

Formica® Melamine Preglued Edging

Formica® Melamine Preglued 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 Preglued Edging is recommended for all types of edge treatment for particleboard, medium density fibreboard and plywood. It is supplied pre-glued with a hot melt.

PRODUCT CHARACTERISTICS

Roll Sizes (nominal):	
Preglued	100m 25m
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

Bonding

a. **General.** Because this product is basically a melamine laminate and not a coated paper; it requires higher operating temperature at the glue line.

To ensure a successful bond the following recommendations should be followed:

1. Avoid cold air draughts in the area where the edgebanding operation is performed.
2. Store edging in a dry place, maintaining temperature at or above 18°C.
3. Use adequate pressure on pressure roller.
4. Always use heating fence where fitted.
5. Periodically check the accuracy of temperature gauges; these can be out by as much as 50°C.
6. Do not use Formica Melamine Edging if the material has been allowed to become damp or wet, or if its temperature is less than 18°C. Substrate moisture content should be 8-10%.

b. Pre-glued Continuous Melamine

Edging. To achieve adequate bonding, a glue film temperature at the point of contact of 140°C must be achieved. Commercial edgebanders with a feed speed of 6-8m/min. and a hot air temperature of 300°C, will successfully bond Formica Pre-glued Melamine Edging.

For an 'iron-on' operation temperatures greater than 250°C are recommended to achieve a glue film temperature of 140°C. This is achieved normally after 10-15 seconds (under pressure) and an 'iron-on' speed of 60-70 seconds per metre length.