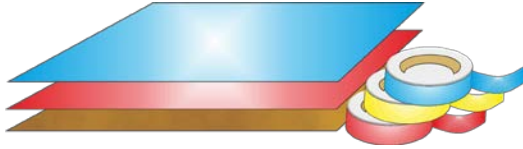


Edges & Laminating

Accurate application and costing of edge-banding materials



The program provides a full set of options to deal with with edged, trimmed and laminated parts. A wide variety of edging methods are:-

- Tape
- Laminate strips
- Solid lipping
- Postform edging
- Bullnose edging
- Laminate front and back
- Core trimming (cutting back before edging)
- Edge before laminating

The edging requirement is set at the part list and can be set for each part. The program automatically calculates the correct cutting sizes required to meet the finished size with edging set at the part list.

Sizes are entered (or imported) via the Part list.

These are typically the finished sizes but where there is edging and laminating the finished size has to be adjusted to the cut size before being sent to the saw.

Part list - Office units										
File Edit View Optimise Help										
Title Office units Opt DEFAULT Saw DEFAULT										
	Description	Material	Length	Width	Quantity	Grain	Edge Left	Edge Right	Face Lamin...	Inf
Global										
1.	F-CUPBOARD-TOP	MFC18-BEECH	700.0	350.0	6	Y	BEECH...	BEECH...		
2.	F-CUPBOARD-SIDE	MFC18-BEECH	332.0	790.0	12	Y	BEECH...	BEECH...		
3.	F-CUPBOARD-BASE	MFC18-BEECH	700.0	350.0	6	Y	BEECH...	BEECH...		
4.	F-CUPBOARD-DOOR	MFC18-BEECH	330.0	790.0	12	Y				
5.	F-CUPBOARD-SHELF	MFC18-BEECH	635.0	340.0	6	Y				
6.	F-CUPBOARD-BACK	HARDBOARD-4MM	665.0	800.0	6	N				
7.	F-CAB-TOP	MFC18-BEECH	450.0	392.0	5	Y				
8.	F-CAB-SIDE	MFC18-BEECH	370.0	585.0	10	Y				
9.	F-CAB-BASE	MFC18-BEECH	450.0	392.0	5	Y				
10.	F-CAB-BACK	HARDBOARD-4MM	420.0	590.0	5	N				
11.	F-CAB-DRW-FRONT	MFC18-BEECH	445.0	290.0	10	Y	BEECH...	3PE-22MM		
12.	F-CAB-DRW-SIDE	MEL-CHIP-15MM	355.0	260.0	20	N				
13.	F-CAB-DRW-BACK	MEL-CHIP-15MM	380.0	240.0	10	N				

Edging - Part list

A set of extra fields (called Information boxes) extend the Part list to allow for the entry of the edging code for each edge of each part. For example, in the above example items such as Top, Side and Base have edging material on some of the edges.

The correct cutting sizes are produced automatically.

	Description	Material	Length	Width	Quantity	Grain	Edge Left	Edge Right	Face Lamin...	Inf
Global										
1.	F-CUPBOARD-TOP	MFC18-BEECH	698.0	350.0	6	Y	BEECH...	BEECH...		
2.	F-CUPBOARD-SIDE	MFC18-BEECH	330.0	790.0	12	Y	BEECH...	BEECH...		
3.	F-CUPBOARD-BASE	MFC18-BEECH	698.0	350.0	6	Y	BEECH...	BEECH...		
4.	F-CUPBOARD-DOOR	MFC18-BEECH	330.0	790.0	12	Y				
5.	F-CUPBOARD-SHELF	MFC18-BEECH	635.0	340.0	6	Y				
6.	F-CUPBOARD-BACK	HARDBOARD-4MM	665.0	800.0	6	N				
7.	F-CAB-TOP	MFC18-BEECH	450.0	392.0	5	Y				
8.	F-CAB-SIDE	MFC18-BEECH	370.0	585.0	10	Y				
9.	F-CAB-BASE	MFC18-BEECH	450.0	392.0	5	Y				
10.	F-CAB-BACK	HARDBOARD-4MM	420.0	590.0	5	N				
11.	F-CAB-DRW-FRONT	MFC18-BEECH	443.0	290.0	10	Y	BEECH...	BEECH...		
12.	F-CAB-DRW-SIDE	MEL-CHIP-15MM	355.0	260.0	20	N				
13.	F-CAB-DRW-BACK	MEL-CHIP-15MM	380.0	240.0	10	N				

Edging - Cutting list

For example, a finished length of 332.0 mm requires a cutting size of 330.0 mm if the part is edged by (2mm) tape on each length edge.

The part list can include a field for describing the Edge diagram.

This field can be used to set how adjoining edge pieces butt on to each other or whether they are mitred.

Edging diagram

This can be used when printing labels for edging to show on the label (at the Edgebander) exactly how the edging is applied.

Ref: Example 2
Part Code: CAB-DOOR-L
Length: 558.0
Width: 418.0
Thickness: 18.0
Total Quantity: 120
Date: 08/05/2012
Edging details:
Top: BEECH-TAPE-22MM
Btm: BEECH-TAPE-22MM
Left: BEECH-TAPE-22MM
Right: BEECH-TAPE-22MM

Edging diagram label

The edging diagram can be included on each part label to show clearly how the edging is produced. This is available with:-

- Printing labels at the Office
- Printing labels at the Saw (Online label PC)
- Printing labels at the Saw (Cadmatic saw controller)

For the Cadmatic the information is passed to the Cadmatic controller on transfer of data to the saw.

- With the Parts & Labels module the edging requirements can be printed on a label as a bar code and used for processing at the edgebander after cutting.

Laminating



The part list can also include fields for laminating one or both sides of a part.

Part list - Office units									
File Edit View Optimise Help									
Title Office units Opt DEFAULT Saw DEFAULT									
Global	Description	Material	Length	Width	Quantity	Grain	Face Laminate	Back Laminate	Inf
1.	F-CUPBOARD-TOP	MFC18-BEECH	700.0	350.0	6	Y	BEECH-L...	BEECH-L...	
2.	F-CUPBOARD-SIDE	MFC18-BEECH	332.0	790.0	12	Y			
3.	F-CUPBOARD-BASE	MFC18-BEECH	700.0	350.0	6	Y			
4.	F-CUPBOARD-DOOR	MFC18-BEECH	330.0	790.0	12	Y			
5.	F-CUPBOARD-SHELF	MFC18-BEECH	635.0	340.0	6	Y			
6.	F-CUPBOARD-BACK	HARDBOARD-4MM	665.0	800.0	6	N			
7.	F-CAB-TOP	MFC18-BEECH	450.0	392.0	5	Y	BEECH-L...	BEECH-L...	
8.	F-CAB-SIDE	MFC18-BEECH	370.0	585.0	10	Y	BEECH-L...	BEECH-L...	
9.	F-CAB-BASE	MFC18-BEECH	450.0	392.0	5	Y			
10.	F-CAB-BACK	HARDBOARD-4MM	420.0	590.0	5	N			
11.	F-CAB-DRW-FRONT	MFC18-BEECH	445.0	290.0	10	Y			
12.	F-CAB-DRW-SIDE	MEL-CHIP-15MM	355.0	260.0	20	N			
13.	F-CAB-DRW-BACK	MEL-CHIP-15MM	380.0	240.0	10	N			

Laminates - part list

The program automatically adds extra items to the cutting list (cutting requirement) to allow for the laminate pieces required.

The laminate size is adjusted to allow for trimming as required.

Cutting list - Office units

File Edit View Optimise Help

Title Office units Opt DEFAULT Saw DEFAULT

	Description	Material	Length	Width	Quantity	Grain	Face Laminate	Back Laminate	Inf
Global									
1.	F-CUPBOARD-TDP	MFC18-BEECH	698.0	350.0	6	Y	BEECH-L...	BEECH-L...	
2.	L0001	BEECH-LAM	718.0	365.0	6	Y			
3.	L0001	BEECH-LAM	718.0	365.0	6	Y			
4.	F-CUPBOARD-SIDE	MFC18-BEECH	330.0	790.0	12	Y			
5.	F-CUPBOARD-BASE	MFC18-BEECH	698.0	350.0	6	Y			
6.	F-CUPBOARD-DOOR	MFC18-BEECH	330.0	790.0	12	Y			
7.	F-CUPBOARD-SHELF	MFC18-BEECH	635.0	340.0	6	Y			
8.	F-CUPBOARD-BACK	HARDBOARD-4MM	665.0	800.0	6	N			
9.	F-CAB-TOP	MFC18-BEECH	450.0	392.0	5	Y	BEECH-L...	BEECH-L...	
10.	L0007	BEECH-LAM	470.0	407.0	5	Y			
11.	L0007	BEECH-LAM	470.0	407.0	5	Y			
12.	F-CAB-SIDE	MFC18-BEECH	370.0	585.0	10	Y	BEECH-L...	BEECH-L...	
13.	L0008	BEECH-LAM	390.0	600.0	10	Y			
14.	L0008	BEECH-LAM	390.0	600.0	10	Y			

Office units / NUM

Laminates - cutting list

Edging summary and costs

The edging gives full details of the edging requirements including the costs.

Review runs

File Edit View Settings Summaries Stock Help

Edging summary Example of edging and laminates

Edging and laminates:///default/?default/SQ [Rules:CL,BL]

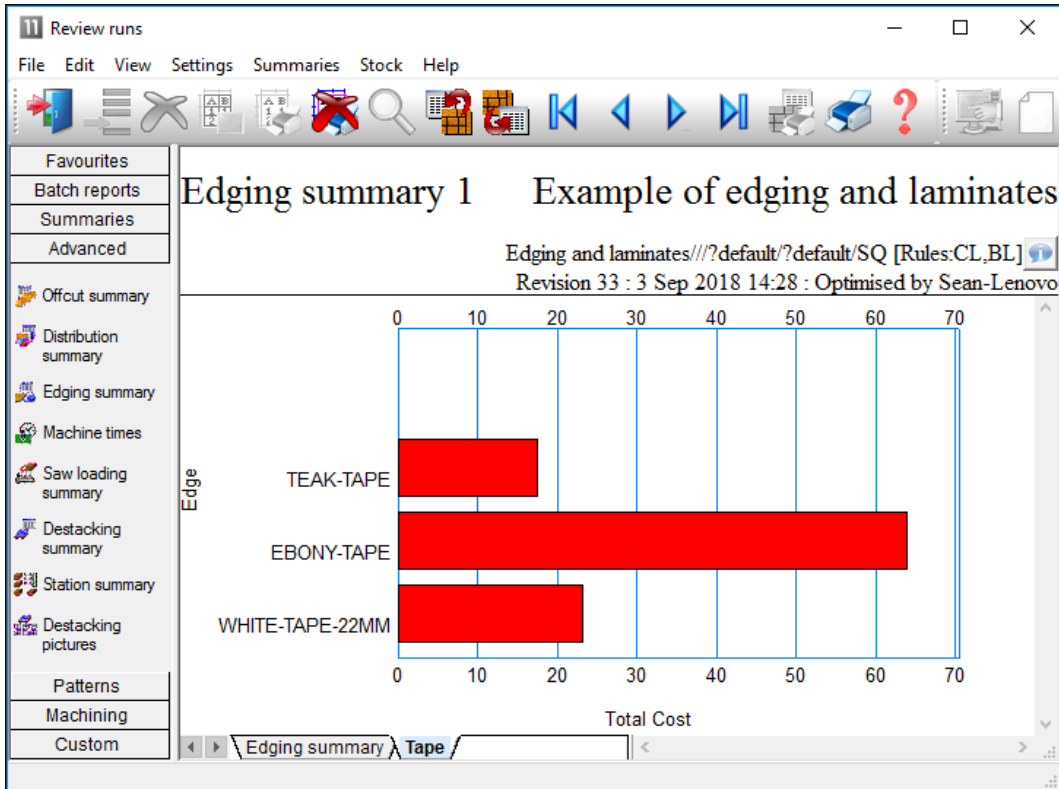
Revision 33 : 3 Sep 2018 14:28 : Optimised by Sean-Lenovo

Code	Description	Material	Thickness	Cost	Total	Total
				m	m	Cost
WHITE-TAPE-22MM	White PVC Tape 22mm		1.0	0.550	42.36	23.30
TEAK-TAPE	Teak PVC Tape 22mm		1.0	0.840	21.00	17.64
EBONY-TAPE	Ebony PVC Tape 22mm		1.0	0.840	76.20	64.01
Total						104.95

Edging summary /

Edging summary

The Edging summary can include a custom graphic representation of the data.



Edging summary - chart

The printed part costing report includes the cost of edging material and the edgebander costs.

Part costing - full						Edging example		
No	Code / Description	Material / Description	Length	Width	Quantity	Part costing - full		
					Time	Use	Rate Cost	
1.	CVR/TP Edge Btm: BEECH-TAPE-22MM Finished size: 920.0 x 420.0 Edgebander: N/A	MFC18-BEECH Edge Top: BEECH-TAPE-22MM Part graining: Grained	920.0	420.0	1			
	CVR/TP	MFC18-BEECH	919.0	418.0	0.384		3.649 1.402	
	BEECH-TAPE-22MM	Beech PVC Tape 22mm			2.320		0.720 1.670	
	Saw				0:50	0.014	50.000 0.697	
	Edgebander				1:20	0.022	30.000 0.663	

						Total cost :	4.432	
2.	FRT/END Edge Top: BEECH-TAPE-22MM Finished size: 750.0 x 420.0 Volume: LOW Part area m2: 0.3 Edgebander: N/A	MFC18-BEECH Edge Left: BEECH-TAPE-22MM Part graining: Grained	750.0	420.0	2			
	FRT/END	MFC18-BEECH	750.0	419.0	0.314		3.649 1.147	
	BEECH-TAPE-22MM	Beech PVC Tape 22mm			0.770		0.720 0.554	
	Saw				0:44	0.012	50.000 0.607	
	Edgebander				0:26	0.007	30.000 0.217	

						Total cost :	2.526	
3.	FRT/TOP Edge Btm: BEECH-TAPE-22MM Finished size: 690.0 x 420.0 Edgebander: N/A	MFC18-BEECH Edge Top: BEECH-TAPE-22MM Edge Left: BEECH-TAPE-22MM Part graining: Grained	690.0	420.0	2			
	FRT/TOP	MFC18-BEECH	689.0	418.0	0.288		3.649 1.051	
	BEECH-TAPE-22MM	Beech PVC Tape 22mm			1.860		0.720	
	Saw				0:41	0.011	50.000	
	Edgebander				1:12	0.020	30.000	

						Total cost :		

Edging - part costing

The operational details and costs of each Edgebander are set up in the Edging parameters and the Machining rate parameters. These include options such as:-

- Overlap for edging
- Gap between parts
- Edgebander speed
- Double sided or not
- ...



Edging library

The details of the edging materials and operations are set up in the Edging library. This can be customised to match many different edging methods, for example, whether edging is applied before laminating, whether a core trim is taken, the type of edging ...

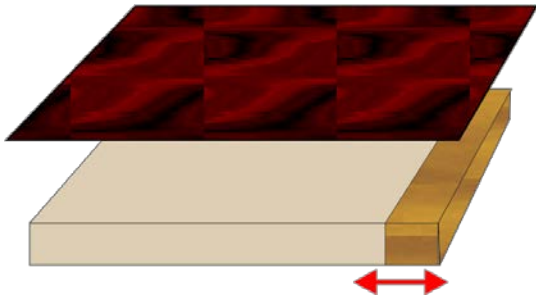
Edging library									
Code	Description	Material	Grain	Fu...	Thick...	Core...	Cost	Edge first	
▶ ASH-TAPE-22MM	Ash PVC Tape 22mm		N	1	1.5	0.0	0.750	N	
BEECH-LAM	Beech Laminate		Y	3	1.0	0.0	1.450	N	
BEECH-TAPE-22MM	Beech PVC Tape 22mm		N	1	1.0	0.0	0.720	N	
BULLNOSE	Bull nosed edge		N	5	0.0	0.0	0.000	N	
CORE-TRIM	Oversize cutting		N	0	0.0	20.0	0.000	N	
EBONY-LAM	Ebony Laminate	EBONY-LAM-1MM	Y	3	1.0	0.0	1.450	N	
EBONY-TAPE	Ebony PVC Tape 22mm		N	1	1.0	0.0	0.840	N	
GREEN-TAPE-22MM	Green PVC Tape 22mm		N	1	1.0	12.0	0.550	N	
LBROWN-TAPE	Light Brown Tape		N	1	1.0	0.0	0.730	N	
MAHOGANY-LIP	Solid Mahogany lip		N	2	25.0	10.0	1.850	N	
OAK-LAM	Oak Laminate	OAK-LAM-1MM	Y	3	1.0	0.0	1.360	N	
OAK-TAPE-22MM	Oak PVC Tape 22mm		N	1	1.0	0.0	0.840	N	
POSTFORM	Postformed edge		N	4	0.0	0.0	0.000	N	
RED-TAPE-22MM	Red PVC Tape 22mm		N	1	1.0	0.0	0.750	N	
TEAK-LAM	Teak Laminate	TEAK-LAM-1MM	Y	3	1.0	0.0	1.400	N	
TEAK-TAPE	Teak PVC Tape 22mm		N	1	1.0	0.0	0.840	N	
WHITE-TAPE-22MM	White PVC Tape 22mm		N	1	1.0	0.0	0.550	N	
*									

Edging library

For example, where a core trim is specified, this indicates that the core material is trimmed first before edging is applied. This is quite common, for instance with doors, where solid wood edges are often applied before laminating.

- Where there are a large number of different laminates for example with laminate colours the Board library can be used instead of the edging library for describing the laminates - this is often more convenient for sheet laminates.

The core trim, for example, allows for the removal of core material ready for solid wood lipping.



Lipping

The laminate size is automatically adjusted to take account of the lipping.



Edging parameters

The tolerances and settings for applying edging and laminates are set via the Edging parameters (*Main screen - Parameters - Edging*).

Edging parameters

Laminate Edging Help view >>

Set the parameters for laminate use

Range
0 - 999
Millimetres

Overlap for laminates: On laminate length (total)

Overlap for laminates

- On laminate length (total) 20.0
- On laminate width (total) 15.0

Core oversize for laminating

- On core length (per edge) 0.0
- On core width (per edge) 0.0

Add to laminate size

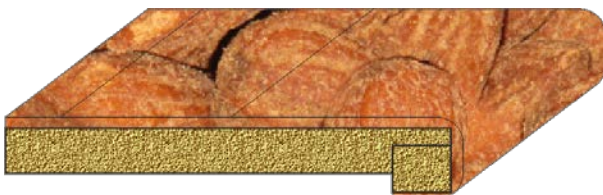
Laminate overlap per edge

- On bull nosed edges 25.0
- On post formed edges 25.0

OK Print Help Cancel

Edging parameters

This includes the details for more complex edges such as Post form and bullnose edges.



Summary of Edging & Laminating

Maximum items in library	99999
Maximum length of edge code	25
Maximum laminates in board library	Unlimited
Edges	•
Laminates	•
Costing	•
Edging diagram with labels	•
Edging Summary	•