Veneer Services
machines, supplies, and services

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Why don't we have a glue pot on our splicer?

We agree that initially it sounds like the Silver Bullet to do it all in one machine and not have a separate glue area. And we agree it would not be hard to add it to our machine.

So why don't we offer it?

Prior to introducing our machine we had a good deal of experience with servicing machines which do have glue pots. We also talked with many people around the world who run these machines to see what they thought.

We found two general conclusions:
The first group simply could not make it work and returned to applying glue outside the machine.
The second group does use it with limitations; they change the glue religiously every 30 minutes or so before it starts to dry in the pot, or they only mix a small batch and use it up before it starts to dry. If you only need to splice 15- 30 minutes per day you will find a way to make the pots work for you if you are determined.

But why doesn't it work? For that answer we talked to the most respected glue suppliers. They have seen the number of complaints about gluing quality rise with the use of the glue pots. They have customers demand a different glue mixture that works better for the glue pots. They have customers complain that the glue they supplied is now getting "all over my machine". They have lost business to other glue suppliers who claim to have developed a "special mixture" for the glue pots though they can't tell you what is special about it.

UF glue is the only glue to be used with a longitudinal splicer. The glue powder is mixed with water for the purpose of allowing it to be spread evenly on the edge of the veneer and even to penetrate the edges slightly. The water acts as a carrier for the glue only. UF glue is a thermoset glue, that is it requires reaching a certain heat level to completely cure and set. For the thermoset action to occur, the water must be completely removed from the process FIRST. It must either be evaporated off or cooked off.

In our system, we apply the glue in a separate step prior to splicing so that the glue has the maximum amount of time to penetrate the fibers before the water is evaporated. Then when the veneer enters the splicing heating area, the heat is being used 100% for the purpose of setting the glue.

In a system with a glue pot which applies the glue just ahead of the splicing heating area, the glue has no time to penetrate the fibers to strengthen the joint. It is applied and boiled until dry.

In a system with glue pots, the glue enters the heating area with all the water still in the mixture of glue. As we said before, the water must be removed before the thermoset glue can work. This means the first part of the heating area is being used to cook the water from the glue. Therefore the machine is losing splicing efficiency since the first section of the heating portion is actually used to dry the glue, not to splice the veneer. You must run the machine slower, so that the remaining area of the heaters has enough time to set the glue.

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This process of drying the glue (removing the water) creates steam that is then vented into the machine. This steam can distort the veneer edges, reducing the quality of the glue line and sometimes even causing buckle.

This steam that is vented escapes around the heater plates and enters moving parts of the machine such as the chains and bearings. It carries with it some amount of suspended glue, which then dries and begins to coat the splicer parts. Although the amount is small enough to be barely visible, it is there and it accumulates. You already know how hard this glue dries; now imagine what that hard glue can do to moving parts. Consider this; suppose you mix enough glue to require 1 gallon of water per shift. That water is now being removed by your splicer because you are not allowing it to evaporate before splicing. Would you consider taking a spray bottle of water, mix in a little glue, opening the side cover of the machine and spraying away until empty, refilling and spraying again until you have covered the machine with a gallon of water and glue? It is exactly the same thing! Of course you would never consider doing such a foolish thing and no manufacturer would consider suggesting you do that unless he wants to sell you more parts – oops!

For those who are determined to make the glue pots work, you are a singularly strong group who I take my hat off to because I know how hard you are working. You stop the machine about every 30 minutes, throw away the remaining glue in the pots, clean the pots and the applicators, mix new glue and start over. Are we then agreed that you lose at least 10 minutes every 30 minutes for this? So you are losing 1/3 of your production time and then enduring double or triple the wear and repairs on your machine.

Now really, what do you save by not having a separate glue area?

In this case there simply is No SILVER BULLET. If you want the highest quality joints, the proper amount of glue application, the lowest glue usage, the fastest splicing speeds, the most production, the lowest maintenance and no time spent cleaning glue from your splicer you must apply the glue prior to splicing and let it dry.

Still have questions? – Please contact me:
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