Edge *details* and edge banding

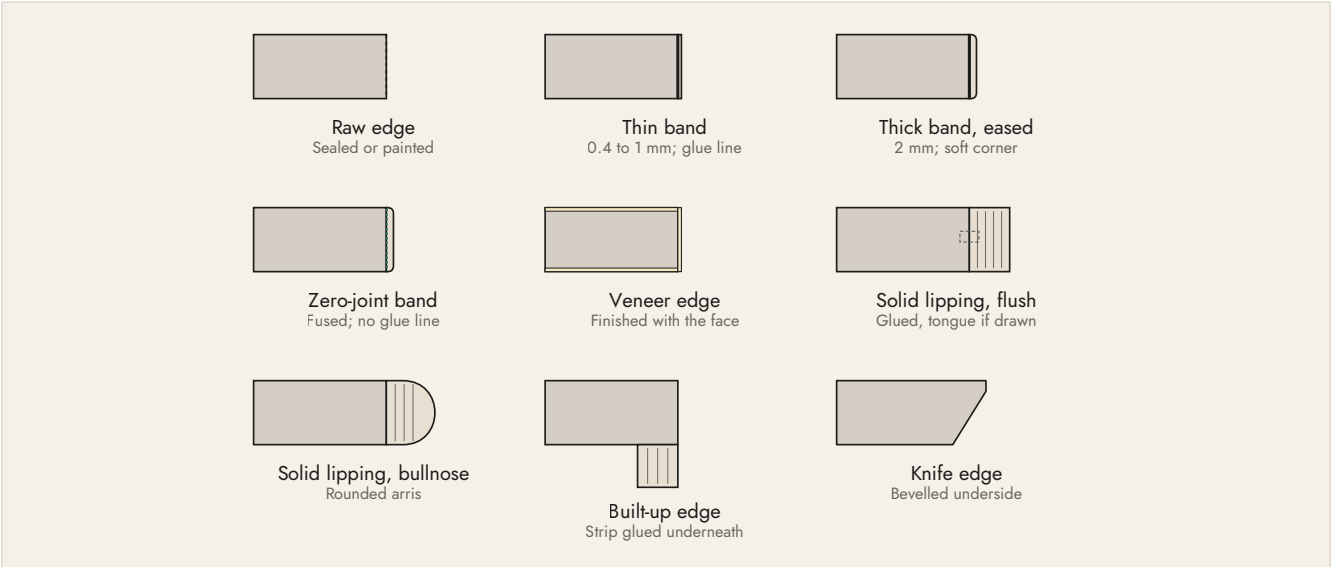
Nine panel edges drawn in section, with band thickness, wear, repair, glue line and wording for a schedule.

AT A GLANCE

Edge	What it is and how it wears	Joint and match
Raw edge, sealed or painted	Core left exposed and sealed. MDF edges soak up paint; knocks and water mark it.	No joint. The colour is the paint's.
Thin ABS or PVC band, 0.4 to 1 mm	A glued strip trimmed flush. Thin gauges chip if struck; a straight run can often be re-banded.	A glue line shows, thinner with PUR. One maker's data sheet allows a slight colour or texture difference.
Thick band, 2 mm, eased	The same at 2 mm with an eased corner; one distributor suggests it for tables and impact edges.	A glue line shows unless the band is zero-joint.
Zero-joint band	A layer on the band's back is fused by laser, hot air or NIR: no separate adhesive (maker claim).	No visible glue line (maker claim). The partner needs the machine and a matching band.
Veneer edge	A thin strip of the face veneer, finished with the panel. It scuffs through; refinishing is local.	Matches the face; a joint can show on pale timber.
Solid lipping, flush	A solid strip glued or tongued on and sanded flush. It can be refinished and stiffens a shelf.	A fine glue line. Grain and colour can differ from the face; it moves a little more than the board.
Solid lipping, bullnose	The same lipping shaped to a rounded arris, which chips less.	As flush lipping.
Built-up edge	A strip glued under the edge makes a thin top look thick.	A joint line under the edge.
Knife edge	The underside is bevelled to a thin visual edge. The arris is fragile.	Depends on the edge applied.

Wear and repair notes are general trade knowledge and one trade article, not test results; see the unverified list. Cost is left out on purpose.

NINE EDGES IN SECTION



BAND NUMBERS FROM ONE MAKER'S ABS DATA SHEET

Thickness 0.4 to 3.0 mm; Vicat softening about 90 °C; back-shrinkage up to 0.6 per cent (1 hour at 80 °C, free strip), which is 12 mm over 2 m; slight colour and surface differences from the board are permitted, so approve the real edge. No standard grades edge banding.

SPECIFICATION WORDING

EDGE SCHEDULE LINE

Edge [E1] on [panel and thickness]: [raw and painted / ABS band [ ] mm / zero-joint band [ ] mm / veneer to match the face / solid [species] lipping [ ] x [ ] mm], profile [square / [ ] mm radius / chamfer / bullnose]. Band and adhesive [PUR / EVA / functional layer]. Colour and texture to match [board or laminate ref], approved on a sample of the actual edge [S-0n].

SOLID LIPPING

Solid [species] lipping [ ] x [ ] mm, [glued / tongued and glued], flush with both faces, same cut and finish as the veneer [ref]; corners [mitred / lapped]. Visible glue line [acceptance to be agreed on sample [S-0n] under raking light]. Finished with the panel.

HIGH-WEAR AND HEAT OR WET EDGES

Contact zones [bar front, table edges, banquette base, door edges] with [2] mm [ABS / solid lipping] and a [ ] mm radius. Edges within [ ] mm of a heat source or in wet zones [solid sealed / PUR-bonded band]. Maker to supply band and adhesive data sheets (softening temperature, heat and moisture resistance) and a full-size edge sample for approval.

TERMS USED

Edge band

A thin strip of ABS, PVC, polypropylene, melamine or veneer glued or fused to a raw board edge and trimmed flush.

Lipping

A strip of solid timber glued to a panel edge to protect it, hide the core or give a solid look.

Zero-joint

An edge band with a functional layer on the back that is fused to the board, so there is no separate glue line (maker claim).

EVA and PUR

Two hot-melt adhesives for banding: EVA can re-melt once cured, PUR cures by moisture and does not.

STANDARDS AND SOURCES

- BS EN 12720, 12721 and 12722:2009+A1:2013 Furniture surface resistance: BSI: Current, Under Review. Not read; scope for edges unclear.
- BS EN 15186 Furniture, resistance to scratching: 2024 edition current per a seller; the 2012 edition was withdrawn 22 Mar 2024. Not read.
- Architectural Woodwork Standards, 1st edition (2009), Sections 8 and 11: US; edgebanding option drawings.
- A board maker's ABS edge data sheet, revision 02, 6 Aug 2025: one product's figures; name in the notes file.
- USDA Wood Handbook FPL-GTR-282 (2021): oak movement coefficients.

Full guide: https://makebespoke.com/trade/technical/edge-details-and-edge-banding. Make Bespoke Studio coordinates manufacture through its partner workshops. Figures are guidance only and your specification governs; some may be superseded, so contact the studio to verify.