

ZERO LINE EDGEBANDING

- Coextruded version -

SETTINGS FOR LASER DIODE EDGEBANDING MACHINE

General settings for application of **ZERO LINE** edgeband with **LASER DIODE** edgebanding machine in order to obtain a correct adhesion.

GENERAL SETTINGS

SPEED	30m/min
LASER ENERGY	Depending on the edgeband reference. Consult the table below.
FIRST ROLL PRESSURE (larger diameter)	3.0 bar
OTHER ROLLS PRESSURE	2.7-3.0 bar

Joules /cm2 for each edgeband reference

Edgeband reference	Joules /cm2	Edgeband reference	Joules /cm2
7872.10	25 Joules /cm2	7875.10	23 Joules /cm2
7871.10	25 Joules /cm2	8135.10	25 Joules /cm2
7714.10	25 Joules /cm2	7876.10	23 Joules /cm2
7870.10	25 Joules /cm2	8050.10	21 Joules /cm2
8356.10	25 Joules /cm2	8062.10	19 Joules /cm2
8459.10	25 Joules /cm2	7877.10	19 Joules /cm2
8245.10	25 Joules /cm2	7878.10	19 Joules /cm2
7713.10	25 Joules /cm2	7873.10	18 Joules /cm2
7874.10	23 Joules /cm2	8190.10	18 Joules /cm2
8133.10	23 Joules /cm2	8107.10	22 Joules /cm2
8134.10	22 Joules /cm2	8105.10	22 Joules /cm2
		8106.10	19 Joules /cm2

These parameters are only indicative and may require minor modifications.

ZERO LINE EDGEBANDING

- Coextruded version -

SETTINGS FOR HOT AIR EDGEBANDING MACHINE

General settings for application of **ZERO LINE** edgeband with **HOT AIR** edgebanding machine in order to obtain a correct adhesion.

GENERAL SETTINGS

SPEED	25m/min
NOZZLE TEMPERATURE	490° for gluing on MDF panel 520° for gluing on chipboard panel
HOT AIR LINE PRESSURE	6-7 bar
FIRST ROLL PRESSURE (larger diameter)	2-3 bar
OTHER ROLLERS PRESSURE	2-2.5 bar

These parameters are only indicative and may require minor modifications.



Tel.: +34 961 597 242
www.cantisa.es
cantisa@cantisa.es