

Technical Specifications

PVC Edgebanding

1. Product name:

PVC (Polyvinyl chloride) Edgebanding

2. Producer

TECE Dekor A.S.

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Nilüfer/Bursa/ Turkey

Tel: +90 224 242 2100(pbx)

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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
 - Woodline
- 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 wooscale 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 : ±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.

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

Water Absorption: Negligible water absorption according to standard ISO 62

Characteristics	Test standard	Tece PVC edgeband
Shore hardness D	DIN 53 505/ISO 868	81 ± 3
Resistance to warping under heat Vicat B 50 (Deflection temperature underload, Softening Temperature)	DIN 53 460 / ISO 306	80 ± 2 °C
Impact resistance 23°C (Izot)	ISO 179/2C	20 ± 2 kJ/m ²
Tensile strength	DIN EN ISO 527-1	45 MPa
Modulus of elasticity	DIN EN ISO 527-1	5 %
Flammability	ATSM D 635	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	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	≥ 1,5 Newton

*19mm-610 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.

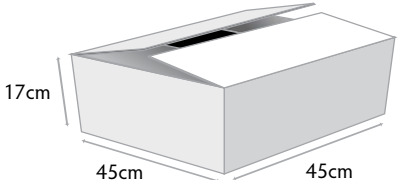
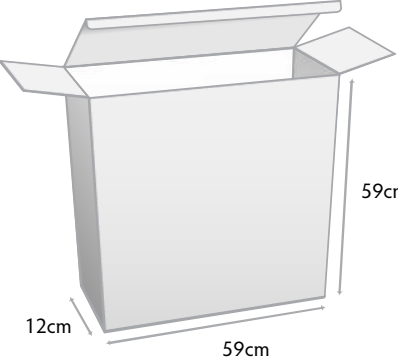
The standard length of 2mm thickness PVC roll is 100 mt.

6. Application Instructions

PVC 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.

7. 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?
0.4 mm - 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	W100cm L100cm H181cm	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	W120cm L120cm H150cm	2mm x 29mm = 400 meter 2mm x 22mm = 500 meter 2mm x 19mm = 600 meter

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

Tel: +90 224 242 2100

Fax: +90 224 243 8525

The information provided is above based on the information of our suppliers and our own experience. Issues that can occur without our control, we shall not be held liable. Our PVC materials should be test and inspected before running into standard production.

This file was prepared on January, 2016.