

# Technical Specifications PVC Edgebanding

## 1. Product name:

PVC (Polyvinyl chloride) Edgebanding

## 2. Producer

TECE Dekor A.S.

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## 3. Description

- Any kind of MDF and chipboard edge band
- Perfect stick with hotmelt glue
- Colorized opaque base
- Original wood pattern and colors
- Available surface finishes :
  - Smooth
  - High Gloss
  - Matrix
  - Pearl
  - Ashpore
  - Woodpore
- Excellent protection to physical damages
- Edging applied to panels in all sort of furniture production.

## 4. Specifications:

**Color:** Due to the fact that sample and the actual product have been produced at different times, there will be slight color variation.

**Color Fastness:** All our products are printed with inks with woolscale of 6-8.

**Gloss:** The specified gloss, determined by ISO 2813, is as follows (equipment reading angle =60°)

- High Gloss Solid Colors : ±93
- High Gloss Woodgrains : ±93
- Woodgrains : ±17

- Embossed Surface :  $\pm 7$

**Color Fastness:** All our products are printed with inks with woolscale of 6-8.

**Dimensional Stability:** During 1 hour at 80°C the shrinkage is  $< 1,5\%$  , according to the standard DIN 53377.

**Tensile strength at break:** The tensile strength at break is 65 N/mm<sup>2</sup> according to the standard DIN EN ISO 527-1.

**Density:** Range between 1.35 and 1.4 according to the standard DIN 53479.

**Water Absorption:** Negligible water absorption according to the standard ISO 62

Characteristics	Test standard	Tece PVC edgeband
Shore hardness D	DIN 53 505/ISO 868	81 $\pm$ 3
Resistance to warping under heat Vicat B 50 (Softening Temperature)	DIN 53 460 / ISO 306	80 $\pm$ 2 °C
Width	-	X* mm $\pm$ 0,5mm
Thickness	-	0,40 mm +0,02 / -0,04 0,80 mm +0,04 / -0,12 2 mm +0,10 / -0,20
Resistance to chemicals	TS EN 12720 / TS 4980	Very Good
Static charge	-	Low
Paint and varnishes- Cross cut test	TS EN ISO 2409	Table1-Classification of test results - Classification 1
Surface quality	-	Super matt to high sheen
Resistance to scratch	TS 4757	$\geq$ 1,5 Newton

\*19mm-650 mm width

## 5. Available Sizes

The width of the edge banding can be changed based on the customer demand (such as 22mm, 33mm, 42mm, 44mm or etc).

The standard length of 0,40mm thickness PVC roll is 300 mt.  
The standard length of 0,80mm thickness PVC roll is 150 mt.  
The standard length of 1 mm thickness PVC roll is 150 mt.  
The standard length of 2mm thickness PVC roll is 100 mt.

## 6. Application Instructions

PVC edgebanding can be processed on all sort of edgebanders (straight-processing and BAZ machining centers) using hot melt adhesive techniques. For each machine, it might require special adjustment in the process or in the parameters.

## 7. Packaging:

Dimension of the box changes as the width of the product changes. The standard box dimensions are here below.

Thickness	Box Dimensions	# of roll in box
0.4mm	49cm x 49cm x 18cm	22mm = 7 rolls, 19mm = 8 rolls
0.8 and 1mm	49cm x 49cm x 17cm	22mm = 7 rolls, 19mm = 8 rolls
2mm	60cm x 60cm x 12cm	22mm = 5 rolls, 19mm = 6 rolls

The boxes come on pallets. On a pallet, there can be 36 boxes of 0.4mm, 0.8mm, or 1mm and 40 boxes of 2mm.

## 8. Storage:

The recommended storage temperature is between 18° and 25°C.  
The product should be used up to 24 months after production date.

## 9. Technical Services

In case you need any technical support, please contact TECE at

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