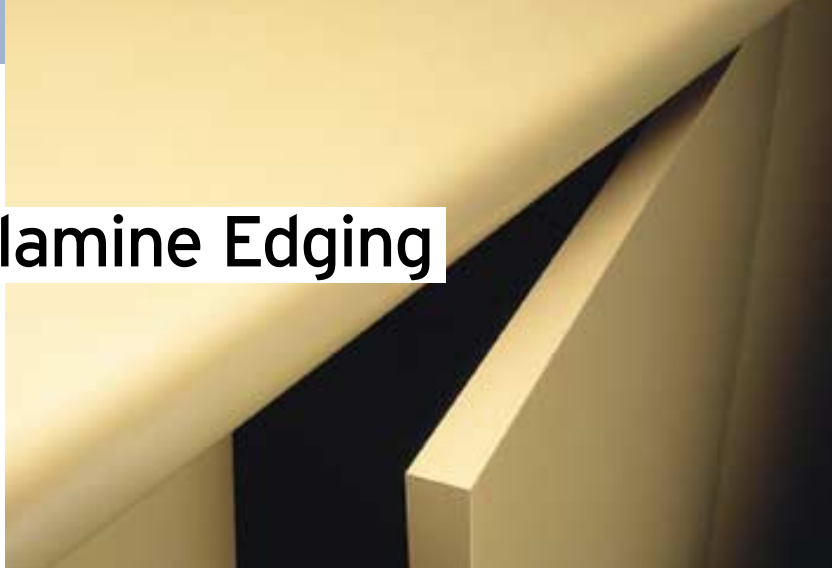


# Laminex® Thin Melamine Edging

Laminex® Continuous Melamine 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

Laminex® Continuous Melamine 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 or unglued for bonding with hot melts.

## PRODUCT CHARACTERISTICS

|                       |                |
|-----------------------|----------------|
| Roll Sizes (nominal): |                |
| Preglued              | 100m<br>25m    |
| Unglued               | 100m           |
| Thickness:            | 0.40mm         |
| Width (nominal):      | 21mm           |
| Finish:               | Natural, Flint |

Some Natural Laminex® Continuous Melamine Edging is available to match the current Vertiboard®/Lamiwood range of colours. Special widths can be manufactured to order dependent on minimum order quantities.

## WHEN SPECIFYING

Edging shall be Continuous Melamine Edging as manufactured by The Laminex Group. Colour and/or pattern shall be ..... in ..... finish.

## Storage

Rolls of Laminex® Continuous Melamine Edging should be stored in dry conditions at temperatures not below 18°C.

## PROPERTIES

| (AS/NZS 2924.1-1998) |                                      |
|----------------------|--------------------------------------|
| PROPERTY             | REQUIREMENT                          |
| Wear Value:          | Average wear not less than 50 cycles |
| Stain Resistance:    | Pass<br>AS/NZS 2924.1-1998 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 Laminex® Continuous Melamine Edging if the material has been allowed to become damp or wet, or if its temperature is less than 18°C.

## 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 375°C, will successfully bond Laminex® pre-glued Continuous 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.

## c. Unglued Continuous Melamine

**Edging.** To achieve an adequate performance, the following factors must be taken into consideration:

1. Glue: it is recommended that a high melting point hot melt (Laminex® HM180™ or Bond-Rite/Jowat 4490 or similar) be used with a loading of 3.5-4.0 gr/lineal metre (21mm width).
2. Substrate: In order to minimise the 'chilling-effect' when the hot melt is pressed against a cold substrate, the substrate edge should be pre-heated by means of a heating fence or electrical blower when cool conditions are present (below 18°C).

3. Temperature: A glue tank temperature of 195-210°C and applicator roll temperature of 205-215°C are essential for successful bonding. Bond failure will occur if glue temperature at the applicator roll is below 195°C.

Maintain constant glue level in glue tank by adding glue often. Do not let tank level run down and then add large quantity of glue, as this will dramatically reduce glue temperature in tank even though gauge may still indicate required temperature.

4. Machine Speed: Speeds of a minimum of 20m/min. are recommended. Lower speeds are acceptable provided the 'open time' (time it takes for the glue to get from the applicator roller to the pressure roller) is less than one second.

General Site Work Notes  
[Appendix 1. Laminate Products.](#)  
Pages 6.1 – 6.2.

Care & Maintenance  
[Appendix 2. General Care.](#)  
Pages 6.5 – 6.6