

Edge Banding

KLEIBERIT EVA Hotmelt

KLEIBERIT EVA-HM 774.4/774.8

For bonding primed polyester edges, PVC and ABS edges, veneer and paper edges.

- For line speeds from 20 up to 60 m/min
- Medium viscosity
- Good green strength

KLEIBERIT EVA-HM 779.6

Universal for nearly all edge material.

- For line speeds from 10 to 70 m/min
- Suitable for pre-coating edges

KLEIBERIT EVA-HM 788

For manual and slow edge banding machines.

- Very long open time
- Application possible from 160°C
- Wide processing window
- Suitable for processing in humid and warm regions

KLEIBERIT EVA-HM 779.7

Universal for softforming / straight edges; pre-coating.

- Especially recommended for softforming
- For line speeds from 15 to 70 m/min

KLEIBERIT EVA-HM 777

Universal adhesive for bonding straight edges and softforming. Highly recommended for softforming with veneer edges and direct postforming

- High heat resistance up to 110°C depending on edging material
- Extremely good adhesion to primed PP edges and solid wood edges



KLEIBERIT EVA-HM 773.3

"Universal" and "transparent" for nearly all edging materials

- Absolutely no stringing – so smearing during routing
- Very good pre-melting properties for high line speeds up to 80 m/min
- Suitable for difficult softforming profiles with a tight radius
- Transparent – invisible glue line

ADHESIVES

In the edge banding field, the adhesive requirements of the furniture industry are constantly increasing, especially regarding faster application, temperature and heat resistance, shapes and materials.

Suitable adhesive systems for edge banding are:

EVA Hotmelts

PO Hotmelts

(Ethylene-vinyl acetate and polyolefin):

- Based on thermoplastic synthetics or resins which set purely physical
- Reach strength immediately after cooling and setting/crystallisation
- Temperature resistance from -20°C to 120°C

Reactive PUR Hotmelts

(polyurethane):

- Besides the physical setting there is a chemical cross linking
- Much higher temperature and moisture resistance from -40°C up to 140°C

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KLEIBERIT EVA-HM 773.7

Thermoplastic synthetic resin adhesive for polyester, CPL and melamine resin, veneer, paper, PVC and ABS edges.

- Very good melting properties
- Transparent joint
- Suitable for softforming processes and bonding in CNC processing centres (easy edge)
- Temperature resistance between -20°C and 100°C (depending on edging material)

KLEIBERIT Supramelt GL 782

Hotmelt cartridge with slide coating for the HOLZ HER cartridge system.

- Increased flow capacity
- Trouble-free melting of the adhesive without any residue

KLEIBERIT PO Hotmelt

KLEIBERIT PO 753.5

For bonding straight edges, softforming and direct-postforming

- high temperature resistance between -20°C and 120°C (depending on edging material)
- Very high green strength
- Application with roller or slot nozzle
- Excellent properties for CNC processing centres

KLEIBERIT PUR Hotmelt

KLEIBERIT PUR 707.7 / 707.9

Reactive PUR hotmelt adhesive

- High temperature resistance from -30°C up to 140°C
- Very high humidity, water and moisture resistance
- Available in white or transparent
- Suitable for bonding aluminium edges

Application

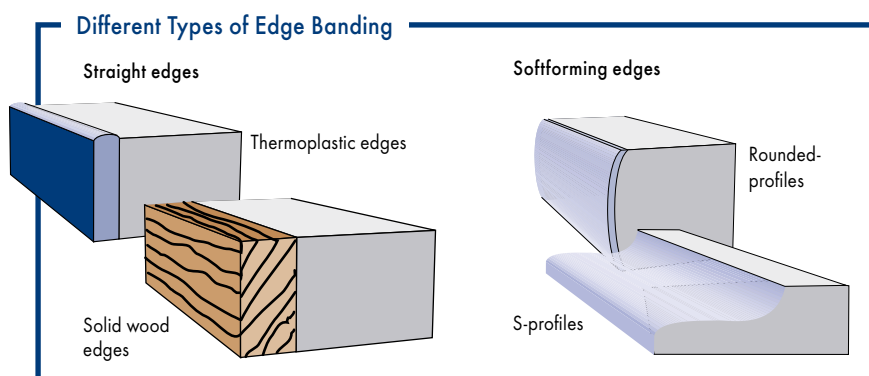
Hotmelt adhesives for bonding of edges and softforming have a medium or high viscosity, in order to fill the gaps in the middle layer of the chipboard and to achieve good strength across the whole width of the board.

Quick crystallisation in the press is necessary to avoid smearing during flush milling. The green strength of hotmelt adhesives must be very high, especially for softforming processes, so that the memory of the edging materials cannot cause the glue line to open.

Edge banding adhesives are free flowing and therefore do not cause blocking in the granulate pre-melter.

Edge banding hotmelts are melted in granulate premelters which are usually situated directly above the application system. The premelted adhesive is guided (level-controlled) through a heated hose into the application basin. The application is either with roller or with a nozzle.

For straight edges the adhesive is usually applied on the chipboard, for softforming always to the edging material.



KLEIBERIT Adhesives for Edge Banding

KLEIBERIT	Product	type of machine manual or slow edge banding machines	usual edge banding machines >18m/min		high-speed edge banding machines		CNC processing center	contour edge banding machines	
			straight edges	softforming	straight edges	softforming		straight edges	softforming
EVA Hotmelts	HM 773.3		■	■	■	■	●	●	●
	HM 773.7	●	■	■	●	●	■	■	▼
	HM 774.4/774.8		■	■	●	●			
	HM 777		■	■			▼		
	HM 779.6	●	■	●	▼	●	▼	●	●
	HM 779.7		■	■	▼	▼	▼	●	●
	HM 779.8		■	■	■	■			
	Supramelt GL 782		■	■	●	●	●		
HM 788	■	▼	▼				▼	■	
PO-HM	HM 753.5	●	■	■		■	▼	■	
PUR-HM	HM 707.9	▼	■	■	■	▼	■	■	●
	HM 707.7	▼	■		■	▼	■	■	▼

■ very well suited ▼ well suited ● possible