ALUMINIUM EDGINGS
PROCESSING TIPS

Aluminium edging - delivered in rolls, 1 mm, 25 m rolls with a protective film

Width	23, 33, 42, 63 mm
Thickness	1 mm
Colours	010.1010. Aluminium matt and 010.1050 Stainless steel coloured

Width	23, 28, 33, 42 mm
Thickness	1 mm
Colours	010.1080. Aluminium high gloss

Width	23, 33, 42 mm
Thickness	1 mm
Colours	010.1020. Aluminium silver-coloured anodised brushed

Aluminium edging - straight lengths, 2 mm thick, 3 m long with protective film

Width	21, 27, 33, 40 mm
Thickness	2 mm
Colours	010.2010 Aluminium matt anodised

Technical Data

Material according to DIN EN 573-3	AlMg1
Hardness according to DIN	1/2 hard H14
Brinell hardness	HB 48
Protective film	PE film 50 60, not UV-resistant
Bonding agent	compatible with most gluing systems, especially PUR hotmelt adhesives
Environment	The aluminium supplied by us: ■ is flame-resistant ■ contains no ozone-depleting substances according to the current state of knowledge ■ contains no substances with heavy metals ■ contains no substances which may produce toxic or hazardous vapours when burnt ■ does not belong to the materials that can release toxic or water-polluting substances when leaching out ■ is anodised and therefore harmless from a medical and food law point of view
Storage	The aluminium edgings supplied by us, whether with or without primer, can be stored for a long time according to the current state of knowledge: ■ Storage at normal indoor climate ■ Shelf life with primer at least 1 year ■ Store in a cool place

Processing of Edgings from a Roll

The edgings can be processed with an edgebanding machine. A special bonding agent on the edgings guarantees a good adhesion between edging and substrate.

Machine Bonding

For an excellent bonding result, we recommend the use of PUR hotmelt adhesives. EVA hotmelts are suitable only to a limited extent; please carry out test bonds to check their suitability. Warm up the edgings to 40 °C in a veneer press or other heat source before processing. Milling will be easier if you wet a cloth with Teflon oil and apply a very thin layer on both milled ends of the edging. (possibly also the sensors)

Manual Bonding

For manual gluing, use REDOCOL Kantol greenline or, for particularly moisture-resistant bonds, Rakollit 280 + Hardener WS1i. Apply the adhesive with a toothed spatula and press with even caul sheets and high pressure.

Processing of Edgings in Straight Lengths

1. To cut the edging to the required length, apply Teflon spray to the (fine tooth) saw blade first.
2. Bonding: with REDOCOL MS Polymer
   Pressing time: 3 to 4 hours, depending on the material
3. Milling processing: apply teflon to the milling edge with the help of a wet cloth, then use a flush cutter or radius cutter to mill.
4. The milled edge should always be sanded with 220 grain; then clean with acetone or DD thinner and rub a thin layer of hard oil wax onto the surface for surface protection.