



# MELAWOOD SUPAGLOSS

## EDGING

### HOW TO GET THE BEST OUT OF YOUR MELAWOOD SUPAGLOSS EDGING\*

The key to any great looking finished panel product is the quality of the edging. Gloss boards are no exception. A well-edged panel creates a superior finished product and a happy customer.

But you don't need the latest and most expensive saws and edge-banding machines to create first-rate product. By applying these tips, using your current equipment, you can go a long way in creating quality edges and great looking finished product out of your MelaWood SupaGloss.

**The quality and finish of your edged MelaWood SupaGloss components will be greatly enhanced by having the following in place:**

- Your saws and edge-banding machines must be well maintained and properly set up
- Your edging material needs to be the best quality you can afford and preferably thinner than 1.5mm
- Your adhesive must be the best possible quality compatible with your particular edge-banding machine

Although a pre-milling system is not essential, it is recommended to ensure a square cut to the edge of the board and to remove any scorer path or saw cut marks.

A good extraction system will ensure trimmings are removed so as not to contaminate the pressure rollers or buffing systems. Anti-static systems are also effective. Applying an inline release agent will help ensure any glue squeeze-out does not bond to the panel surface.

A "framing effect" is often the result of poorly finished and overly thick edging. This will spoil the appearance of your gloss components. To avoid this, use good trimmer and rounding blades and scrapers to ensure the edging material has an attractive finish. Buffing wheels should then clean off any glue squeeze-out and further enhance the appearance.



Always try and use an edging material thinner than 1.5mm. The gloss of the edging is only on its surface and does not run all the way through the material. As the trimmers cut away the corner material, the duller core is exposed, adding to the "framing effect". The thicker the edging, the more noticeable the dullness of the core.

Last, but not least, use the best possible adhesive system your machine can process. The emphasis should be on spreading the glue as thin as possible, while still keeping the required bond strength. The thicker the glue line, the more noticeable the joint between the edging and the panel.

With this knowledge in hand and by paying close attention to your processes, you can confidently create superior edged panels and amazing finished products that will help keep your customers coming back.

**Adhesive systems at a glance:**

### **EVA Hot Melt**

- Basic thermo plastics, normally in granular format
- Heat resistance of 95°C
- Capable of running on most conventional edge-banding machines
- With careful attention to settings, unfilled hot melts are capable of producing a finish with a minimum glue line of about 185 gsm
- Working with unfilled hot melt enables a much thinner spread with stronger bonding capabilities

### **Polyolefin (PO) Hot Melt**

- Thermo plastics with polyolefin rather than EVA-based polymer
- Heat resistance of 130°C
- Higher water resistance than EVA hot melt
- Step up from EVA hot melt, producing stronger bond and thinner glue line (Target = 160 gsm)
- Polyolefin can still be processed on most conventional edge-banding machines



## PUR Hot Melt

- Modern adhesive system allowing for very thin glue line while offering optimum bonding (Target = 120gsm and lower)
- PUR reacts to the slightest moisture in the atmosphere, so keeping the system purged remains a challenge for most workshops and requires very good discipline at all times
- Due to the chemical crosslinking (fully engaged after 48hr) the glue line is heat, moisture and solvent resistant with a near lifelong bond
- This superior bonding system is ideal for the kitchen industry where components are often exposed to moisture and heat

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