

## GENERAL INFORMATION REGARDING FINISHING OF SPECIAL EMBOSSING

The following points summarize the results of our experience, together with a collaboration with IMA. They should be considered as a guideline, which could be, anyway, furtherly improved and modified.

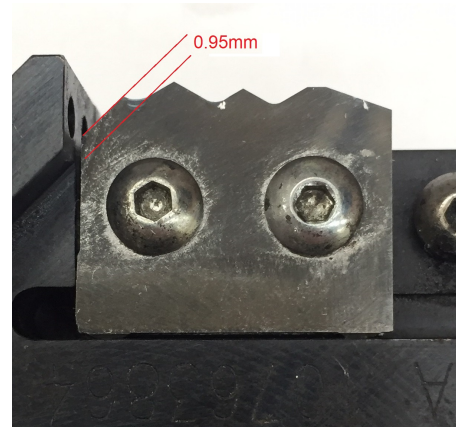


- It is important to preserve the surface of the panel: the panels with special embossing should be worked keeping sufficiently far the tools from the joint between the edge band and the panel itself;
- Often the multi-profile scraper is equipped with two knives and connected with the double tracing roller (above the panel). The idea is to copy these panels with only one tracing roller (the second must be vertically raised). A suggestion is to use a single knife, in order to have a more direct control. It is recommended a radius larger than the edge band thickness: i.e. with an edge band thickness 1mm, use 2mm radius;
- In addition, the glue scraper should work only with the second knife (if installed on your machine), which normally has a wider angle with respect to the first knife. In this case the horizontal tracer, should remain inserted;
- Laser gluing or PU gluing, instead of EVA gluing, significantly help to avoid that some glue remains on the surface and between the ridges of the embossing;
- As an alternative to the single knife on the multi-profile scraper, it is possible to make a change to the geometry of the tool, by removing the final part of the radius. In this way, the exit of the tool does not work on the embossing. See the attached pictures below.

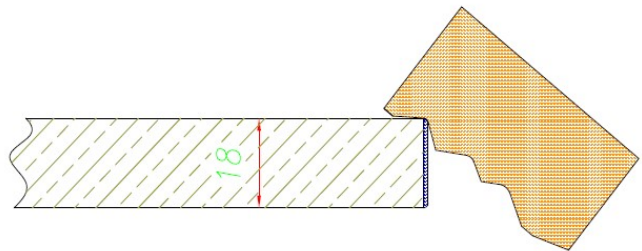
Picture of the original tool geometry, to be modified.



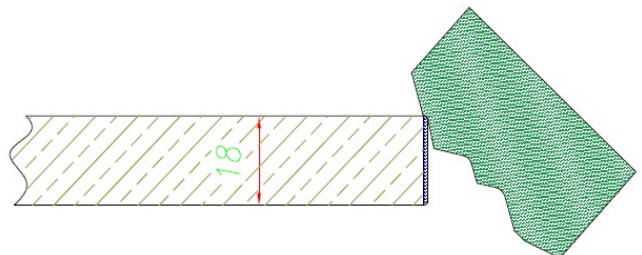
Picture of the modified tool geometry. A part of the radius of the tool has been removed. The remaining part of the 2mm radius measures 0,95 mm after the cutting.



Scheme of the unmodified tool working on the panel.



Scheme of the modified tool working on the panel.



Lissone 19/05/2020  
Dr Stefano Monti  
R&D Manager