

## StyleLex®

Luxury Covered Outdoor & Wet Area Panels

### Problem diagnostics Tips and instructions for process step problems

| Problem                                                                                                                                                                                 | Problem diagnosis and suggestions                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 1. The edgeband can easily be peeled off by hand. Hot-melt adhesive remains on the chipboard. The raster pattern of the glue applicator roller is visible.                              | <ul style="list-style-type: none"> <li>• Application of adhesive not sufficient</li> <li>• Room temperature too low</li> <li>• Edgeband material too cold (storage outdoors)</li> <li>• Hot-melt temperature too low</li> <li>• Feed rate too low</li> <li>• Contact pressure of applicator rollers too low</li> </ul>                                                                                                                                                                                                                                                                                                                                  |
| 2. The edgeband can easily be peeled off by hand. Hot-melt adhesive remains on the chipboard. The hot-melt adhesive surface is completely smooth (edgeband slides off).                 | <ul style="list-style-type: none"> <li>• Board and/or edgeband too cold <ul style="list-style-type: none"> <li>– Check hot-melt adhesive type</li> <li>– Check adhesive agent application</li> </ul> </li> </ul>                                                                                                                                                                                                                                                                                                                                                                                                                                        |
| 3a. The edgeband can be peeled off by hand. Most of the hot-melt adhesive remains on the edgeband.                                                                                      | <ul style="list-style-type: none"> <li>• Temperature of board material too high due to previous process step (e.g. veneering)</li> </ul>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |
| 3b. Glued joint is not closed (edge glueing machine).                                                                                                                                   | <ul style="list-style-type: none"> <li>• Contact pressure too low</li> <li>• Adhesive too cold <ul style="list-style-type: none"> <li>– Raise application temperature, pre-warm board or increase feed rate</li> </ul> </li> <li>• Edgebands have no, or inverse, pre-tension</li> </ul>                                                                                                                                                                                                                                                                                                                                                                |
| 3c. Glued joint is not closed (machining centre).                                                                                                                                       | <ul style="list-style-type: none"> <li>• Contact pressure too low</li> <li>• Edgeband has become too cold and cannot be squeezed</li> <li>• Restoring forces of edgeband material too high <ul style="list-style-type: none"> <li>– Increase heater power or reduce feed rate</li> <li>– Increase geometry or use thinner edgeband material</li> </ul> </li> <li>• Adhesive not machining centre compatible, heat adhesiveness too low</li> <li>• Adhesive does not harden quickly enough <ul style="list-style-type: none"> <li>– Reduce the glue application temperature</li> </ul> </li> <li>• Edgebands have no, or inverse, pre-tension</li> </ul> |
| 3d. Edgebands are only bonded in edge area.                                                                                                                                             | <ul style="list-style-type: none"> <li>• Contact pressure too low</li> <li>• Joint milling on board part hollow</li> <li>• Pre-tension of edgebands too high</li> </ul>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |
| 4. The edgeband bonded does not have enough glue on the front edge of the board/the board is splintered at the front as the result of an incorrectly positioned glue applicator roller. | <ul style="list-style-type: none"> <li>• Application of adhesive not sufficient as a result of incorrectly positioned glue applicator roller <ul style="list-style-type: none"> <li>– Increase the quantity applied</li> </ul> </li> </ul>                                                                                                                                                                                                                                                                                                                                                                                                              |
| 5. Milling waves are visible.                                                                                                                                                           | <ul style="list-style-type: none"> <li>• Feed rate too quick</li> <li>• Cut speed of milling cutters too low <ul style="list-style-type: none"> <li>– Rework with draw blades and buffing station</li> <li>– Mill in counter direction</li> <li>– Increase number of blades on miller cutters</li> <li>– Increase speed</li> </ul> </li> </ul>                                                                                                                                                                                                                                                                                                          |
| 6. For thick edgebands, the colour in the milling area lightens a little (stress whitening).                                                                                            | <ul style="list-style-type: none"> <li>• Heat the milling area using a hot-air station (can be retrofitted)</li> <li>• Draw blade is too thick <ul style="list-style-type: none"> <li>– Rework with buffing station</li> <li>– Reduce draw blade size (max. 0.1 – 0.2 mm)</li> </ul> </li> </ul>                                                                                                                                                                                                                                                                                                                                                        |
| 7. Stress whitening indications for machining centre processing within radius.                                                                                                          | <ul style="list-style-type: none"> <li>• Edgeband has become too cold <ul style="list-style-type: none"> <li>– Increase heater power or reduce feed rate</li> <li>– Increase geometry or use thinner edgeband material</li> </ul> </li> </ul>                                                                                                                                                                                                                                                                                                                                                                                                           |

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|-------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 8. Strong stringing of adhesive after application                       | <ul style="list-style-type: none"> <li>• Lower application temperature <ul style="list-style-type: none"> <li>- Clean glue part</li> <li>- Test other adhesive</li> </ul> </li> </ul>                                                                                                                           |
| 9. "Mouse teeth" in the joint                                           | <ul style="list-style-type: none"> <li>• Increase quantity applied <ul style="list-style-type: none"> <li>- Increase application temperature</li> <li>- Pre-warm board</li> </ul> </li> </ul>                                                                                                                   |
| 10. Rupturing of the long edgebands after the cross-edging              | <ul style="list-style-type: none"> <li>• Only format and insert the board <ul style="list-style-type: none"> <li>- Check the miller cutter to see if the penetration depth is OK</li> <li>- Reduce the amount of material removed or use other chipboards</li> </ul> </li> </ul>                                |
| 11. Damage to the decor of the edgeband for machining centre processing | <ul style="list-style-type: none"> <li>• Use special rubber rollers</li> </ul>                                                                                                                                                                                                                                  |
| 12. "Dents" or "scratches" in the edgeband                              | <ul style="list-style-type: none"> <li>• Clean the edgeband feeder <ul style="list-style-type: none"> <li>- Clean the contact rollers and spray them with separating agent</li> <li>- Clean the scan shoes; if not better, inspect the scan shoes for damage and renew them if necessary</li> </ul> </li> </ul> |
| 13. Rupturing or luting at ends of edgeband                             | <ul style="list-style-type: none"> <li>• Have the mitre saw sharpened <ul style="list-style-type: none"> <li>- Ask the tool supplier for a suitable tool</li> </ul> </li> </ul>                                                                                                                                 |
| 14. Rupturing at the top and bottom of edgeband                         | <ul style="list-style-type: none"> <li>• Lower edgeband projection <ul style="list-style-type: none"> <li>- Adjust temperature (to above 18 °C) of boards and edgebands the day before</li> <li>- Increase the room temperature and prevent draughts</li> </ul> </li> </ul>                                     |
| 15. Edgeband luted on copying                                           | <ul style="list-style-type: none"> <li>• Lower the number of blades <ul style="list-style-type: none"> <li>- Regulate the speed</li> <li>- Mill edgebands in counter direction</li> <li>- Increase feed rate</li> </ul> </li> </ul>                                                                             |
| 16. 3D 2-in-1 offset in corner area                                     | <ul style="list-style-type: none"> <li>• Precise adjustment of the edgeband holding down clamp <ul style="list-style-type: none"> <li>- Set edgeband projections to the minimum</li> <li>- Check edgeband for sabre shape</li> </ul> </li> </ul>                                                                |

