

Preglued Edgebanding Application Guidelines



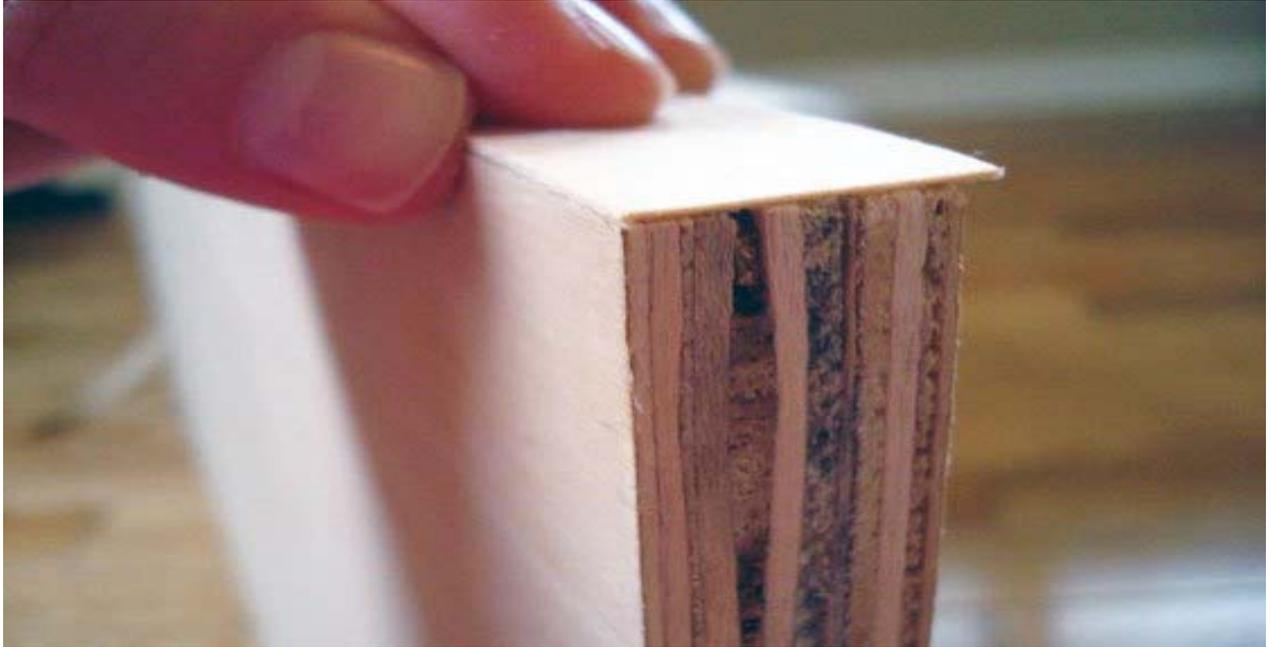
Hot Air Edgebander application

If you are applying our preglued edgebanding with a hot air bander please follow the manufacturer's recommended settings. The approximate application temperature for our hot melt glue line is 200C – 210C (392F – 410C) with an approximate application line speed of 10 – 40 meters (33 – 131 LF) per minute. The recommended settings for your edgebander may be different.

Applying our preglued edgebanding by hand or manually

1. Gather your tools and materials.
 - a) Iron
 - b) Scissor
 - c) Preglued veneer edgebanding from Edgeband USA
 - d) Sandpaper and/or wood file
 - e) Trim knife
 - f) Small block of wood such as a 2 x 4 x 4
2. Set your iron to the cotton or hottest setting. The temperature to make the glue line flow should be 390 F or hotter. Failure to ensure a proper temperature level could affect bonding quality. You can overcome some lower temperatures with additional pressing time on the edging. If you find you cannot soften the glue line enough for the glue to flow and to form a bond you should buy a different iron capable of temperatures in excess of 390 F.
3. Prepare the edgebanding. Use your scissors or trim knife to cut a section of veneer that's roughly half an inch longer than the edge you're going to cover. Try to maintain a 90 degree cut on the edging. You don't have to be precise in your measurements; just hold the veneer against the cabinet edge to figure out how long the section should be. You can work directly from the coil, but it's easy for the veneer to get twisted, so we recommend cutting it into lengths first. Be careful handling the real wood veneer edgebanding as splinters may occur.

4. Starting at one end, carefully position the veneer against the edge that you want to cover. The veneer will be slightly wider than the edge that you're covering. Keep it flush on your finished or exposed side and let it overhang the other side. You will trim this extra off after it is applied and cooled.



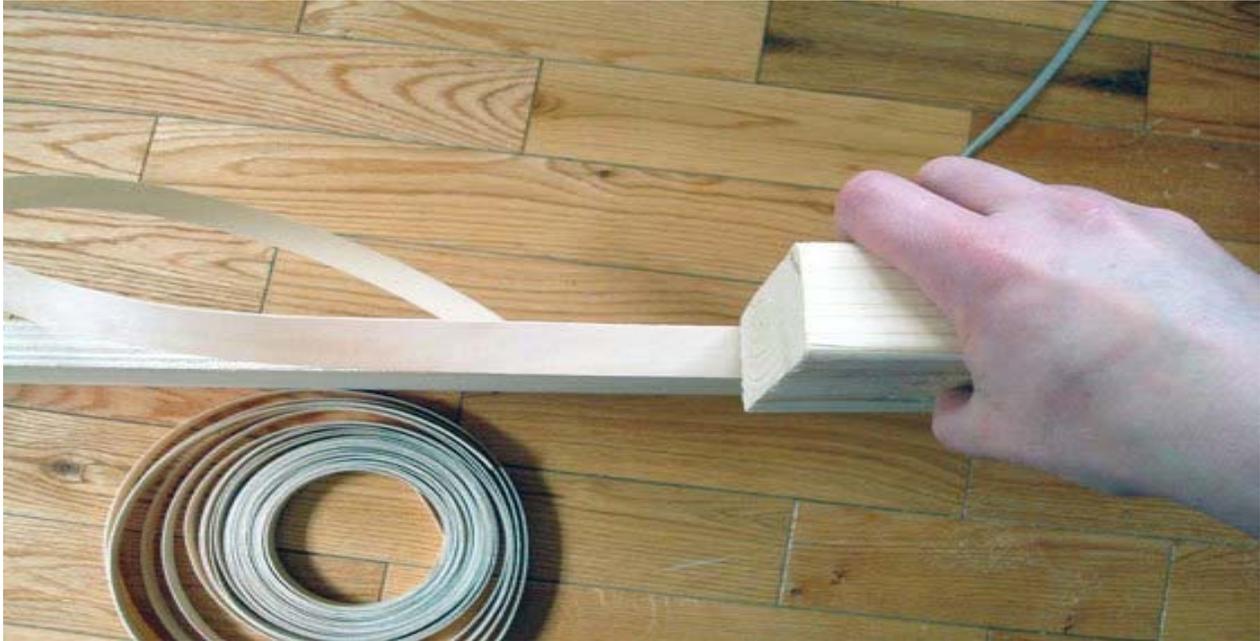
5. With your edgebanding in position, apply the iron to melt the glue.



“Pressing” firmly is preferred rather than an “ironing” technique. Just hold your iron in one spot for about 20 seconds. It will take time for the hot iron to soften the glue line enough

that a bond is formed. When you remove the iron, make sure the veneer is still aligned along the edge of the plywood. The glue will stay soft for only a couple of seconds so adjustments have to be made quickly. You can reapply the iron to resoften the glue if necessary. The fewer times the better though.

6. Using your block of scrap wood, firmly press the edgebanding onto the plywood.



Press firmly and slide the block back and forth over the section that you ironed making sure that the veneer fully adheres to the plywood. This pressure is necessary to ensure a firm strong bond with the glue line and your edge. A good bond will prevent you from pulling the edgebanding up off the plywood in any place along the edge. You don't want the edgebanding to delaminate once your project has been completed.

Repeat steps 5 and 6 until the raw edge is completely covered with veneer.

Remember that all successful edgebanding projects are based on the correct combination of temperature, pressing time, and pressing pressure or down force.

7. Once the veneer has cooled, trim the excess that's overhanging the one side with a file or trim knife. File or trim towards the face of your plywood keeping the file at roughly a 90 degree angle. Take your time to ensure a nice clean trimming. There are tools that will trim the extra veneer off as well. If you use a file to trim the veneer, clean the file regularly to ensure your trimming is nice and clean.

8. Your edge should now be nice and smooth and ready for stain or paint.

Before



After

