

# Technical Specifications

## PP Edgebanding

### 1. Product name:

PP (Polypropylene) Edgebanding

### 2. Producer

TECE Dekor A.S.

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### 3. Description

- Can be used on any kind of MDF and chipboard
- Perfect stick with hotmelt glue or PUR glue
- Colorized opaque base
- Original wood pattern and colors
- Available surface finishes:
  - Smooth
  - High Gloss and more...
- Excellent protection to physical damages
- Edging applied to panels in all sort of furniture production
- Chlorine-free plastic, Possibility to be recycled or incinerated with general waste

### 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 Variation In Solid-Colors:** Maximum allowed deviation from the master sample to the new production is max. 1.0 on delta E\*.

**Color Fastness:** All our products are printed with inks having light fastness values between 6 and 8 of blue wool-scale.

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

- High Gloss Solid Colors :  $90 \pm 3$
- High Gloss Woodgrains :  $90 \pm 3$
- Woodgrains :  $17 \pm 3$
- Embossed Surface :  $7 \pm 3$

**Dimensional Stability:** During 1 hour at 80 °C the shrinkage is <0.5 % according to our own method.

**Density:** Range between 0.95 gr/cm<sup>3</sup> and 1.08 gr/cm<sup>3</sup> according to the standard DIN 53479.

Characteristics	Test standard	Tece PP edgeband
Hardness Rockwell R-Scale	ISO 2039 - 2	75 ± 3
Resistance to warping under heat Vicat B 50 (Deflection temperature underload. Softening Temperature)	ISO 306 B	100 ± 2 °C
Impact resistance 23°C (Izod)	ISO 180	38 ± 3 kJ/m <sup>2</sup>
Tensile strength	ISO 527	25 ± 3 MPa
Tensile elongation	ISO 527	% 14 ± 4
Width	-	X* mm ± 0.5mm
Thickness	-	0.40 mm +0.02 / -0.04
		0.80 mm +0.04 / -0.08
		2.00 mm +0.10 / -0.20
Chemical Resistance	DIN 68861	Very Good (Class 1B)
Static charge	-	Low

\*19mm-260 mm width

## 5. Available Sizes

The width of the edgebanding may vary (such as 22mm. 33mm. 42mm. 44mm or etc).

The standard length of 0.40 mm thickness PP roll is 300 mt.

The standard length of 0.80 mm thickness PP roll is 150 mt.

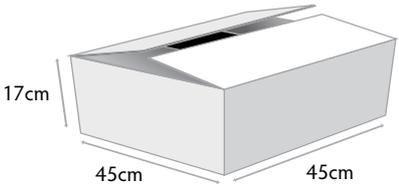
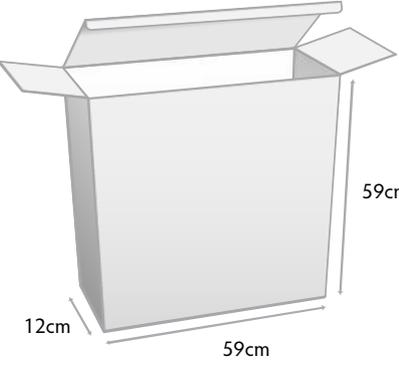
The standard length of 2.00 mm thickness PP roll is 100 mt.

## 6. Application Instructions

PP edge banding can be processed on all sorts 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.

Product Thickness	Box dimensions	# of lines on pallet	# of boxes by pallet	Total Pallet Weight	Pallet Size	What is inside of one box?
<b>0.4 mm - 1mm</b> 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	800 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
<b>1.5mm - 2mm</b> Roll length is 100 meter between 1,5mm and 2mm of thickness.  <b>2.5mm - 3mm</b> Roll length is 75 meter		10 lines	40 boxes	900 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, proper dry conditions.

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 +90 224 242 2100 or [info@tece.com.tr](mailto:info@tece.com.tr)

## 10. Cleaning

After the application of edgebanding to the board remainder of the glue can be cleaned. To clean PP edgebanding we recommend you to use special cleaning materials for PP. A test of the cleaning material is always recommended.

## 11. Whitening Edges

While processing edgebanding thicker than 1 mm (especially the ones with dark colors like wenge and cherry) the edgebanding might be prone to whitening on the trimmed edges. This

whitening can be removed by making sure that the trimming blades are sharp and the edgebanding machine uses the right polishing by a subsequent polishing chemical.

## 12. Common Issues and Solutions

In the below table you can see some of the common errors during processing of PP laser (seamless) edgebanding and recommended solutions. After following these instructions if the problem still persists please get in touch with Tece staff.

Problem	Suggested Solution
For thickness above 0.8mm the color shade in the trimmed side is becoming white or getting slightly lighter.	<ul style="list-style-type: none"><li>Polishing unit must be active with the proper chemicals inside. Polishing makes the edgebanding to get back to the original color.</li><li>Make sure that the trimming knives are sharp and set to right position.</li></ul>
The edgebanding is easily being pulled off by hand.	<ul style="list-style-type: none"><li>Make sure that the room temperature is minimum 15 °C</li><li>Make sure that the hot melt tank is at the right temperature.</li><li>Make sure that the hotmelt inside the tank has still its properties intact. When the same hotmelt is heated and then cooled down too many times, it loses its adhesion feature. Remove the tank and fill in with new hotmelt.</li><li>Make sure that the edgebanding and the board are not too cold. Must be above 10 °C</li><li>Make sure that there is pressure on the roller.</li><li>Make sure that the machine is adjusted to the right thickness.</li></ul>

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 PP materials should be test and inspected before running into standard production. This file was prepared on November 2019.