



Application technology Information For Achievable Radii 26.05.2006

Realistic outside and internal radii of thermoplastic edgeband for use on CNC controlled BAZ processing with direct adhesive application. (like IMA + HOMAG)

The following data are to be understood as approximate values. In practice it can indicated values are strongly dependent on the processing conditions and the type of edgeband used. Some serious factors that influence the processing process are specified in the following:

Edgeband parameter

ABS	(most heat required)
PP	(ideally for kitchen work tops 43x1,5mm)
PMMA 3D-BAZ	(Requires most warming)
PVC	(ideal for all ranges)
Dimension	(above all the thickness is crucial)
Unicolour	(each color has its unique heat absorption properties)
Metallic Materials	(Metallicpigmente can cause reflection part of the IR radiation to reflect)
Single colour or Wood effect edge	(printing inks to be able white break up to a certain part to cover)
Tolerances	(e.g. strength tolerance, pre-loading tolerance)

Environmental conditions like Temperature , Air humidity???

Adhesive properties like Processing viscosity (the more highly the viscosity, the better is the initial adhesive force)
 Processing temperature (affects again Processing viscosity)
 Open time of the adhesive
 Adhesive basis "EH, APAO, PURE" (are generally suitable unfilled adhesives are the best)
 EVA ideally during heat support only with IR emitter, or without heat support???
 APAO ideally during heat support by means of IR emitters + hot-air shower???
 PUR only conditionally for BAZ processing suitably direct order or reactivation adhesive quantity laid on by pre-coated edges

Machine equipment, like edge warming up possibilities (IR emitter, hot-air or magazine furnace (there is also possible for combinations))
 feed roll assembly (reproduction role)
 kind of the order for glue???

Processing programme as feed speed during the edge warming up phase, within the radius ranges and directly behind the radii
 reproduction role employment
 contact pressure
 Synchronitaet between gluing rapid feed and edge transportation feed motion (with internal radii is it to work recommendable with edge loop)
 Offset . attitude

Bend Radius for Wood effect edgebands

Material	PVC		ABS		PP		PMMA - 3D	
	External mm	Internal mm	External mm	Internal mm	External mm	Internal mm	External mm	Internal mm
Radius→								
Thickness								
1mm	5-15	30	10-20	30	5-15	30	10-20	30
2mm	20-30	40	30-45	40	30-45	40	20-30	40
3mm	35-45	60	45-60	60	40-60	60	45-60	60

Bend radius for Single Colour edgebands

Material	PVC		ABS		PP	
	External mm	Internal mm	External mm	Internal mm	External mm	Internal mm
Radius→						
Thickness						
1mm	10-20	30	15-25	30	5-15	30
2mm	25-35	40	35-45	40	30-45	40
3mm	40-50	60	60-70	60	40-60	60