



Technical Specifications

ZERO-LINE PRO (LASER) Edgebanding

Product Name

PP (Polypropylene) Edgebanding with PP-based laser functional layer (FL)

Producer

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Description

- Can be used on any kind of MDF and chipboard
- Perfect stick through functional layer
- Colorized opaque base
- Original wood pattern and colors
- Available surface finishes :
 - Smooth
 - High Gloss and more...
- Excellent protection to physical damages
- Edgebanding applied to panels in all sort of furniture production
- Chlorine-free plastic

Specifications

Color : Due to the fact that sample and the actual product have been produced at different times there will be slight color variation. The edgebanding has a perfect color-match to its functional layer.

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 including PP laser edgebanding are printed or coated with inks / lacquer 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 ± 3
- High Gloss Woodgrains : 90 ± 3
- Woodgrains : 17 ± 3
- Embossed Surface : 7 ± 3

Dimensional Stability : During 1 hour at 80 °C the shrinkage is $<0,5\%$, according to own method.

Density : Range between 1.05 gr/cm³ and 1.10 gr/cm³ DIN 53479. according to the standard DIN 53479.





Characteristics	Test Standard	Tece PP edgeband
Shore hardness D	DIN 53 505/ISO 868	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 (Izot)	ISO 180	38 ± 3kJ/m ²
Tensile Strength	ISO 527	25 ± 3MPa
Tensile Strength	ASTM D 638 M	%14 ± 4
Width	-	X* mm ± 0,5mm
Thickness	-	1 mm +0.04 / -0.12 1.2 mm +0.05 / -0.14 2 mm +0.10 / -0.20
Chemical Resistance	DIN 68 861	Very Good (Class 1B)
Static Charge	-	Low

*19mm - 260 mm width

Characteristics	Test Standard	Functional Layer
Shore hardness D	DIN 53 505/ISO 868	55 ± 4
Basis	-	PP-based
Melting Point (DSC – Heating Rate 10 K/min)	DIN EN ISO 11 357-1	140 ± 10°C
Tensile Strength	ISO 527	25 ± 3MPa
Thickness	-	0.2 mm ± 0.02 mm
Chemical Resistance	DIN 68 861	Very Good (Class 1B)

Available Instructions



ABS edge banding can be processed on all sort 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.





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?
1,2 mm Roll length is 150 meter.		9 lines	36 boxes	8900 kg	W 100 cm L 100 cm H 181 cm	1,2mm x 29mm = 750 meter 1,2mm x 22mm = 1050 meter 1,2mm x 19mm = 1200 meter
1.5mm - 2mm Roll length is 100 meter between 1,5mm and 2mm of thickness. 2.5mm - 3mm Roll length is 75 meter		10 lines	40 boxes	900 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



Available Sizes

The width of the edgebanding may vary (such as 22mm. 33mm. 42mm. 44mm or etc).
The standard length for zero-line pro is 100 mt. This can change based on demand and thickness.
Minimum thickness for zero-line pro is 1mm and maximum is 3mm.



Storage

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



Cleaning

After the application of edgebanding to the board, remainder of the glue can be cleaned.
To clean Zero-Line Pro (Laser) edgebanding we recommend you to use special cleaning materials for PP. A test of the cleaning material is always recommended.



Whitening Edges

While processing edgbanding thicker than 1 mm (especially the ones with dark colors like wenge and cherry) the edgbanding 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 edgbanding machine uses the right polishing by a subsequent polishing chemical.



Common Issues and Solutions

In the below table you can see some of the common errors during processing of Zero-Line Pro (Laser) edgbanding 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 1mm the color shade in the trimmed side is becoming, white or getting slightly lighter...	<ul style="list-style-type: none"> Polishing unit must be active with the proper chemicals inside. Polishing makes the edgbanding to get back to the original color. Make sure that the trimming knives are sharp and set to right position.
The edgbanding is easily being pulled off by hand...	<ul style="list-style-type: none"> Make sure that the room temperature is minimum 15 °C. Make sure that the board and the edgband are not too cold. They must be stored and processed above 15 °C. Make sure that the machine is adjusted to the right energy, heat and speed levels. There will be different energy and speed settings for different colors or for different machines.
The functional layer is delaminated easily after pulling off the edgband from the board...	<ul style="list-style-type: none"> Make sure that the energy setting is proper and not too high. Make sure you have let the edgband to cool down for at least couple of hours.
While processing with Hot-Air, Plasma and NIR, the tensile strength is low...	<ul style="list-style-type: none"> Make sure that the right energy parameters are used. Make sure that the temperature is stable along the process. Make sure the air pressure and the related parameters are properly working. Make sure that the line speed is not too high. In case above suggestions do not work, please test at higher temperature and/or lower speed.