

# Technical Specifications Melamine Edgebanding

## 1. Product name:

Melamine Edgebanding

## 2. Producer

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## 3. Description

Single layer melamine edge banding made from 150gsm or 170 gsm decorative base paper and impregnated with urea+acrylic resin. Before impregnation, the paper is printed; after impregnation, the paper is coated with clear lacquer. It is to be used as panel edging in home and office furniture.

## 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.

**Surface:** The smoothness of the surface is always measured by eye. Visual testing should be done by holding the product at least 60cm away from the spectator. The surface is resistant to abrasion and chemicals.

**Gloss:** Due to the fact that sample and the actual product have been produced at different times, there will be slight color variation. The gloss level is  $\pm 18$  with 60° angle.

**Heat resistance test:** all products are tested to assure to have heat resistance with an iron of 170- 180°C

**Abrasion (Scratch Test):** According to TS 4757, all products are tested and proved with  $\geq 1.5$  kg abrasion test.

**Resistance to Chemical:** According to TS EN 12720 / TS 4980, the result with our product is very good.

## 5. Chemical Composition

Substance	Proportion for 150 gsm paper	Proportion for 170 gsm paper
<b>Paper</b>	150 gr / m <sup>2</sup>	170 gr / m <sup>2</sup>
<b>Resin</b>	80-90 gr	100-115 gr
Urea Formaldehyde	70%	70%
Acrylic Dispersion	30%	30%
<b>Lacquer</b>	16-20 gr	16-20 gr
<b>Total Weight/m<sup>2</sup></b>	<b>250–265 gr / m<sup>2</sup></b>	<b>290–305 gr / m<sup>2</sup></b>

The materials above are bound together under heat and with help of cross-linker.

Formaldehyde Emission Test Result:	$\leq 3,5$ mg/h m <sup>2</sup>
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## 6. Available Surface Structures

- Mechanical pore embossing
- Mechanical woodgrain embossing
- Mechanical ash pore embossing.

## 7. Available Sizes

The width of the edge banding can be changed based on the customer demand (such as 18mm, 22mm, 38mm or etc). Minimum width is 16mm with 1mm increments.

The standard length of the roll is 500mt. It can also be changed if requested.

Thickness	150 gr/m <sup>2</sup> : 0,28 µm 170 gr/m <sup>2</sup> : 0,31 µm
Weight	150 gr/m <sup>2</sup> : 255 ± 8 gr 170 gr/m <sup>2</sup> : 285 ± 10 gr

Inner core is 152mm.

## 8. Application Instructions

Tece melamine edgbanding can be applied with automated edgbanding machines.

For each machine, it might require special adjustment in the process or in the parameters.

## 9. Technical Services

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

Tel: +90 224 242 2100  
Fax: +90 224 243 8525

## 10. Packaging

The standard box dimensions are 50cm x 50cm x 22cm. The boxes are placed on pallets.