

# Technical Specifications

## Soft Melamine Edgebanding

### 1. Product name:

Soft Melamine 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

Single layer melamine edge banding made from 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.

The soft-forming melamine edges enable the user to apply the edging to panels with **3mm** radius.

### 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  $60^\circ$  angle.

**Heat resistance test:** all products are tested to assure to have heat resistance with an iron of  $170-180^\circ\text{C}$

**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 170 gsm paper
Paper	170 gr / m <sup>2</sup>
Resin	100-115 gr
Urea Formaldehyde	70%
Acrylic Dispersion	30%
Lacquer	16-20 gr
<b>Total Weight/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:	$\leq 3,0$ 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	170 gr/m <sup>2</sup> : 0,31 µm
Weight	170 gr/m <sup>2</sup> : 285 ± 10 gr

Inner core is 152mm.

## 8. Application Instructions

Tece soft melamine edgbanding can be applied to soft-forming edgbanding machine. The ideal glue temperature is 170°

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.