

Wood Acoustic Systems

Field Cutting & Edgebanding

Tools

- Table saw, mitre saw, or radial arm saw (or jig with fine tooth blade)
- Household clothing iron
- Sandpaper – 80 and 120 grit
- Hand-held flush trimmer (JSO Wood Products trimmer works good – available on amazon)
- Scissors
- Pencil

Material

- Edgeband – at least $\frac{1}{8}$ " wider than product. It is best to have pre-glued edgeband. If you don't have pre-glued edgeband, then you must also have hot melt sticks, a glue gun, and a putty knife (to spread the hot melt evenly on back of the edgeband prior to applying it to the product).
- Stain – maybe necessary to touch up, blend, or match (depending on whether edgeband is pre-finished or not)

Basic Field Cut and Edgeband Procedure

Note: You may need to take in consideration anchoring and pre-installed threaded inserts. If you have any questions, please reach out to Sonus for assistance.

Cutting

- It may be necessary to cut panels or planks to fit restricted or shaped areas (walls, fixtures, other product). Mark your cut line with a pencil.
- If using a table, mitre, or radial arm saw, place the panel face up. We recommend using 60 or 80 tooth medium/fine blades.
- Make slow cuts across the product. Do not run saw back and forth to prevent issues with wood veneer.
- If you are making a cut-out on the inside of a panel or plank, you may use a hole-saw or jig saw with panel or plank facing up. No edgebanding is typically performed.

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Edgebanding (pre-glued)

Set iron to "cotton" temperature (medium-high)

Trim the edgeband 1" longer than the length of panel section using scissors

Place the panel on it's edge so the edge you are edgebanding is facing up and the iron can be placed on top and be worked horizontally.

Set the edgband on top of edge making sure that there is overlap on each horizontal side.

Apply the iron at one end and work your way across the edgeband. A two foot section normally takes about 30 seconds of iron time.

DO: Apply a constant even pressure with the iron flat on the top edge

DO: Keep the iron moving to avoid hot spots or damage to panel

DO: Use a cotton cloth between iron and edgeband to prevent any possible damage

DON'T: Run the iron on the corners or a non-horizontal position

Let it cool briefly and then test adhesion

Trim the corner edges with scissors

Trim the horizontal edges with the hand-held flush trimmer – consistent equal pressure is important. It may take more than one pass. It is important to run the trimmer with the grain – not against it.

Lightly sand the edges and corners – this removes any excess adhesive and creates a smooth edge.

If using unfinished edgeband or you feel the need to touch up spots, apply stain with a cotton rag. Do not put excess amounts of stain on at once to speed this up. It is important to apply small amounts multiple times.