



Technical Specifications PVC Edgebanding

Product Name

PVC (Polyvinyl chloride) Edgebanding

Producer

TECE Dekor A.S.

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Description

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

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 printed products use inks with a light fastness of 6-8 on the blue wool scale.

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

High Gloss Solid Colors : ≥ 90 GU

High Gloss Woodgrains : ≥ 90 GU

Woodgrains : 15-20 GU

Embossed Surface : 5-10 GU

Dimensional Stability : Shrinkage $\leq 1.5\%$ after 1 hour at 80°C. (Tested according to internal test method. Results may vary with edge band thickness and application conditions.)

Density : Range between 1.35 and 1.40 g/cm³, determined according to EN ISO 1183-1.

Water Absorption : 24 h / 23°C ≤ 0.3 % according to standard ISO 62.





Characteristics	Test Standard	Tece PVC Edgebanding
Shore hardness D	ISO 868	80 ± 4
Resistance to warping under heat Vicat B 50 (Softening Temperature)	ISO 306	80 ± 2°C
Impact Resistance 23°C (Izod)	ISO 180	20 ± 2 kJ/m ²
Tensile Strength	ISO 527-2	45 MPa
Flammability	ASTM D635	Self Extinguishing
Width	-	X* mm ± 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	DIN 68861	Very Good (Class 1B)
Static Charge	Internal test	Low (non-antistatic)
Paint and varnishes-Cross cut test	ISO 2409	Table1-Classification of test results -Classification 1
Surface quality	-	Super matt to high sheen
Light Fastness (Xenon Arc, 200 h, BST 65°C, 17 min light / 3 min spray, 50% RH) (EN ISO 4892- 2:2013+ A1:2021)	ISO 4892-2	ΔE _{cmc} = 0.2 – 1.2 No cracking, No chalking (Grey Scale ≥ 4)
Scratch resistance	EN 15186	≥ 1 Newton

*19 mm - 610 mm width



Available Sizes

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

The standard length of 0,40 mm thickness PVC roll is 300 m.

The standard length of 0,80 mm thickness PVC roll is 150 m.

The standard length of 1 mm thickness PVC roll is 150 m.

The standard length of 2 mm thickness PVC roll is 100 m.

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Available Instructions

PVC edgbanding can be processed on all sort of edgbanders (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.



Packaging

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

Product Thickness	Box Dimensions	# of lines on pallet	# of boxes by pallet	Total Pallet Weight	Pallet Size	What is inside of one box?
0.4mm-1mm Roll length is 300 meter between 0.4mm and 0.6mm of thickness. For 0.6mm - 1mm, it is 150 meter.		9 lines	36 boxes	1,008 kg	W 100 cm L 100 cm H 181 cm	0.4mm x 29mm = 1500 meter 0.8mm x 29mm = 750 meter 1mm x 29mm = 750 meter 0.4mm x 22mm = 2100 meter 0.8mm x 22mm = 1050 meter 1mm x 22mm = 1050 meter 0.4mm x 19mm = 2400 meter 0.8mm x 19mm = 1200 meter 1mm x 19mm = 1200 meter
1.5mm - 2mm Roll length is 100 meter between 1mm and 2mm of thickness		10 lines	40 boxes	1,280 kg	W 120 cm L 120 cm H 150 cm	2mm x 29mm = 400 meter 2mm x 22mm = 500 meter 2mm x 19mm = 600 meter



Storage

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