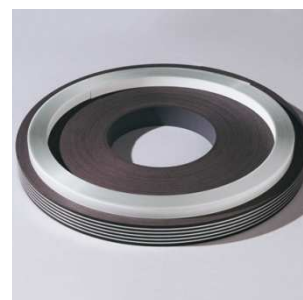


PROCESSING INSTRUCTIONS

EGGER ACCENT EDGING



EGGER Accent Edging is a thermoplastic edging product with primarily aesthetic properties for finishing edges on wood-based panels. It differs visually from matching ABS Edging due mainly to its unique depth.

Uses / Applications

EGGER Accent Edging is used for edging coated wood-based materials like chipboards, MDF and HDF boards providing a contrasting finish for all decorative surfaces. It can be used in a wide range of applications: “accents” can be used in kitchens, bathrooms, offices, bedrooms, living rooms, exhibition and shop fittings, front panels, worktops, etc.

Product Properties

As care must be taken with the edge material during processing, differentiation is required at the decor level.

MATERIAL

Ten of the fourteen decors have been manufactured from acrylic. Acrylic (PMMA = Polymethyl methacrylate) is a very high-quality thermoplastic that has been tried and tested over many years and which provides even better transparency than glass. The following decors are Acrylic-based:



H8952 Multiplex Effect



H8951 Walnut Aluminium Effect



H8953 Light Striped Wood Effect



H8954 Dark Striped Wood Effect



F8994 Brushed Aluminium Effect



F8995 Brushed Steel Effect



F8996 Brushed Bronze Effect



W8900 3D Premium White



F8991 Glass Effect



F8992 Alu Wave

Three PET-based (polyethylene terephthalate) types of edging have been produced. A sheet of real aluminium is embedded in the PET material. This gives the edging a shiny appearance, while the sheet is protected by the PET material. The following decors are PET-based:



FA101 Brushed Aluminium



FA102 Brushed Steel Effect



F8993 Metallic green

One PP-based (polypropylene) edging is used. A real sheet of aluminium is also used for this type of edging. In this case, an imprinted aluminium sheet is used on the edge surface. The following decors are PP-based:



H8950 Wenge Aluminium Effect

Processing

EGGER Accent Edging is particularly easy to process, it can be processed manually and on commercially available edge banding machines and processing centres, using hot-melt adhesive. In general, clean joint milling (formatting) is important when processing acrylic-based Accent Edging. Otherwise, protruding chips may be apparent through the decors*.

***This applies particularly to decors F8994 (Brushed Aluminium Effect) and F8995 (Brushed Steel Effect).**

EGGER Accent Edging can be conventionally processed without difficulty on all normal edge banding machines. Ensure that movement of the edging or edge feeding rollers cannot cause damage to the edging. Rubberised rollers should normally be used for transporting and feeding the Accent Edging. Special Glue coating rollers have been developed to avoid damage to the decor edge. These glue coating rollers differ from normal steel (spiked) rollers in that they have been modified. On processing centres, where the hot-melt adhesive is applied to the coreboard, there is no need for a special glue coating roller. As with every thermoplastic material, the material must be sufficiently warmed through when moving individually designed components to processing centres in combination with external radii. The decor colour of the EGGER Accent Edging plays a decisive role here. Standard colours – e.g. colours or wood decors – absorb heat energy extremely well through the infrared radiation from the processing machines. Metallic decors, on the other hand, may reflect back to large proportion of the infrared radiation. Therefore, we recommend that you work with additional sources of heat. Hot air units and/or edging magazine ovens are an excellent solution. Particularly when dealing with external radii on processing centres, it is important to ensure that the edge is glued stress-free. Added to this is the fact that small external radii on the boards require a high heater power/air temperature or low feed speed. If the edging is insufficiently warmed through, there is a risk of stress build-up. On units not equipped with sufficient heat sources, the edge decor FA101 Brushed Aluminium, FA102 Brushed Steel Effect, F8993 Metallic Green and H8950 Wenge Aluminium Effect cannot be processed.

In order to achieve a clean and durable edge coating, certain processing parameters must be observed; these are dependent on the material used (edges, adhesives, coreboards), on the technology used (edge banding machines, processing centres) and on the conditions (temperature, humidity). We therefore recommend that you carry out your own tests to determine the best settings and procedures.

Observe the guideline values and instructions from the relevant machine and hot-melt adhesive manufacturers.

ADHESIVE

EGGER Accent Edging is coated with a universal bonding agent (primer), ensuring perfect adhesion to all suitable hot-melt adhesives. The bonding agent has been optimized for use with EVA, PA, APAO and *PUR hot-melt adhesives. An extremely heat-resistant glue should be used if the product is likely to be exposed to critically high temperatures, e.g. in the kitchen or in shipping containers. Polyurethane hot-melt adhesives are particularly suitable for use in humid areas. In any case please follow the instructions of the respective adhesive supplier. Contact adhesives containing solvents **must not be used**. The layer of adhesive should be even and sufficient for small droplets to be squeezed out from under the edge and for the spaces between the strips to be filled. Ensure that there is sufficient adhesive in the pre-melt container so that both the quantity applied and the temperature remain constant. The quantity applied should be between 160 and 220 g/m², depending on type of hot-melt adhesive. The processing specifications recommended by the adhesives manufacturers must be observed. The precise dimensions of EGGER Accent Edging give a sealed, visually perfect joint.

* Do not use PUR hot-melt adhesive for decors F8994 Brushed Aluminium Effect and F8995 Brushed Steel Effect.

WORKING TEMPERATURE

The work should be carried out at room temperature. The edges and coreboards that are to be machined should be conditioned at normal room temperature (18-24 °C). If the edges and carrier boards are too cold (e.g. due to storage in unheated places), then the hot-melt adhesive that is applied will come off before the edge band is even attached. Draughts should therefore also be avoided. The processing temperature for the adhesive varies between 90 and 230°C depending on adhesive type. The required processing temperature should be taken from the relevant manufacturer's specifications. It is advisable to measure the temperature on the coating roller.

WOOD MOISTURE CONTENT

For further processing, the optimum wood moisture content of the coreboard material is between 7 – 10 %.

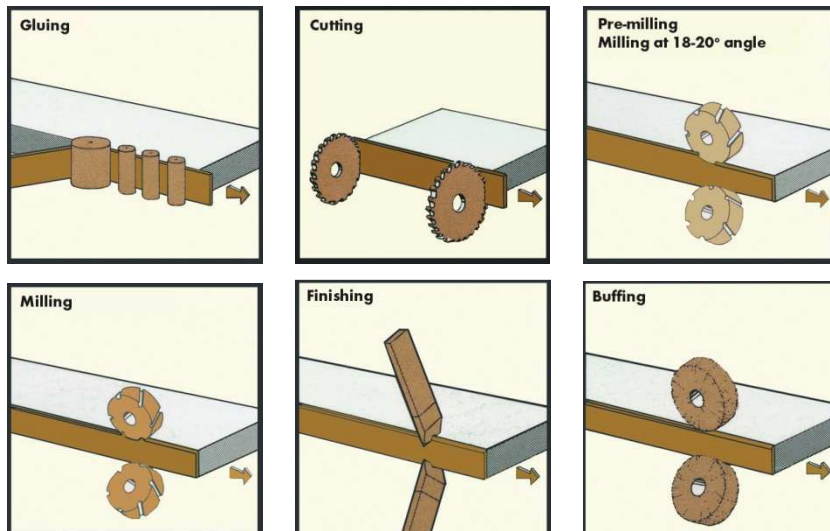
FEED SPEED

The feed speed is dictated by the processing characteristics of the hot-melt adhesive and how it is applied (jet or roller).

Please follow the adhesive supplier's instructions.

If the feed speed is too high, then the hot-melt adhesive may pull fibres out and prevent covering the entire edge of the coreboard material. Furthermore, the coating roller may jump. During edge milling, milling ripples may be produced. If the feed speed is too low, then the interval between application of the adhesive and feeding through of the board is too long. In this case, the temperature falls below the necessary processing temperature and the adhesive will harden before the two surfaces are joined.

WORKFLOW ON THE EDGE BANDING MACHINE



PRESSURE ROLLERS

Taking into account the conditions in the machine, there must be an adequate number of pressure rollers, which must also be set up correctly to achieve an optimum joint. To prevent the joints gaping, the contact pressure must be set high enough to ensure that the entire surface of the edge band is fixed to the board. The pressure rollers must be totally clean to prevent any indents on the edging.

JACK KNIFE

The jack knife must have a sharp blade and make a clean cut of the edging material. As little material as possible should be left protruding for milling, so as to make a subsequent profiling easier.

OSCILLATING SAW

With feed adjusted, the oscillating saw should make a clean cut into the edge material. Saw blades with pointed teeth on one side are tried and tested, as opposed to saw blades with teeth on both sides which are only suitable in specific circumstances.

MILLING

Edge protrusion should be the same on both sides, approx. 1.5mm more than the edge band thickness. If it protrudes too far, the risk of splinters is greater. Processing with chamfer cutters can be used to create special design effects on EGGER Accent Edging. Four- to six-blade cutters with a diameter of approx. 70 mm and a rotational speed of between 12,000 and 18,000 rpm should be used. DIA milling tools have proved particularly effective. The exact choice depends on the characteristics of the cutter and the machine. Blunt tools running at inappropriate speeds can damage the edges. If lubricating effects occur, reduce the speed of the milling cutter or increase the feed. The direction of rotation for coarse, fine or radius milling should be upcut.

SCRAPER PROCESSING

EGGER Accent Edging can usually be easily processed with scrapers. As the materials tend to lighten in colour slightly after scraping, the scraper blade should not exceed 0.1 to 0.2 mm. Milling tools with a high running accuracy will produce the required milling accuracy ("without blade marks").

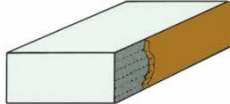
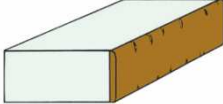
BUFFING

EGGER Accent Edging can be easily processed using a finishing wheel. Furthermore, the finishing wheel removes any dirt (adhesive residue) from the surface and/or the edge angle. Any adhesive remnants can be easily removed using electronically controlled separating agent spray units; this also reduces blade wear. When using separating agents, you MUST check beforehand that they do not contain any solvents or alcohols, as acrylic (PMMA) must not come into contact with these. Any colour lightening caused by scraper machining can simply be polished away using the finishing wheel. The acrylic edging in particular can be polished using soft finishing wheels and matching polishing pastes to practically any desired level of gloss, whereas PET and PP edging can only be polished to a moderate degree.

WASTE EXTRACTION

Thermoplastic ships may become statically charged, and thereby attach themselves to the material and the machine component, so that a stronger suction power is required (approx. 2.5 m³/s).

NOTES ON PROCESSING ERRORS

<p>1. Edge can be easily removed by hand. Residue of hot-melt adhesive on the chipboard. The lattice structure of the adhesive coating roller is visible.</p>	<ul style="list-style-type: none"> ➤ Room temperature too low or draught in the area between application of the hot-melt adhesive and the pressure roller ➤ Edge material too cold (outdoor storage) ➤ Hot-melt adhesive temperature too low ➤ Feed speed too slow ➤ Contact pressure of coating rollers too low ➤ Not enough adhesive applied
<p>2. Edge can be easily removed by hand. Residue of hot-melt adhesive on the chipboard. The hot-melt adhesive surface is completely smooth (edge slips off)</p>	<ul style="list-style-type: none"> ➤ Board and/or too cold ➤ No bonding agent, or wrong/insufficient bonding agent ➤ Unsuitable hot-melt adhesive used
<p>3. Edge can be easily removed by hand. Most of the hot-melt adhesive is left behind on the edge.</p>	<ul style="list-style-type: none"> ➤ The board material is still storing excessive thermal energy (e.g. after earlier veneering or laminating of the board surfaces)
<p>4. No adhesive on the glue edge at the front of the board and the edge is split by a few millimetres at the front.</p> 	<ul style="list-style-type: none"> ➤ The adhesive coating roller is not close enough to the edge of the board. No adhesive has been applied to the first part of the edge because the roller has been held back at the front edge of the board. ➤ Increase amount of adhesive applied
<p>5. Milling ripples can be seen.</p> 	<ul style="list-style-type: none"> ➤ Feed speed too high ➤ Cutting speed too low ➤ Use upcut milling ➤ Increase number of cutters on miller ➤ Increase rotational speed ➤ Post-process with scrapers and finishing wheel
<p>6. On thick edge boards, the colour in the milled area has faded a little.</p>	<ul style="list-style-type: none"> ➤ Edge fed in too cold ➤ Increase heater power or reduce feed rate ➤ Increase geometry or use a thinner edge material ➤ Warm up the milled area in the hot air station (re-work)

Further information on EGGER Accent Edging can be found in our product data sheet!