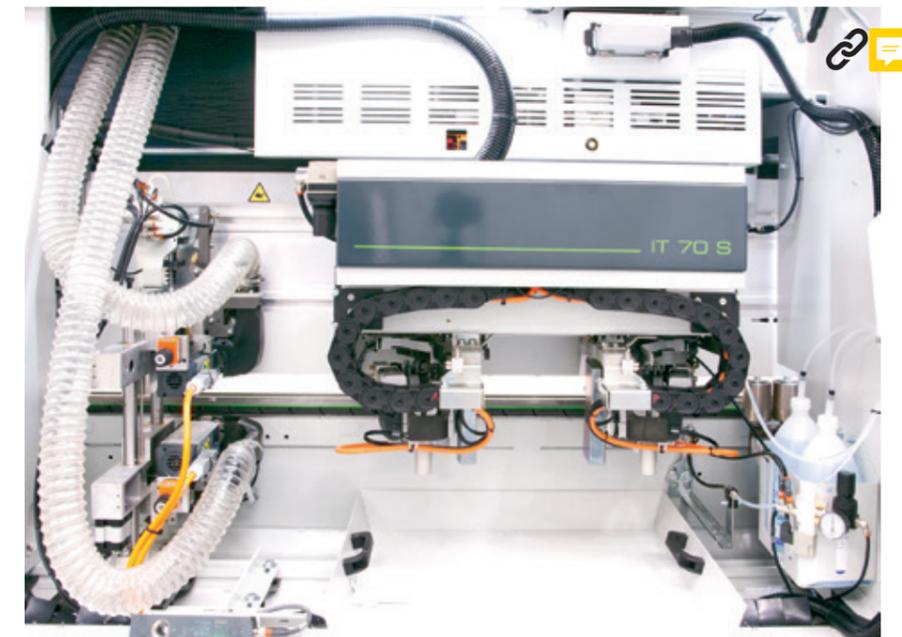
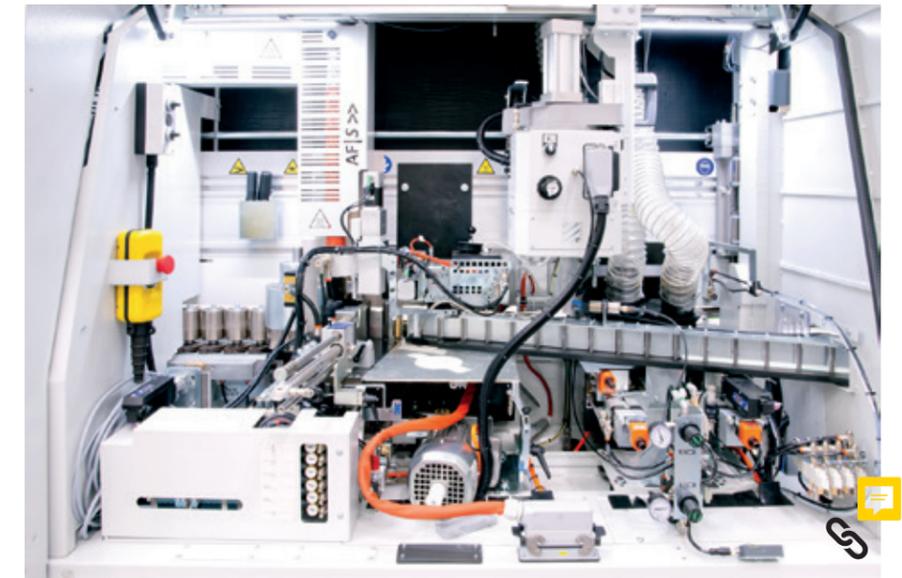


Main Image: The Biesse Stream A
Right: The Stream A can be equipped with both the hybrid glue head and Airforce for the application of laser edging tapes.



An edge on quality

Looking for that all-important invisible glue line? Biesse has a few clever units on its edgebanders that can help you achieve better-looking products.

The importance of an invisible, or near invisible glue line between edging tapes and panels has never been greater than it is today, especially if you are producing slab doors and fascias but for those who are super critical about their quality, how do you ensure you are getting the best from your machine? It's a question Biesse's designers and engineers have

pondered long and hard and what they've come up with is a raft of clever solutions that can be added to most machines in the Biesse range from the Akron 1300 up.

"The only true way to get zero glue line is to use an Airforce-type machine that releases the functional layer on a laser tape with heat," Malcolm Storey, Biesse UK's Edgbanding Brand Sales Manager told me.

"But when most people refer to a zero glue line, what they mean is usually something that is less visible than the standard glue line they are getting from EVA. We've introduced a number of changes to our machines that ensure a near invisible glue line:

"One of the big changes we've made to the Akron and Stream A ranges is the introduction of a hybrid glue head. With a hybrid glue head you can run EVA or PUR on the same machine rather than having separate glue tanks and you don't have to take anything off the machine to switch from one to the other.

"There are two types of hybrid glue head: a small one that takes 850gm in the pot and an extended version that takes 1.5 kilos. We combine the smaller glue head

with a pre-melting unit that feeds EVA or PUR as required so the head doesn't have to be quite so large.

"The new design of the head requires less maintenance. If an operator can maintain the glue head easily without taking it off the machine he is more likely to clean it more frequently rather than waiting until there is a problem before stopping the machine – and that's a major contribution towards achieving a better glue line.

"When you want to change your colour or glue type, there is a cleaning cycle in the program of the machine to make it easy. The unit heats up and when it reaches the temperature, there is a switch to rotate that opens the bottom of the glue head so the residue flows out of the hybrid pot into a

receptacle under the head. Once that's done, close it by rotating the switch and either apply a cleaning wax if you want to clean it right down or, if you are changing from EVA to PUR, just fill as required.

"The big plus from a customer's perspective is there is no cleaning of the glue head off the machine. Depending on how much adhesive there is in the pot, it takes no more than 15 minutes to change between adhesive types or colours. A lot of small to medium sized workshops are batch-size-one producers, so having the facility to change over on demand is very beneficial."

The hybrid glue head can also be combined with an NC-controlled glue gate that will enable you to regulate the quantity of glue on the coating roller relative to the

