

Formica® Melamine Unglued Edging

Formica® Melamine Edging is formulated to achieve exceptional performance. The combination of modified melamine thermosetting resins and continuous hot pressing, ensures high wear and stain resistance.



APPLICATIONS

Formica® Melamine Edging is recommended for all types of edge treatment for particleboard, medium density fibreboard and plywood. It is supplied unglued for bonding with hot melts.

PRODUCT CHARACTERISTICS

Roll Sizes (nominal):	
Unglued	100m
Thickness:	0.40mm
Width (nominal):	21mm

WHEN SPECIFYING

Edging shall be Formica Melamine Edging as manufactured by The Laminex Group. Colour and/or pattern shall be in finish.

STORAGE

Rolls of Formica Melamine Edging should be stored in dry conditions at temperatures not below 18°C.

PROPERTIES

(AS/NZS 2924.1)	
PROPERTY	REQUIREMENT
Wear Value:	Average wear not less than 50 cycles
Stain Resistance:	Pass AS/NZS 2924.1 type VLS

APPLICATION

RECOMMENDATIONS

For best adhesion, the room, equipment and material temperature will be ideally maintained at minimum of 18°C. Machine components such as pressure rollers, which are in contact with edging, can cause heat loss and should be maintained at equal to or above 18°C to max 40°C.

Substrate moisture content: 8 -10%.

HINTS FOR UNGLUED EDGE BANDING

As this is a thermally reliant process, cold air draughts can affect satisfactory interface bonding temperatures significantly. Ensure edge bander is not subject to cold air draughts. For best adhesion, the room, equipment and material temperature should not be less than a minimum of 18°C, to max 40°C.

Additional Hints

- Keep edging clean and store edging in a dry place
- To maintain satisfactory molten adhesive do not allow adhesive tank to run down before refilling. Keep tank full by adding to adhesive tank as required
- Adhesive tanks should be inspected and cleaned regularly
- Similarly, if using a cartridge system, maintain a charged system
- Be careful not to contaminate adhesives by allowing dirt, dust or foreign matter to be mixed with the adhesive

Generally adhesives begin to degrade over time at temperatures above 180°C. It is good practice to lower temperatures to 120°C if the machine is not intended to be used for prolonged periods.

To effectively complete heat transfer and bonding of both materials, adequate use of pressure on pressure roller is required. 3.5 Bar in a range of 3 to 5 Bar is generally sufficient.

Substrate temperature can affect rapid heat loss when applying adhesives. Therefore it is recommended to use a heating fence where possible if minimum temperatures cannot be maintained.

Periodically check accuracy of temperature gauges supplied on the edge bander machines. If left un-calibrated they can indicate inaccurately by as much as +\-20°C.

Hot Melt Types

There are many commercial hot melts available. It is recommended that adhesive products chosen are specifically formulated for use with melamine laminate edge strip. Ensure that OH&S procedures, technical support and application technology information is available and well supported by the adhesive supplier.

Unglued Edging Application

Hot Melt Adhesive loading:

3.5 to 4.0 gms per lineal meter (21mm width) or as determined by edge bander operator required to achieve satisfactory results dependent on type of hot melt adhesive used.

Hot Melt Applicator Temperature:

190° to 200°C

Hot melt Temp at Pressure Roller:

180° minimum

Pressure Roller Temperature:

18°C minimum to
40°C maximum

Feed Speed:

6.5 to 20 meters/min

Note: Colour/Finishes and product shown are available at the time of publication but may be withdrawn.

General Site Work Notes

Appendix 1. Handling & Product Application Guidelines
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Laminate Product: Care & Maintenance

Appendix 2. General Care and Maintenance
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