

KANTEN



NEWS

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DÖLKEN

KUNSTSTOFFVERARBEITUNG

A SURTECO COMPANY

Folding Edge – the plastic edge that you can fold

Plastic edges are predominantly used for finishing off the level narrow surface of a board. Due to their flexible material characteristics, plastic edges can also be processed on curved boards, with excellent results.

In the edgebanding of angled surfaces however, other products are generally used, such as paper edges, which can be formed at the relevant position. Another option is profiles that have already been extruded to fit. With the new Folding Edge from Doellken there are now folding edges made from plastic.

Edges that just fold

The edgeband is provided on its underside with one, two or more V-shaped grooves. At these points it can be folded inwards or outwards to whatever degree is needed.

A particular advantage, known from conventional edges, is that the Folding Edges are supplied on a roll. Unlike equivalent profiles that come in length form, this is a major



Used in fold edging: The Doellken Folding Edge!

advantage, which comes to the fore during handling and above all processing.

At the same time, depending on the thickness of the edge, an elegant

and pleasant to the touch radius can be produced where it joins with the board.

On handle-less fronts the Folding Edge is the ideal edge solution.



A wide variety of applications

Wherever a recess needs edge-banding, the Doellken Folding Edges can be used. The Folding Edge is ideal for use on doors in particular.

In the kitchen design industry the Folding Edge has application for instance on handle-less fronts with a rebate, which act as a recessed handle.

The Folding Edge is also particularly advantageous on chamfered fronts, which are then fully varnished. This does away with time-consuming

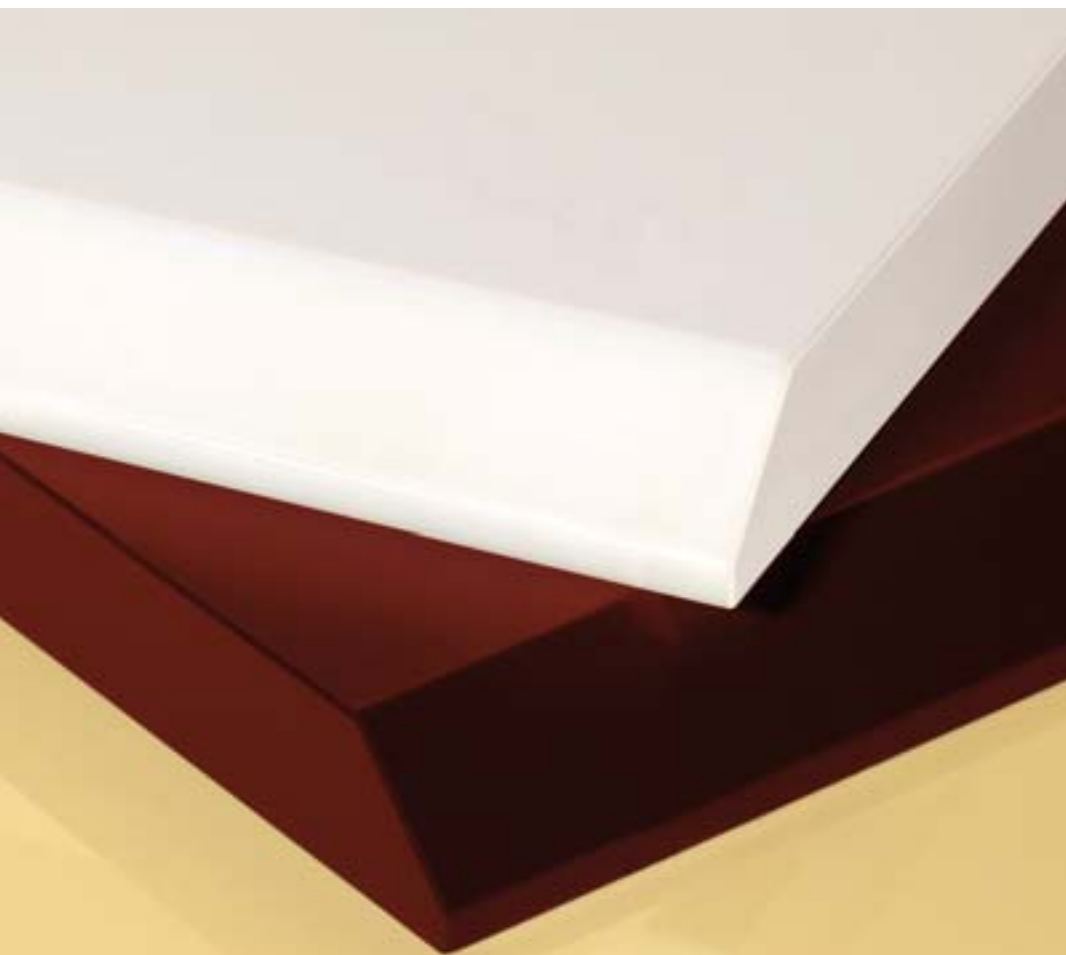
filling of the open narrow surfaces. For office furniture the Folding Edge is also used on desks with angled surfaces.

It is the perfect solution for providing a number of narrow surfaces with one and the same edge.

Available tailored to order

As with all the Doellken edges, the Folding Edge can also be supplied in just about any finish and any standard size. Naturally the V-shaped grooves can also be notched into the edgeband to suit the requirements of the individual customer.

*Angled surfaces are fully enclosed by the Folding Edge.
These can then be easily varnished.*



In a Word

Dear Reader,

we start 2007 with some technically challenging and decorative edge solutions for a wide range of applications, along with some clever stock concepts.

Here of course we have an eye to current trends, such as that, for example, of “frameless lightweight boards”. We have developed a suitable supporting edge – the Doellken Bonding Edge – especially for this, enabling economic edgebanding of this type of board.

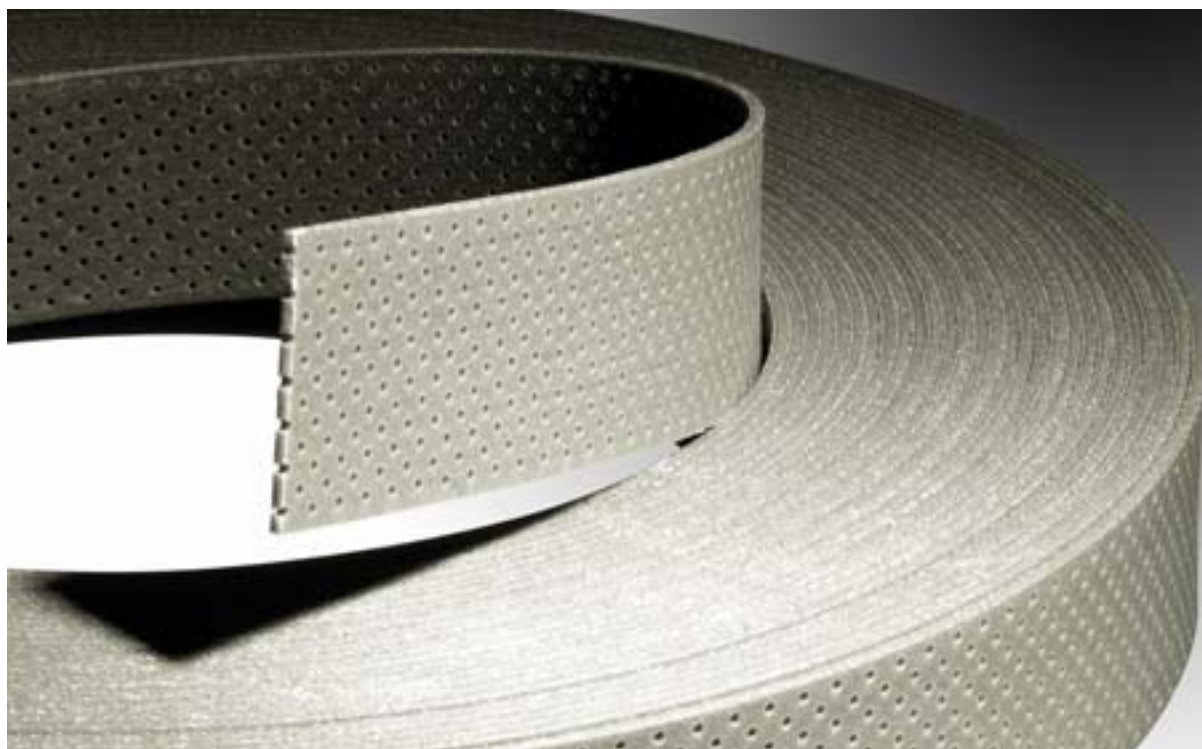
An additional technical highlight is a folding thermoplastic edge on a roll: This is the Doellken Folding Edge, which is used predominantly in edgebanding recessed areas.

As regards the current trend for high glosses, we are now offering popular unicolours ex-stock. Along with ready availability, here the wide selection of edge width is the great advantage. In contrast to glass like surfaces, we have recently developed 3D edges that have the additional quality of a matt surface and are particularly suited for use with real veneer boards.

As you can see, there’s a lot happening at Doellken. Where functional design-oriented products and competitive concepts are concerned, we’ll be there for you in the future too.

Your Doellken-Team

Edge solutions for Lightweight Boards



Design in furniture construction and the fitting out of interiors is currently influenced by bulky furniture items of solid appearance. At the same time, there is a demand here for lightweight products resulting in a reduction in transport and handling costs and permitting a certain amount of tailored design.

Here frameless lightweight boards – in the main honeycomb versions – provide the answer. Some board manufacturers, such as Egger, are adding an added dynamic to the field with new products such as the “Egger-Eurolight”.

As a result, there is a demand here on manufacturers of complementary

products to develop the relevant solutions.

Doellken has devoted considerable time and energy to the challenge of edgebanding honeycomb lightweight boards, carrying out a development project. After a series of successful trials, an edge solution is due to be presented for the first time at ZOW, and it will very soon be ready for production.

Lightweight boards up to thicknesses of 50 mm, which also have decks of 8 mm, can be edgebanded with any Doellken edge from 2 mm on.



Edgebanding as in the past

Along with its decorative finish, the edge, depending on the design of the lightweight board, must also have a securing or supporting function, so that processing can run without any problems.

What edge is to be used in the final instance depends essentially on the board thickness and the thickness of

the cover layers (decks) that cover the honeycomb core from above and below.

If the decks have a thickness of 8 mm, then boards of up to 50 mm can easily be processed with conventional Doellken edges. However, an edge thickness of at least 2 mm must be used to ensure problem-free processing, in particular when profiling. As a rule the following applies: Edge thickness increases with board thickness.

Bonding Edge: Edge with support function

On boards with decks of less than 8 mm, the Bonding Edge from Doellken is used as well as the decorative edges. This innovative supporting edge is the economic way of stabilising the board, and then providing it with a decorative edge finish by way of a follow-up.

The Bonding Edge from Doellken is made of plastic and thereby meets the demand for weight reduction in furniture. Due to the special, polyolefin material recipe, the supporting edge offers sufficient stability at the same time as providing flexibility.

For this reason it is also ideal when used on radius processing.

In the future the Bonding Edge will be supplied on a roll just like any other edgeband, and then machine processed. For this, a single groove is milled in each of the decks, in which the Bonding Edge is then inserted.

Unlike other supporting edges on the market, the Bonding Edge from Doellken has a further advantage – it is fully perforated. When the decorative edge is glued on, the adhesive penetrates the holes of the Bonding Edge and thereby achieves very secure anchorage of the two edges and also with the honeycomb core. Also, when gluing the Bonding Edge to the decks of the board, the perforation allows even greater adhesion.

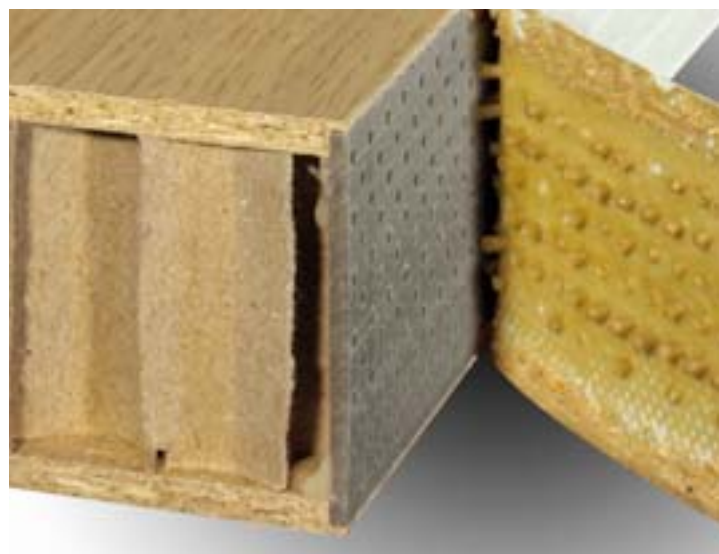
This is why Doellken is your innovative partner for technically challenging edge solutions.



Lightweight boards with 4 mm decks: This is where the Doellken Bonding Edge comes into play. The supporting edge is inserted in grooves that are pre-milled.

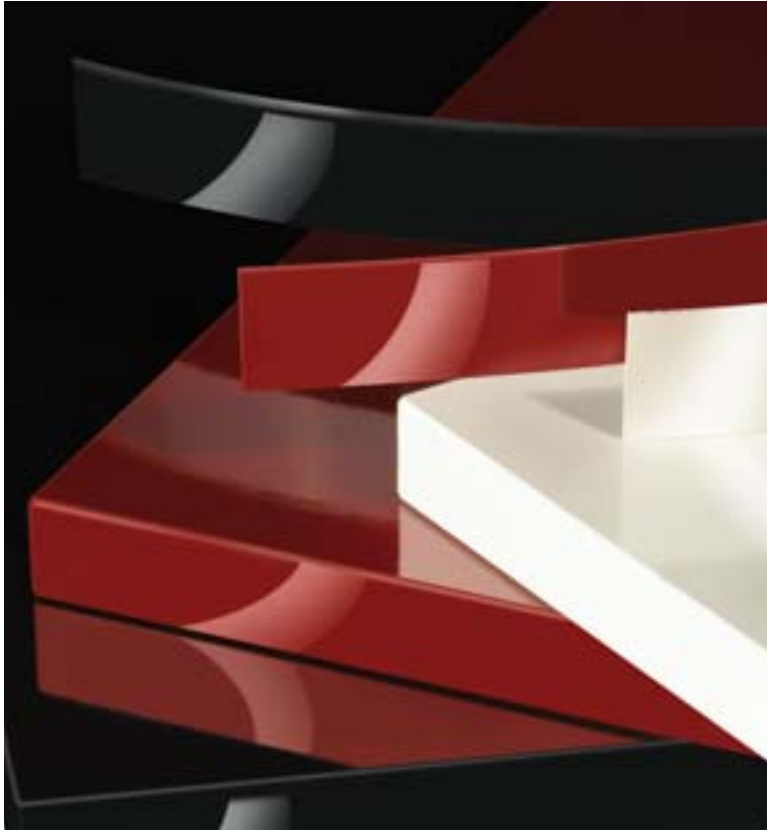


The decorative edge is then applied to the Bonding Edge.



Due to the perforation on the Bonding Edge, the adhesive bonds perfectly with the decorative edge and the honeycomb core.

High gloss edges ex-stock

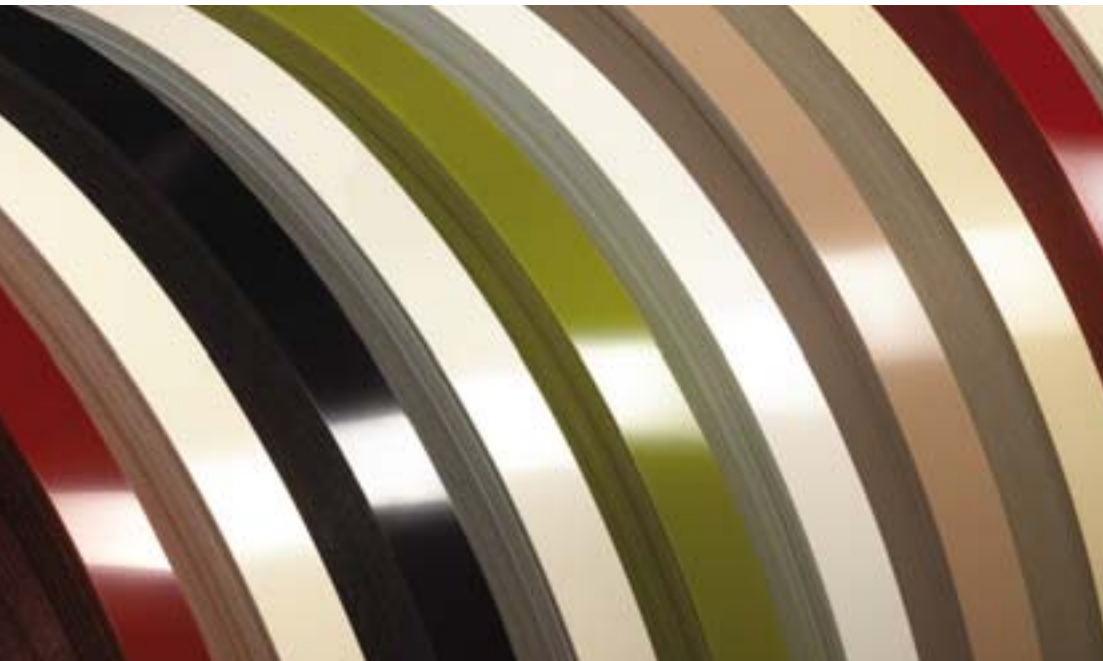


After processing, the board and edge appear as one.

The trend towards high gloss furniture concepts continues. Once again elegant glass like surfaces are to be found in just about every living area.

To keep up with this, there is a growing demand from the industry and trade for matching edgeband products and stock concepts.

The programme includes the latest trend colours in high gloss.



Gloss without varnish

A production process developed by Doellken now makes it possible to manufacture high gloss unicolour edges in ABS without the use of any high gloss varnish. Its particular advantage is primarily the homogeneity of the material: The base material and the surface are the same. This is evident above all when it comes to processing, when, for instance, the edge is milled, and the glossy surface comes away, revealing the base material. Once polished, the radius and visible side of the edge have the same colour and the same gloss. The finished piece of furniture therefore appears as if cast en bloc.

Gloss ex-stock

With the new stock programme, the most common unicolours are now readily available. To begin with, the selection covers 10 trend colours from Ferrari red via apple green to cappuccino. The stocked edgebands, which are all provided with protective film, come in a thickness of 1.3 mm.

When it comes to edge width, on the other hand, there is a relatively wide range of choice.

This means that the programme can always offer the right width for use on fronts, carcasses, worktops and leg supports. Naturally for larger quantities, other colours and thicknesses can be tailor-made to order.

3D Edge for wooden matt surfaces



an increasing number of manufacturers require a high quality edge solution with the abovementioned advantages, but for highly natural wood reproduction boards with a matt surface like real wood.

This new development fully meets this challenge. Both the printed pattern and the surface are exactly matched to the board. They obtain their genuinely wooden appearance from the matt surface and the embossing that matches the board. It appears so natural that it is also the ideal edge finish for real veneer boards.

Since arriving on the market, the 3D Edge has set particularly high standards of quality and design. The many product variations have meant an increasing variety of application options for this edge. Now Doellken has again further developed its premium product and is offering it for the first time as an optimum match for naturally matt surfaces.

Advantage: 3D Edge

The advantages of the 3D Edge are due to the special manner of its manufacture. It is made of high-quality transparent acrylic. At the same time, it has a printed pattern on its rear, which fully covers the

open narrow surface of the board. When the edge is milled, only the transparent material is removed. The printed pattern, on the other hand, remains fully intact. This manages to prevent the notorious frame-like effect, and the combined effect of edge and board is as of one item.

Perfect matching finish

The 3D Edge was originally used as a contrasting edge. Since then it has been increasingly used as a finish to match the board. Because the surface of the 3D Edge can be buffed up to a high gloss, it has been and still is the ideal finish for the relevant boards. As well as glassy surfaces,



Authentic surface textures



Matrix has a bark-like surface, distinguished by matt and high gloss effects.

The current trend in surfaces is primarily for authentic-effect textures that make the furniture item look and feel natural.

To achieve a harmonious overall effect, the surfaces of the individual components must also be perfectly coordinated. On the other hand, quite singular effects can also be achieved via unusual and striking embossed finishes.

Wooden Matrix

Using a deep brushed-effect surface with matt and high gloss effects, more and more board manufacturers are giving their wood reproductions a natural wooden look and tangible feel. In the field of edgebands Doellken is the forerunner here, and with its “Matrix” it has developed an equivalent edge surface, which won the ZOW 2006

Innovationscout Award. The Doellken Matrix goes particularly well with the corresponding boards from Pfliederer, Egger or Cleaf. Matrix has such a natural effect that it is also outstanding when used in combination with real veneer boards.

A gentle grained texture characterises the new W87 embossed finish from Doellken.



Polished Microline

Microline is the name of the new embossing that has been specifically developed for metallic finishes. What is special about many types of metallic surface finishes is their slightly brushed texture, resulting from polishing during processing. Microline provides the finish with these typical fine abrasions, thereby giving it a thoroughly metallic look.

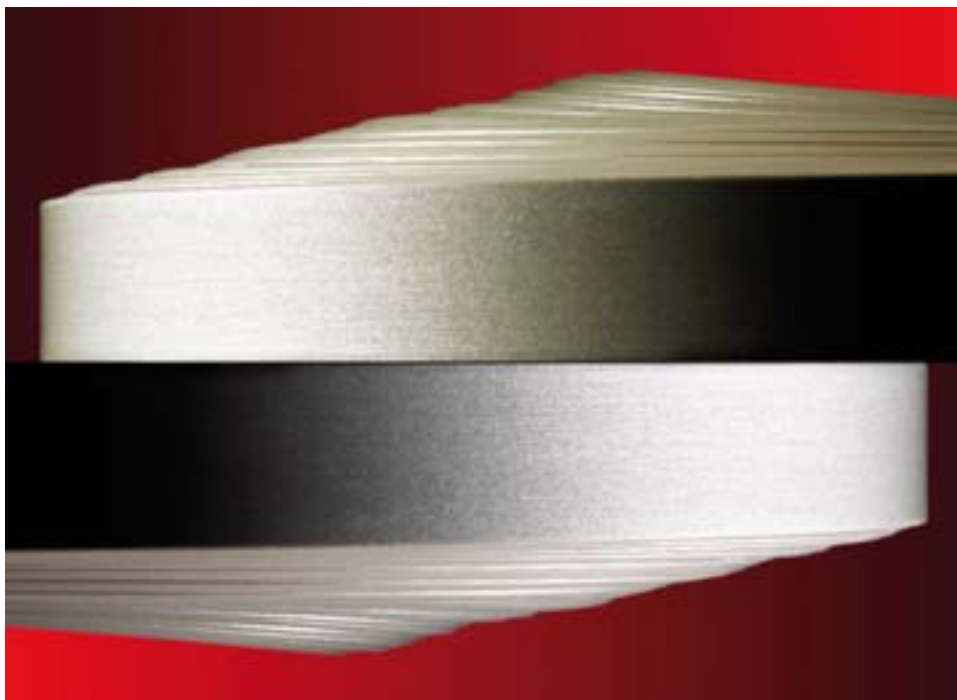
3D-Wave – something different

A classic among textures is the well-known “Wave”. Doellken has now provided its 3D Edge with it – on the underside in fact! The 3D effect comes from the smooth surface in combination with the transparent material and the finish attached to the reverse.

With the further addition of the wave texture to the underside, the edge obtains its unmistakable look with its formidable depth effect. This makes this version the ideal finish for adding some strong final touches.

Universal grain texture

An innovative, embossed finish version that will find wide application is the recreation of the grained surface of board finishes, as offered by Egger, for instance. Its subtle, haphazard contours result in the visual and tactile characteristics of a texture that is used universally on wood, unicolour and imaginative design finishes.



The Microline embossing gives finishes such as aluminium and stainless steel their typical slightly abraded look.



Embossed on the underside: This is what gives 3D-Wave its very striking depth effect.

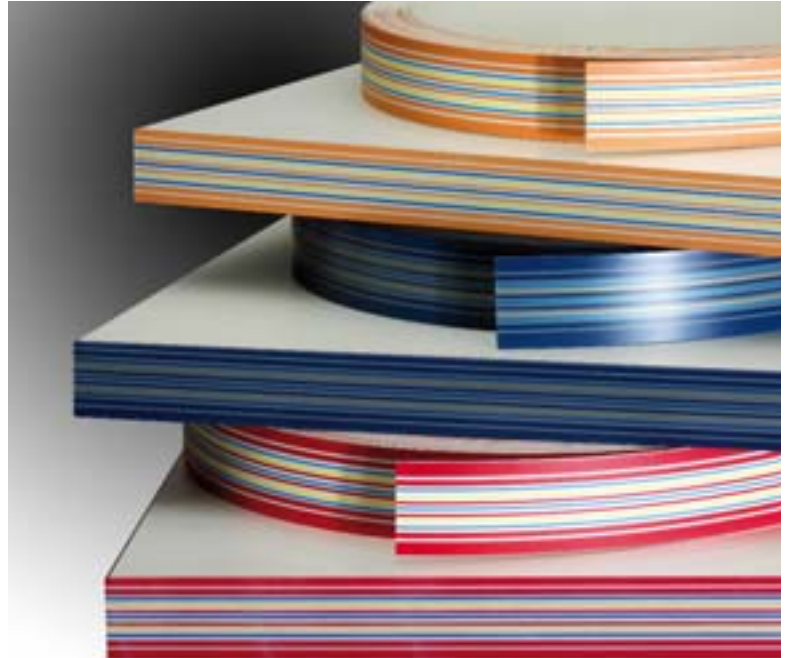
Striped edge design

In the field of interior design the current preference is for simple clean lines. At the same time we are seeing striped designs appearing in all furniture concepts. Doellken has edges to suit, which can either be used as finish to match the board or just as easily as a contrasting finish.

Colour-Line

Unusual and yet universal in use – this is what distinguishes the new “Colour-Line” 3D Edge series. It is a striped edge finish full of colourful contrast and is the ideal partner particularly for combining with high gloss unicolour boards.

The two-colour finish consists of an irregular sequence of stripes of varying widths. The strong colours, such as red, blue, green and orange, contrast boldly with the white background. In colour combinations with their corresponding board surface, these edges are a striking and bold alternative to neutral unicolour edges.



The new finishes of Multico-Line impress with their clean straight lines.

The black/grey/white versions of this 3D design series offer a particularly wide range of application options.

Wood-Line

In Wood-Line the classic design of the multiplex look has been given a new interpretation.

The colour gradings of the stripes are in light, medium and dark wood shades and are the ideal complement to boards involving one of these shades.

But Wood-Line also provides a particularly effective finish to unicolour boards.

A classic design with a new interpretation: Wood-Line.



Multico-Line

The new Multico-Line in ABS and 3D gives even greater emphasis on straight lines. The multi-colour finish consists of a regular sequence of stripes of varying width, which run parallel to each other and give the appearance of being mirrored in the centre of the edge. Almost all colour combinations are possible.

The trendy contrasting edges of Colour-Line and Multico-Line are for use predominantly in children's and young people's furniture design, in shop fitting, catering, or even in the bathroom.

Full of imagination

Doellken offers the right solution, not just when it comes to a contrast, but also in terms of a matching finish to a wide range of boards of striped design.

Particularly impressive here are the Mystic Decors from Thermopal in high gloss or the Latin Stripes from Lamitak, for which Doellken has edge finishes that match exactly.



Ideal for high gloss unicolour boards: Colour-Line in 3D!



Perfect matching finish: Doellken has the exact edge to provide the right match for current striped designs.



10 years of the Instant Edging Programme



The choice of edges covers the full spectrum of colours and finishes current in modern living environments.

Just 10 years ago it was still not that easy for stock-holding dealers to offer the tradesman a plastic edge to match a board. There was no edge-band manufacturer who had a well-designed stock solution to hand for the trade. The Instant Edging Programme from Doellken was born of this situation. Specially designed for the needs of the cabinetmaker, Doellken could offer the trade a matching ABS edge for around 800 different board finishes at short notice ex-stock. What's more, the mini-

quantity was just a single roll per colour/finish. The concept took off. Now – 10 years later – the Instant Edging Programme is a permanent feature for all dealers who carry a good range of edges – and this is now the case throughout the whole of Europe. The current range of matching finishes covers edges to match around 9,000 boards from more than 50 manufacturers.

And the indications are that this is to grow further.

Massive range of matching finishes

An important factor in this success is above all our ongoing maintenance of the matching finish range. As new board collections come on line, the programme is continually being extended and optimised – with the result that Doellken can offer edges to match all the stock collections of the leading board manufacturers. Most recently the Instant Edging Programme has, for instance, been further adapted to take the new Egger “Zoom” collection. For all new Egger boards Doellken has an edge in stock that exactly matches the finish and embossing. At the same time, popular versions have also been made in 23 x 1 mm dimensions specifically for the carcass. In terms of edge thickness, Doellken follows the demand for high-quality products for the trade, as there is an even greater premium here on differentiation from competitor solutions.

International orientation

The continued international orientation of the Instant Edging Programme has resulted in many new European board manufacturers being incorporated in the Doellken range of matching finishes. You can find an overview of all manufacturers at www.doellken-kv.com under the “Edgeband finder” menu item.

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