

# PROCESSING INFORMATION

## LINOLEUM EDGINGS

### Introduction

The linoleum edging is a surface material for the narrow surface of furniture and other interior surfaces. Our range includes all colours for the Desktop Furniture Linoleum. The edgings consist of renewable raw materials such as linseed oil, resin and wood powder as well as pigments. They are made from the same material as the Furniture Linoleum Desktop surfaces and can be easily applied to all standard wood-based boards, such as MDF, chipboard and multiplex.

### Product Characteristics

**Structure:** Linoleum edgings consist of two layers: the linoleum and a factory-applied surface protection. The first production step is the manufacture of the linoleum base compound from oxidised linseed oil and natural resin. Enriched with wood powder and colour pigments, the linoleum is applied to an impregnated backing paper via calendering process. After drying, a surface protection is applied, which gives the material its matt look. To acquire just the edging, the backing paper is removed again after production and maturing in a special process. This gives furniture with linoleum edgings an almost seamless look when combined with the same linoleum surface material.

**Quality:** As with almost all surface materials, there is a possibility that samples from different productions will show small differences in colour. This fact is to be taken into account for possible repeat orders and does not constitute a defect. During the last phase of the production process, a yellowish haze, the so-called drying room yellowing, may appear on the surface. This cannot be avoided with linoleum products due to the specific material and is particularly visible with light colours. However, it disappears completely when exposed to daylight and the linoleum regains its original colour. The duration of this process depends on the prevailing UV light intensity.

**Application areas:** the linoleum edging is an edging solution for furnishing objects. It can be used on both horizontal and vertical surfaces. Possible applications are the narrow surfaces on:

- desk tops / pads
- tables and shelves
- cabinets (doors, fronts, shelves, etc.)
- interior doors
- (adjustable) partitions
- wall panelling, surfaces in furniture making

The use of linoleum edgings on kitchen worktops and counters etc. is only possible to a limited extent due to the mechanical and thermal stress.

**Carrier material:** Linoleum edgings are a surface material that is applied to wooden baseboards. Frequently used substrate materials are MDF, multiplex, chipboard, etc. However, with chipboard, be sure that the centre layer is as finely chipped as possible so that individual chips and irregularities cannot be pressed through.

## Processing

Before processing, both the linoleum and the linoleum edgings should be stored at room temperature for some time to acclimatise. Linoleum edgings cannot compensate irregularities and unevenness. Particularly when exposed to oblique light or backlight, dirt particles and other impurities can therefore stand out on the upper side of the material and adversely affect the overall impression of the workpiece. To ensure a smooth surface, the back of the material and the top of the wooden board must therefore be absolutely clean.

**Bonding:** For machine processing on an edgebanding machine, the use of PUR hotmelt adhesive is recommended. Due to the lack of a paper backing, PUR is the right choice. For manual processing, a solvent-free contact adhesive should be used.

We recommend the PUR hotmelt adhesive REDOCOL Kantomelt PUR for machine application and the solvent-free edging glue REDOCOL greenline Kantol.

**Note:** If possible, always apply a test edging before starting the final production.

**Edging radius:** The radius of the linoleum edgings can basically be processed in the same way as with other edging materials. Our recommendation is to either round off the edgings or chamfer them. Remove fresh adhesive residues immediately and always protect the linoleum surface while doing so. A slight colour difference between the surface itself and the processed part at the edging may occur immediately after processing. However, this colour difference disappears over time when the edging is exposed to UV light.

**Instructions for processing with the edgebanding machine:** It is basically possible to process the linoleum edging with an edgebanding machine, although it is demanding. To do so, it is important to adjust the edgebanding machine optimally on all units. The use of radius scraper, surface scraper and buffing discs is not recommended.

## Processing Characteristics

Machining	Suitability
Cutting	good
Milling direction	conventional milling*
Pre-milling	good
Radius milling / Chamfering	good / good
Profiling	good
Scraper processing	not suitable
Buffing	not suitable
Bonding	PUR Hotmelt Adhesive
Polishing	not suitable
Stress whitening	none
Lacquering	not suitable
Setting pressure zone	Note the pressure**
Setting detaining device	give enough air***
Machining on BAZ processing centre	not suitable

\*Conventional milling is recommended for linoleum edgings.

\*\* Adjust the setting of the main and following pressure rollers according to the substrate; if the pressure is too high, there is a risk of the substrate being pushed through.

\*\*\* The retaining device must be set with sufficient air; if it is set too low the edging could jam and slide open.

## Storage

Store the linoleum edgings dry, airtight and protected from light in the packaging provided on delivery. The packaging prevents the goods from drying out. Do not place any sharp or heavy objects on the edging and prevent dirt particles from getting between the individual layers of the edging roll. For optimal further processing, we recommend storing the linoleum edging at an indoor climate (20°C, < 70 % relative humidity).

## Cleaning

When it comes to cleaning the linoleum edgings, the same instructions apply as for cleaning the Forbo Desktop surface material.

We recommend our REDOCOL greenline finish cleaner 61 for cleaning.

## Disposal

In view of the high calorific value, thermal utilisation of the product is essentially possible. Remnants of linoleum edgings can be incinerated together with chipboard residue in systems approved for this purpose. Even particle boards with applied linoleum edgings can be disposed of in this way. There is no need for time-consuming sorting of waste or separation of edgebanding and board material.