2mm from the board edge

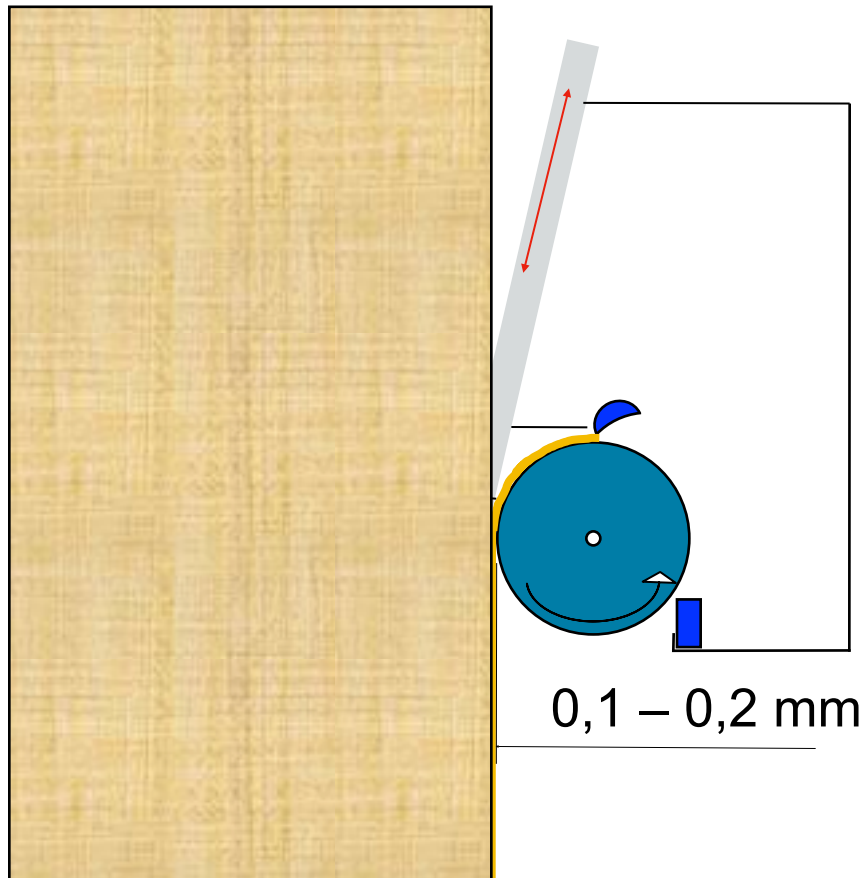
### Benefits:

- Even adhesive coating on the edging
- Improved adhesive wetting out on the edging
- Improved bond line
- Higher bond strength
- Reduced fibre contamination on the roller coater
- Reduced contamination in the glue pot
- Reduced damage to the board edge
- Increased heat resistance
- Increased water resistance



# Edge Banding

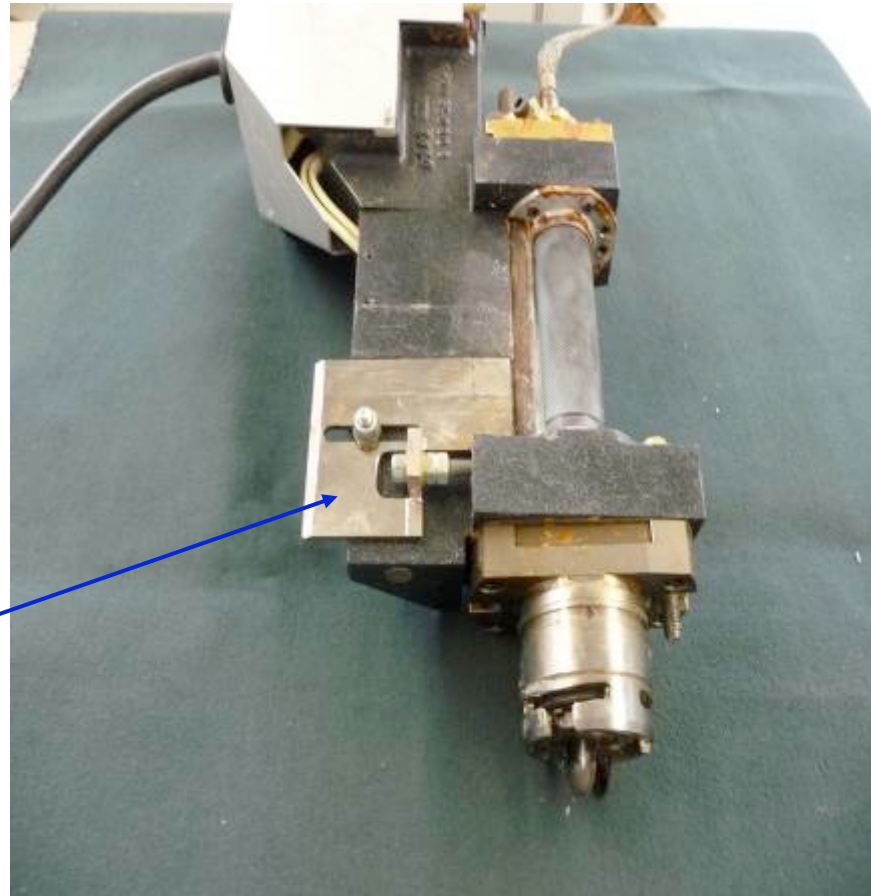
## Roller Coater – guide plate setting



Guide plate setting on the application roller

# Edge Banding

Roller Coater – guide plate setting

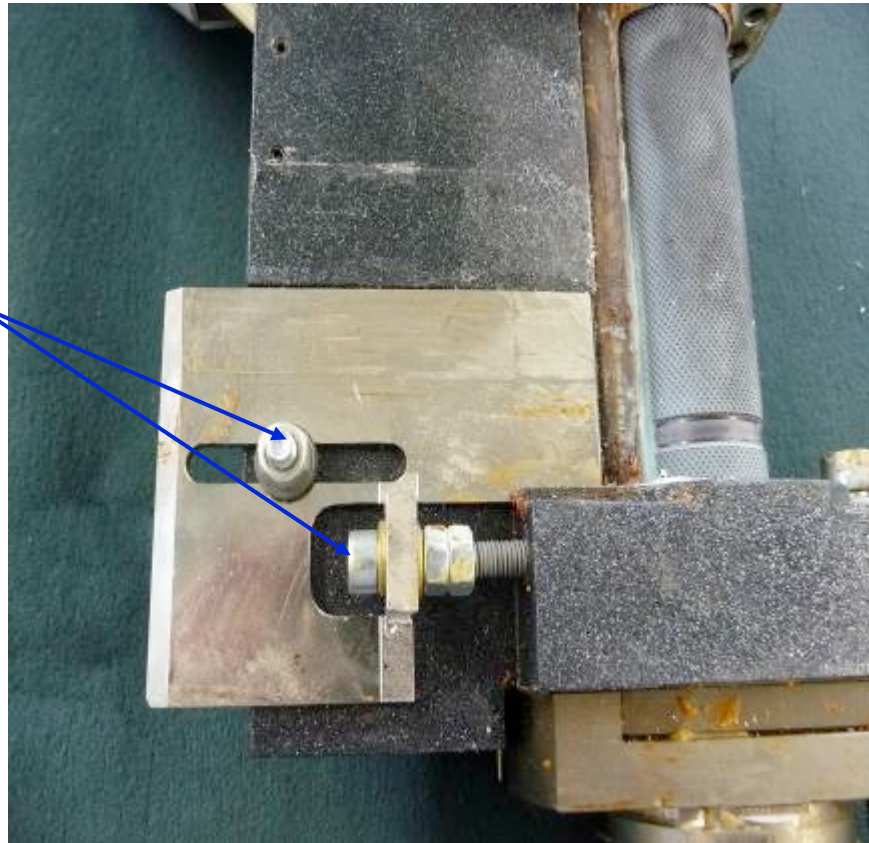


Guide Plate

# Edge Banding

## Roller Coater – guide plate setting

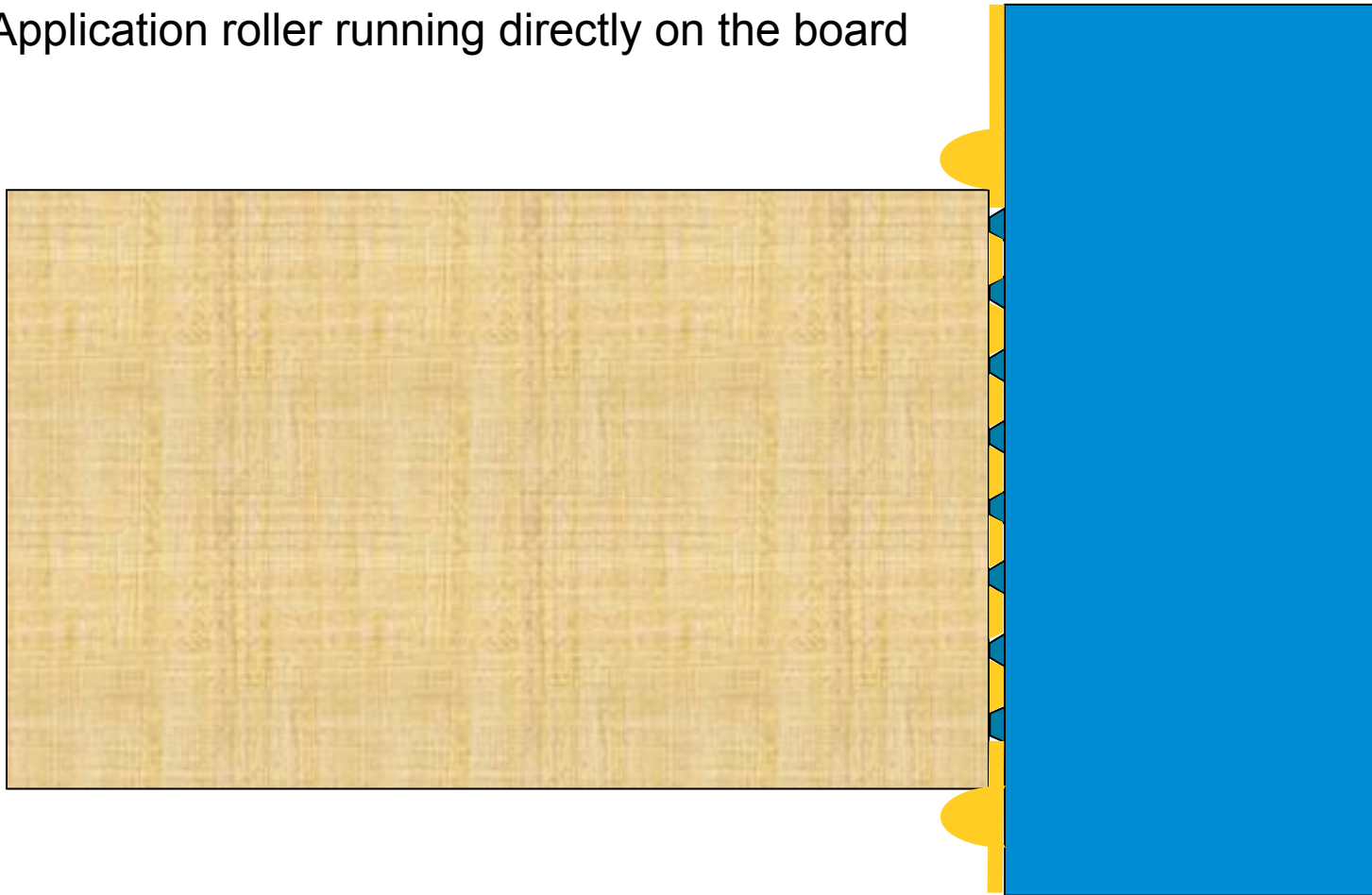
Guide plate  
adjustment  
screws



# Edge Banding

## Roller Coater – guide plate setting

Application roller running directly on the board





# Edge Banding

## Roller Coater – guide plate setting

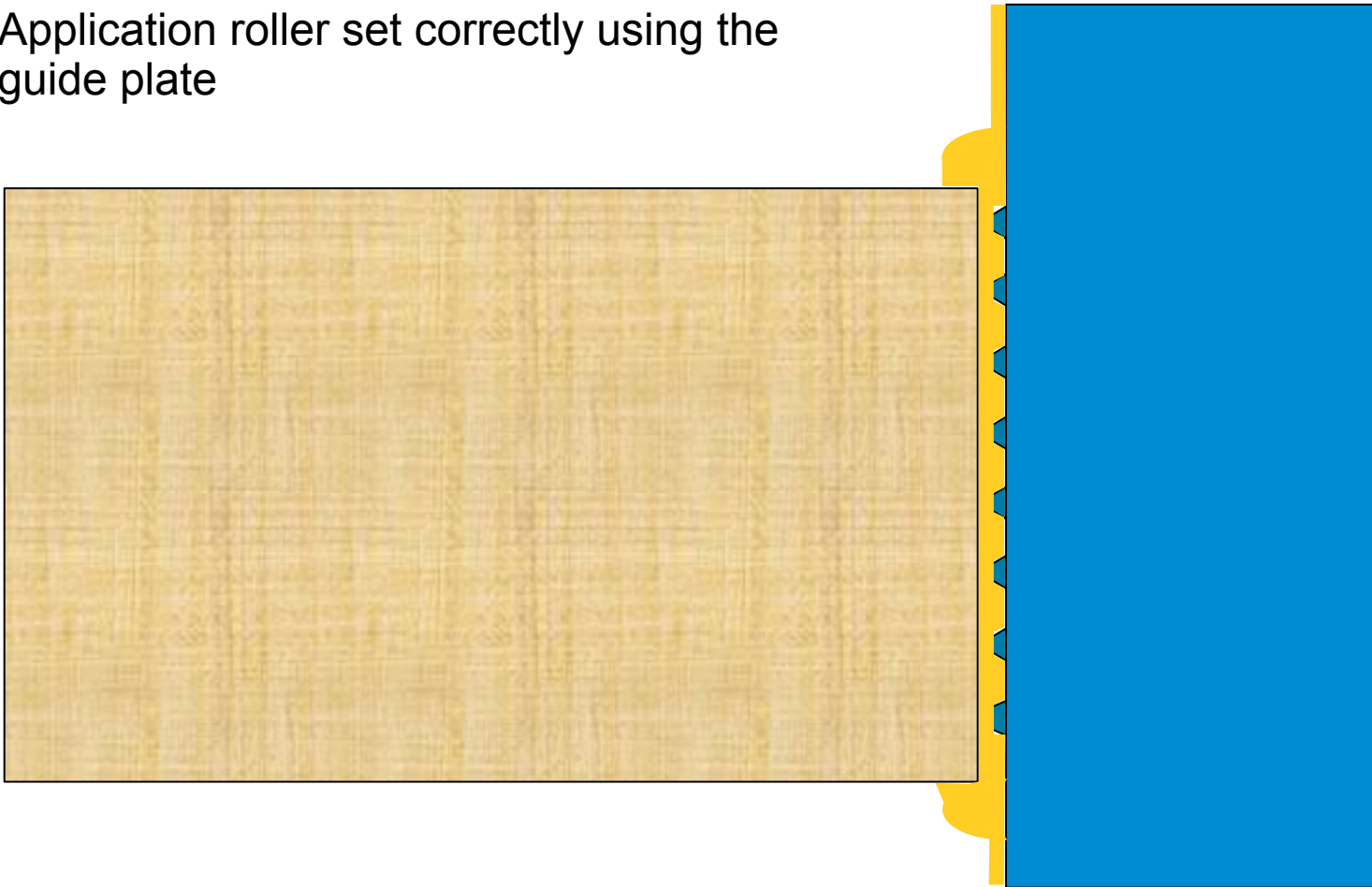


Roller coater set with direct contact to the board giving an uneven coating.  
(magnified x 40)

# Edge Banding

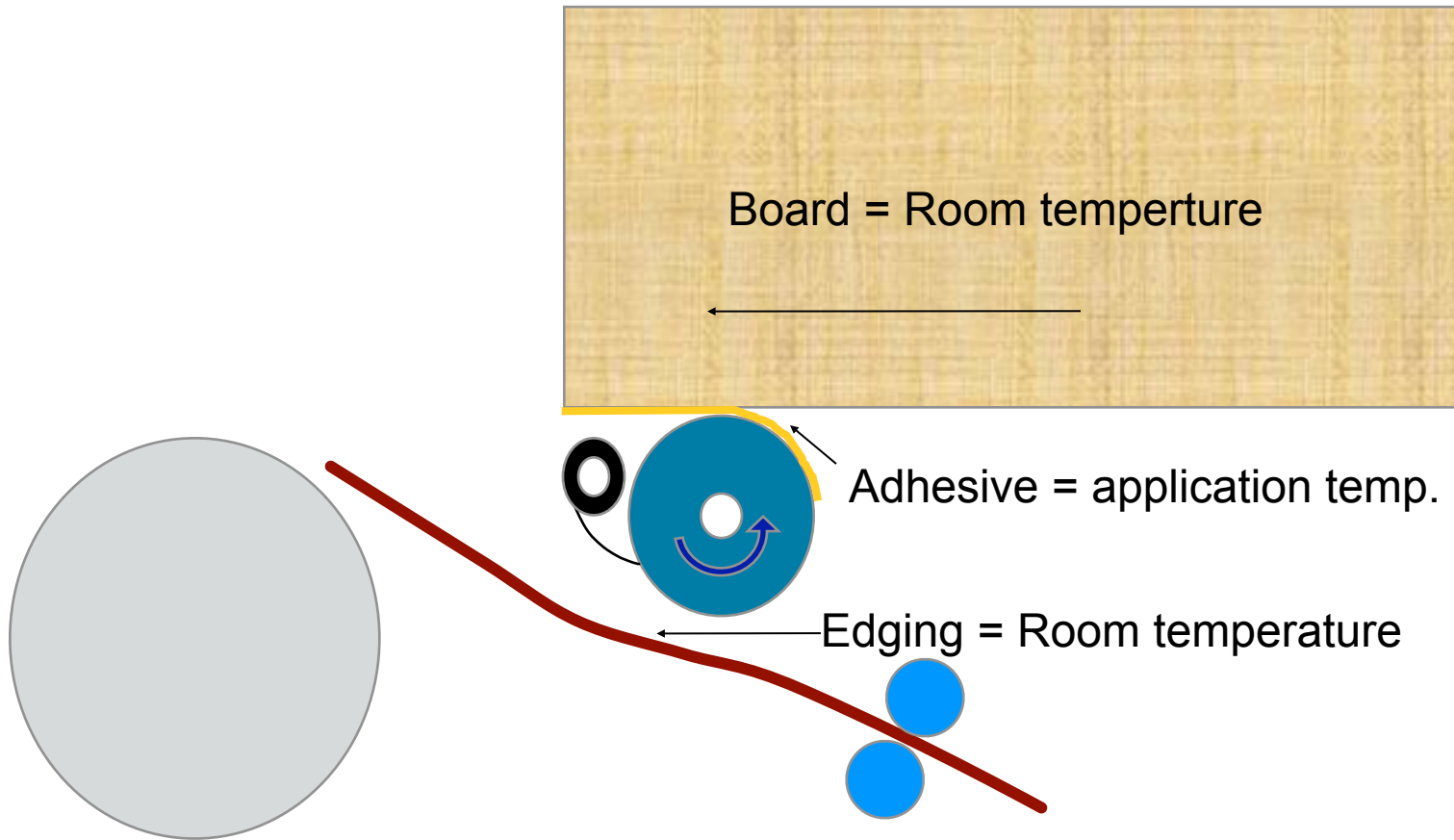
## Roller Coater – guide plate setting

Application roller set correctly using the guide plate



# Edge Banding

## Temperature control



# Edge Banding

## Temperature control



Measure both panel and edge temperature



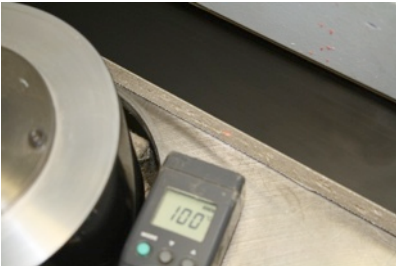
Temperature setting (melting equipment) in line with recommendation of hotmelt supplier (please check Technical Data Sheet)

# Edge Banding

## Temperature control



Measure correct temperature on roller and compare it with figure shown on display. Adjust if required.



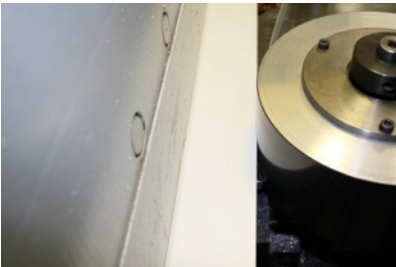
Measure adhesive temperature (contact) on the board before the edging is applied.

# Edge Banding

## Pressure roller



Check correct pressure on display.



Additionally, check correct pressure directly on roller.

# Edge Banding

## Pressure roller - settings

Edging Material	Main Pressure Roller	Small Pressure Roller
• Thin edging	2.5 bar	3 bar
• Thick edging	3 bis 4 bar	3 bar
• Solid Wood	< 1 bar	3 bar



# Edge Banding

## General Information

Store adhesive in a dry, and dust free environment.

Set the correct application temperature of the adhesive

Adhesive application weight has to be set correctly, with an even coating across the edge, and with the correct guide plate setting.

Set the pressure roller to the correct setting according to the edging being run.

Ensure the edge preparation of the board is a 90 degrees

Both board and edge temperature have a minimum of 18 °C

Ensure correct extraction around the roller coater

Avoid dust contamination in the area of adhesive application





# Edge Banding

## Fault Finding



# Edge Banding

Transparent edge fault finding

**Smooth hotmelt coating above, no hotmelt below or vice versa**



---

Panel not right angled.

**Open pores in middle layer of panel**



Hotmelt amount too low

**Smooth hotmelt coating**

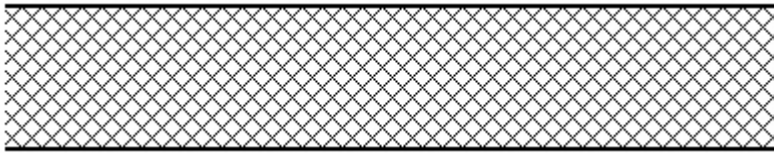


Hotmelt application ok

# Edge Banding

Transparent edge fault finding

**Hotmelt shows pattern of roller**



Hotmelt too cold or Chipboard too cold or  
the pressure roller set too low

**Pattern of roller above, smooth hotmelt coating below,  
or vice versa**



Chipboard not correctly angled or  
the pressure roller not correctly angled

**Thank You**

