

PANEL CUTTING AND MODIFICATION

Handle panels with care and use a protective cushion when cutting. Use of a template or guide will aid in cutting and protect the veneer edges. The following tools are recommended for cutting and machining:

Table saw - with a sharp carbide tooth blade (cut face up)

Miter saw - with a sharp carbide tooth blade (cut face up)

Jig saw - with medium tooth blade (cut face down)

Hole saw - (cut face up)

Do NOT use a drywall router or roto zip.

MATERIALS NEEDED

- Edgebanding (enough to allow for overhang on each panel edge)
- Clothing iron and cotton or flannel insulating cloth (for self-adhesive edgebanding)
- Hand held flush trimming tool (or router with flush cutting bit)
- Sanding block and sandpaper

EDGEBANDING

Edgebanding MDF core or acoustical core panels is necessary when trimming panels to fit restricted locations such as the edge of walls, the edge of ceilings around fixtures, and projections. **Please ensure that any panels cut are done so as per Install Instructions in the approved shop drawings sent with each shipment (if shop drawings can not be located, contact Navy Island) .**

EDGEBANDING - SELF-ADHESIVE

1. Use a scissors to cut the banding approx. 1" longer than the length of the panel receiving the banding.
2. Set the iron to "medium" or "cotton."
3. Hold up the panel edge to be banded so that the iron is used horizontally.
4. If using pre-finished edgebanding, use cotton cloth between banding and iron to prevent damage to the finish.
5. Start at one end of the banded edge and work the iron slowly across the banding.
6. Keep the iron moving to avoid burning the banding.
7. A small bead of adhesive is visible once it starts to activated.
8. To ensure a good bond, follow the iron with a clean, smooth block of wood, applying pressure until the adhesive hardens.
9. If the banding edge lifts, use a block of wood at an angle to press the edge back in place.
10. Trim the face and edges back with the flush trimming tool or flush cutting router bit, working the tool with the direction of the grain to avoid tear-out.
11. Lightly sand the corners and top and bottom edges of the panel banding to eliminate excess adhesive.
12. If using unfinished banding, it can now be stained and finished.

EDGEBANDING WITH AN EDGEBANDING MACHINE**When applying edgebanding using a edgebanding machine**

SoundPly panels have a mineral wool or fiberglass substrate which is more compressible than solid core panels. Ensure the tension on the top pressure rollers is reduced as much as possible while still applying enough pressure to ensure the panel moves through the machine without getting hung up on the trim stations. Too much pressure will result in the edgebanding being applied unevenly and the corners of the panel getting crushed.

If your edgebander has a pre-mill station, do NOT use it as it will cause the fibers in the core to tear-out.

Most edgebanders utilize one of two types of glue applicator stations. The first and most common type utilizes a glue pot with roller applicator. The second most common type is a nozzle applicator, which is most common to Holzher edgebanders. Edgebanders with the nozzle applicator can use the same adhesive to apply edgebanding to SoundPly as they do to MDF or PB.

If your edgebander has a glue pot with a roller applicator, use Jowatherm 282.20/21 - www.jowat.com or a glue with a viscosity of approx, 30,000. This adhesive will work better at a higher temperature.

Set the temperature to 160°C or 320°F. Operating at a lower temperature will result in the adhesive being too “sticky”, this will result in the adhesive on the doctor roll absorbing the fibers from the core and clogging up the applicator.

It is recommended to keep the speed of the edgebander below 20 meters (66 feet) per minute. Going too fast will prevent the higher temperature glue from properly setting before the panel engages with the trim stations. This will result in the edgebanding not adhering to the panel.

You may use the front and back trim stations when edgebanding square panels. If edgebanding trapezoidal or triangular shaped panels, disengage the front and back trimmer and use a knife to trim the excess overhang when the panel exits the machine.

Set the top and bottom trim stations so that the movement of the trim heads using tracer wheels is at a minimum to prevent damage to panel.