



karuun® is a natural material obtained from the rattan palm which is produced using a highly energy-efficient manufacturing process. *karuun*® edge has unique properties. Its typical linear fibre structure means that no visible joints are left from the processing stage, unlike conventional veneer edge.

Thanks to a patented technique it's possible to incorporate a unique striped pattern in the material according to colour preferences. Its aesthetic grace presents completely new design possibilities. To avoid cracks during processing,

karuun® edge is quick and easy to supply, allowing for a seamless finish that is perfectly tailored to each individual needs. The environmentally friendly material *karuun*® edge available in different colours, qualities and designs.

How to use

Individual pieces of *karuun*® edge are usually joined to form long sheets which are then glued to carrier panels (e.g. chipboard, multiplex or MDF) for edge finishing.

We recommend performing a test when first gluing the edge material in order to find the right balance between pressing time, temperature and pressure.

The standard thickness of *karuun*® edge is 2 mm: *karuun*® and 0.1 mm laminating material. If the material is polished, the minimum final thickness should be no less than 1.8 mm (excluding lamination).

karuun® edge is a semifinished product, therefore its lightfastness partly depends on the composition of the finished product. For optimal results, we recommend testing the product in advance based on the specific purpose and intended use.

Product Specifications



Thickness: ~ 2 mm
Length: 30 / 50 mm
Width: 16 / 20 / 23 mm (custom width upon request)
Design: natura, black (bleached/unbleached)

400 kg/m³

Density (product)
+/-

10 %

Moisture content
at 20°C / 65% relative humidity

0.048 %

Differential shrinkage (V) longitudinal
per % changes of moisture

0.15 %

Differential shrinkage (V) radial / tangential
per % changes of moisture

2.3 N/mm²

Compression (fc,90,k)
Rectangular to the grain

12 N/mm²

Compression (fc,0,k)
Face grain direction

All dimensions are approximate. *karuun*® is a natural material therefore slight variations in color and dimension cannot be ruled out.



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Processing guidelines (rolled goods)

Storage: Store *karuun*® materials covered in a dry place protected from dust and UV rays

Suitable adhesives: Common adhesives such as PVAC, PU, UF, MF or adhesive films

General tips:

- The fibres are oriented longitudinally, which means the material is not as tough across the grain
- Avoid crushing the material at individual points
- Over-exposure to heat can lead to discolourations and make the material brittle

Suitable tools:

- Gluing machines with hot melt adhesive (optically adapted to edge) and sharp flush cutter
- Clamps

Preparation:

- Always choose *karuun*® edge 2-3 mm wider than the panel material, as it will be sanded / milled flush afterwards
- Edge can be glued wet with all common adhesives, also by hand with additives and clamps / pressing aids
- The ideal moisture content to process *karuun*® materials is 8–11 %.
- Most common panel materials can be used as substrate
- Due to its high longitudinal strength, the edgeband can also be used as a stand-alone product.

Pressing:

- Adhesive required: 100–200 g/m²
- Open time: depends on adhesive (see manufacturer's guidelines)
- Pressing temperature: 15–130 °C depending on the adhesive and pressing process (discolouration may occur at higher temperatures and longer pressing times)
- Pressing time: depends on adhesive (see manufacturer's guidelines) and pressing process (from 5 seconds)
- Pressing pressure: 3–8 kg/cm² depending on application
- Include cooling time in the calculation if necessary
- For extreme angles, it helps to slightly moisten the edge from the outside.

Sanding:

- Use 180–300 grit sandpaper
- Hand sanding (e.g. with an orbit sander)
- Sanding flap brush 180–240 grit
- Maximum removable thickness during sanding: 0.15 mm (for a 0.6 mm panel)
- We recommend sanding at an angle to the fibre
- Sand protruding fibres across the grain rather than peeling them off

- Blow any residue off the surface with compressed air once sanding is complete
- The surface is raw and should be sealed after sanding and brushing.

Finishing:

- Surface must be dry, free of dust and grease
- The finishing process should be performed immediately after sanding
- Suitable products: varnishes, hard oils and hard waxes
- Environmentally friendly acrylic resin-based water varnishes recommended
- The product you choose shouldn't intensify the material (i.e. cause a yellow tinge)
- The final hardness of the product you use shouldn't further fix the fibres
- Processing order:
 1. first application is the priming coat (see "Suitable products" above)
 2. after curing comes intermediate sanding (e.g. 240 grit – orbit sander)
 3. blast surface with air
 4. 1–2 top coats of the product (see "Suitable products" above)
- Application rate varies according to field of application and product used
- A fine intermediate sanding after each application is recommended.

Lightfastness:

- karuun*® edge can be varnished using any product or method which is suitable for treating natural materials. However, of all the products available those with the following characteristics yield the best results:
- High wetting power
 - High yellowing resistance
 - High UV protection.



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