EGR DECOR

StyleLex®

Edgeband Troubleshooting Guide

Luxury Covered Outdoor & Wet Are Panels
Australia & New Zealand

October 2026

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.	• Application of adhesive not sufficient • Room temperature too low • Edgeband material too cold (storage outdoors) • Hot-melt temperature too low • Feed rate too low • Contact pressure of applicator rollers too low
2. The edgeband can easily be peeled off by hand. Hot-melt adhesive remains on the chipboard. The hot-melt adhe sive surface is completely smooth (edgeband slides off).	• Board and/or edgeband too cold – Check hot-melt adhesive type – Check adhesive agent application
3a. The edgeband can be peeled off by hand. Most of the hot-melt adhesive remains on the edgeband.	• Temperature of board material too high due to previous process step (e.g. veneering)
3b. Glued joint is not closed (edge glueing machine).	• Contact pressure too low • Adhesive too cold – Raise application temperature, pre-warm board or increase feed rate • Edgebands have no, or inverse, pre-tension
3c. Glued joint is not closed (machining centre).	• Contact pressure too low • Edgeband has become too cold and cannot be squeezed • Restoring forces of edgeband material too high – Increase heater power or reduce feed rate – Increase geometry or use thinner edgeband material • Adhesive not machining centre compatible, heat adhesiveness too low • Adhesive does not harden quickly enough – Reduce the glue application temperature • Edgebands have no, or inverse, pre-tension
3d. Edgebands are only bonded in edge area.	• Contact pressure too low • Joint milling on board part hollow • Pre-tension of edgebands too high
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.	• Application of adhesive not sufficient as a result of incorrectly positioned glue applicator roller – Increase the quantity applied
5. Milling waves are visible.	• Feed rate too quick • Cut speed of milling cutters too low – Rework with draw blades and buffing station – Mill in counter direction – Increase number of blades on miller cutters – Increase speed

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6. For thick edgebands, the colour in the milling area lightens a little (stress whitening).	• Heat the milling area using a hot-air station (can be retrofitted) • Draw blade is too thick – Rework with buffing station – Reduce draw blade size (max. 0.1 - 0.2 mm)
7. Stress whitening indications for machining centre processing within radius.	• Edgeband has become too cold – Increase heater power or reduce feed rate – Increase geometry or use thinner edgeband material
8. Strong stringing of adhesive after application	• Lower application temperature – Clean glue part – Test other adhesive
9. "Mouse teeth" in the joint	• Increase quantity applied – Increase application temperature – Pre-warm board
10. Rupturing of the long edgebands after the cross-edging	• Only format and insert the board – Check the miller cutter to see if the penetration depth is OK – Reduce the amount of material removed or use other chipboards
11. Damage to the decor of the edgeband for machining centre processing	• Use special rubber rollers
12. "Dents" or "scratches" in the edgeband	• Clean the edgeband feeder – Clean the contact rollers and spray them with separating agent – Clean the scan shoes; if not better, inspect the scan shoes for damage and renew them if necessary
13. Rupturing or luting at ends of edgeband	• Have the mitre saw sharpened – Ask the tool supplier for a suitable tool
14. Rupturing at the top and bottom of edgeband	• Lower edgeband projection – Adjust temperature (to above 18 °C) of boards and edgebands the day before – Increase the room temperature and prevent draughts
15. Edgeband luted on copying	• Lower the number of blades – Regulate the speed – Mill edgebands in counter direction – Increase feed rate
16. 3D 2-in-1 offset in corner area	• Precise adjustment of the edgeband holding down clamp – Set edgeband projections to the minimum – Check edgeband for sabre shape

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