

EDGE BANDER SET-UP AND ROUTINE CONTROL PROCEDURES

To set-up an edgebander, the operator should have the following equipment at his disposal:

- Thermometer or pyrometer with surface and immersion probes
- Tachometer to measure line and application roller speed
- Roll of clear PVC (available from Canplast)
- Magnifying glass

GLUE POT OR RESERVOIR

The glue pot must be cleaned periodically. The frequency will depend on the amount of carbonized hotmelt (char) adhering to the walls and sides of the glue pot and the presence of other contaminants such as sawdust.

- Adhesive is flushed from the reservoir and what remains is removed with a spatula. If necessary, use a special cleaner such as toluene.
- Add new hotmelt and adjust the temperature as recommended by the manufacturer. In general, the hotmelt temperature, taken at the applicator roller, should be between 190° and 210°C (374° and 410°F).

CANPLAST CANADA, LTD.

4797, boul. Couture
Montreal, QC, Canada H1R 3H7

Phone: (514) 327-9555

Fax: (514) 327-1582

CANPLAST online

E-mail: info@canplast.com

<http://www.canplast.com>

PRESSURE ROLLS AND PRESSURE BEAM

Pressure rolls must be well adjusted and kept clean at all times. Also, the pressure beam must be adjusted to exert optimum pressure on the board.

CANPLAST CANADA, LTD.

4797, boul. Couture
Montreal, QC, Canada H1R 3H7
Phone: (514) 327-9555
Fax: (514) 327-1582

CANPLAST online
E-mail: info@canplast.com
<http://www.canplast.com>

OPERATING SPEED

Measure the line speed using a tachometer and adjust to the manufacturer's recommendations.

QUANTITY OF HOTMELT

Run the core stock through and bond it with clear PVC. Make the necessary adjustments so that the glue line is smooth without excessive squeeze-out. Using a magnifying glass, inspect the glue line or deposit.

HOW TO OBTAIN GOOD ADHESION

The relation between temperature, quantity of hotmelt, pressure and speed in Edgebanding is very important. The following are some processing recommendations:

- The wrong temperature is very often responsible for poor adhesion. Each operator should have a standard thermometer to verify the precision of the dial thermometer attached to the edgebander. Temperature should be taken at the applicator rolls.
- The temperature should be taken at regular intervals and recorded for reference purposes.
- Manual addition of hotmelt is often responsible for temperature fluctuation (as much as 40°C or 104°F) resulting in poor adhesion. Frequency and quantity of hotmelt additions should be optimized. Pots should be filled during breaks or at regular intervals.
- Edging and boards should be conditioned at room temperature (22°C or 72°F) for at least 24 hours before being processed.
- Pressure rolls must be well adjusted and kept clean at all times.
- Uniformity and thickness of the glue spread (6-10 mils) are very important. It should be thick enough to minimize heat loss and without excessive squeeze out.
- Applicator roller is subject to wear and should be changed when the quad pattern is too light. These rollers have an average lifetime of one year when used continuously for 1 shift per day, five days per week.

CANPLAST CANADA, LTD.

4797, boul. Couture
Montreal, QC, Canada H1R 3H7
Phone: (514) 327-9555
Fax: (514) 327-1582

CANPLAST online
E-mail: info@canplast.com
<http://www.canplast.com>