

## Problem Solving Edgebanding Application Issues



### Why doesn't my edgebanding stick?

- 1) Substrate, cabinet, or the edge you are gluing must be clean of dust and dirt and at room temperature or warmer. Cold substrate sitting outdoors in the middle of the winter will be more difficult for edgebanding to bond to due to the cold substrate causing the hot melt glue to immediately skin over when it touches the cold surface. The glue line looks like it is soft and flowing but up next to the substrate it has cooled too quickly to form a strong bond. The dust, dirt, and cold all create a barrier to the bond.
- 2) Incorrect time, temperature, pressure or a combination of all of these. All successful edgebanding projects are based on the correct combination of temperature, pressing time, and pressing pressure or down force. If anyone of these is lacking the glue line may not bond successfully to your substrate or cabinet and delamination may occur.
  - a. Make sure the application temperature is correct for your machine or your manual application. In colder climates, increased temperature settings may help to ensure the glue line is flowing correctly and open long enough to form a good, strong bond.
  - b. Make sure your application line speed supports the glues ability to flow properly and to ensure the correct open time necessary for a proper bond. Going too fast marginalizes the glue line and decreases the success of making a delam free edging. Going too slow increases costs in manufacturing and can also give the glue too much time to cool and not form a good bond.
  - c. Make sure that there is sufficient and equal pressure across the entire width of the edgebanding. Not ensuring this could lead to gaps and bubbles.
- 3) Make sure there is enough glue on the edging to ensure a full coverage of glue across the entire width of the banding. Spotty or insufficient glue lines will not have enough glue to form a strong bond across the entire width of the edge. It is the glue line that forms the bond and adheres the edgeband with the substrate. Skimping here will only cause you problems. Run a glue test if possible.
- 4) If you have noticed that occasionally when you peel a piece of edgebanding off of a panel that you've run through an edgebander or manually applied, the adhesion is poor. The glue line looks fine and solid, but very little glue remains stuck to the banding when it is pulled off. Assuming you are using a good line of glue, the cause of this problem is usually too cold glue or the substrate is too cold. Increase the heating temperature of the glue and/or warm up the substrate or cabinet to room temperature or warmer.

**Edgeband USA hopes this information allows you to get the most out of our edgebanding. Please feel free to contact our product technical support department to work through any problem you may be having. Edgeband USA - Service is our No. 1 product.**