

## PVC EDGE BANDS | TECHNICAL SPECIFICATIONS

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### 1 MATERIAL PROPERTIES

Embossing : Various embossing structures are applied according to customer requirements .

Wood Decors : The inks used for the surface printing application have a minimum light fastness grade of 7. The decor is then coated with acrylic UV lacquer for the highest scratch resistance.

Primer : The back side is primed to suit bonding with all the conventional hot-melt adhesives.

### 2 APPLICATIONS

PVC (poly-vinyl chloride) is a shockproof, high-quality thermoplastic edgeband based on PVC and synthetic modifiers. It can be processed easily on edgebanding machines for covering the edges of carrier materials, mainly chipboards and MDF.

### 3 TECHNICAL CHARACTERISTICS

PROPERTY	TEST METHOD	VALUE
Light Fastness	ISO 877	7-8
Hardness Shore D	ISO 868	80 ± 4
Indentation Hardness	ISO 2039-01 (Nt/mm <sup>2</sup> )	105-120 Nt/mm <sup>2</sup>
Vicat Softening Temperature (50°C/h, B 50N)	ISO 306	75°C
Impact Strength, 23°C Notched	ISO 179/2C	19-21 (Kj/m <sup>2</sup> )
Impact Strength, 23°C Unnotched	ISO 179/2D	No Break
Shrinkage (1h at 80°C)	Own Method	< 4 %
Resistance to Chemicals	DIN 68861	Excellent (1B)
Static Charge		Low

### 4 PACKING INFORMATION

## TECHNICAL SPECIFICATIONS

Product	0.40mm-1.20mm	1.30mm-3.00mm
Method	Calender	Extrusion
Core	Plastic	Plastic or None
Inner Core Diameter	6 inches	15 inches
Outside Core Diameter	430mm	660mm
Length	+/- %2	+/- %2
Packaging, Labelling and Palleting	All customer requirements are possible	

#### CENTRAL OFFICE

Barbaros Mh. Ak Zambak Sk.  
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Ataşehir/İstanbul

#### FACTORIES

- 1 Organik Cad. No:11 KOSB Tuzla/İstanbul
- 2 Melek Aras Bul. Tuna Cad. No:10 KOSB Tuzla/İstanbul
- 3 Analitik Cad. No:59 KOSB Tuzla/İstanbul

#### CONTACT

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## 5 TOLERANCES

Width	18-54mm	+/- 0.45mm	
Thickness	0.00mm-1.00mm	+0.15/-0.10mm	
	1.10mm-2.00mm	+0.10/-0.20mm	
	2.10mm-3.00mm	+0.15/-0.25mm	
Pretention	Thickness	Width<30mm	Width>=30mm
	0.00mm-1.00mm	0.0mm-0.40mm	0.0mm-0.50mm
	1.10mm-3.00mm	0.0mm-0.30mm	0.0mm-0.40mm
Parallelism	<b>Thickness</b>	<b>Deviation</b>	
	0.00mm-2.00mm	0.10mm	
	2.10mm-3.00mm	0.15mm	
Longitudinal Distortion	Max. 3mm/1mt		
Delta E- Unicolors ( DL, a, b)	< 1		
Gloss Level	5-30	31-90	
	± 3	± 5	

## 6 PROCESSING

PVC edges can easily be processed with all conventional hot-melt adhesives (EVA, PA, PO, PUR) in the edgebanding machines.

Machining	Suitability
Cutting	Very Good
Rough Milling	Very Good
Radius Milling	Good
Profiling	Good
Side Scrapping	Good
Buffing	Good
Polishability	Good
Stress Whiting	Low
CNC Workability	Very Good

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NEW THINKING | BETTER EDGEBANDING

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### 7 STORAGE

PVC edges should not be stored under direct sunlight or in extreme temperatures. Avoiding these extreme conditions, the edge can be stored for a long time with no change to its properties. However, it is important that the material should rest for at least one day at room temperature prior to processing.

### 8 CLEANING

PVC edge is easy to clean using commercially available cleaning agents suitable for plastic surfaces. The use of solvent or alcohol-based substances should be avoided as they could partially dissolve the surface.

### 9 TECHNICAL CHARACTERISTICS

PVC Edge does not contain any materials hazardous to health that can be emitted during processing or storage. The material is suitable for recycling; however it is not suitable for incineration.

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