

Dear Valued Customer,

As the cooler mornings are now with us again, we would like to take the opportunity to remind our customers that it may be necessary to adjust edgebander settings and factory conditions to allow for the colder conditions and ensure the best possible edgebanding results.

Colder air temperature along with colder board and edging surfaces create more challenging conditions for hotmelt adhesives to do their job.

We would like to offer some suggestions which might assist in achieving optimum bonding during the winter months.

- **Edgebanding Machines:** always refer to recommended settings from your machine supplier. Generally speaking in colder conditions, hotmelt adhesives will perform better when operating at a slightly higher temperature (provided the adhesive is also suitable for that temperature).
 - **Glue Pot:** the actual glue temperature within the glue pot should be checked periodically using an independent temperature probe, to ensure the temperature gauge reading is correct.
 - **Machine Location:** avoid the possibility of cold breezes flowing onto the machine (near open doors etc) as this can have a negative effect on the performance of the adhesive.
- **Hotmelt Adhesives:** always refer to the Technical Data Sheets and recommendations made by your Adhesive supplier and use a Hotmelt adhesive suitable for your machine. Operating temperatures are generally relative to the machine speed, so please also refer to this information on the TDS for your Adhesive.
- **Edgebanding:** rolls should ideally be stored in closed cabinets or at least off cold concrete floors. The edgebanding rolls should ideally be warmed prior to application to promote optimum bond. This is generally achieved by hot air, heated fence or heat lamps near the infeed on the machine.
If possible and practical, schedule edgebanding processing for later in the day when temperatures have generally increased.

Should you have any questions or problems with edgebanding or adhesion, please do not hesitate to contact your Surteco Area Sales Manager who will be happy to assist.

BauschLinnemann

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SURTECO AUSTRALIA PTY LTD

ABN 35 092 690 232 • www.surteco.com.au • info@au.surteco.com

NSW 7-11 Penelope Crescent, Arndell Park • PO Box 6411 Blacktown BC NSW 2148 Australia
Phone Customer Service: +61 (0) 2 9421 0366 • Head Office: +61 (0) 2 9421 0300 • Fax: +61 (0) 2 8814 8000

VIC 5/3 Sahara Grove Carrum Downs VIC 3201 Australia • Phone: +61 (0) 3 9775 0533 • Fax: +61 (0) 3 9775 1822

QLD 13 Tombo Street, Capalaba QLD 4157 Australia • Phone: +61 (0) 7 3245 1881 • Fax: +61 (0) 7 3245 1476

WA 4 Lee Place, Perth Domestic Airport WA 6105 Australia • Phone: 1300 SURTECO • Fax: +61 (0) 2 8814 8000

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