

OSHKOSH

Door Company

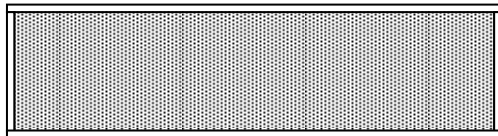
Right product. Right place. Right time.

TECHNICAL BULLETIN 100-00

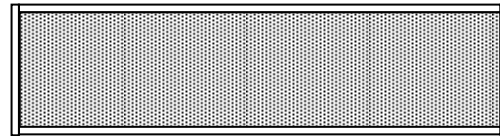
Edge Details For High Pressure Laminate (HPL) Doors:

There are two schools of thought regarding whether the edge strips should be installed before or after the face laminate. This is not addressed by industry standards, but most manufacturer's standard is to apply the laminate to the face of the door and then to the edge. The argument used by those applying the edge first and then the face is that it is more aesthetically pleasing. The laminate typically specified for doors is .050 inches thick, which is slightly less than 1/16. It is also usually general-purpose laminate with a decorative face in a solid color or wood grain pattern. The color or wood graining is only on the surface of the laminate and the balance of the material is dark brown. Regardless of whether the edge is applied first or last the dark brown line formed by the edge of either the edge band or the face laminate will always be visible. It is much more predominate in light colors and becomes much more muted with dark colors.

VIEW LOOKING DOWN AT THE DOOR TOP



Edge Applied First



Edge Applied Last

The argument that the edge applied first is more aesthetically pleasing would have merit if the door were to be viewed only from the pull side and in the closed position. None of the edges are visible when viewed from the stop side of the door and it is closed. When the door is standing open, which often is the case with many doors, it requires a close inspection to determine which was applied first. On the other hand there is a valid reason for applying the edge last.

HPL is very impact resistant when struck on the flat surface of its face because of the support from the core behind it. However, it is very susceptible to chipping when struck directly on the edge of the sheet. Most of the damage to doors results from being struck on the edges while standing open. When the face laminate extends all the way to the edge of the door past the edge band then the most vulnerable point of the laminate sheet is directly exposed to impact. When the edge band is applied last and covers the edge of the face sheet it protects the face sheet from the direct impact to its edge.

If the edge band is damaged it can be removed and replaced with relative Ease, even in the field. The door face is another matter and requires extensive work in a shop for removal and replacement usually equaling the cost of a new door.

Impact into an unprotected face edge often results in a large chip popping out of the door face.

