Technical Specifications
PVC Edgebanding

1. Product name:
PVC (Polyvinyl chloride) Edgebanding

2. Producer
TECE Dekor A.S.
Bursa Org. San. Bölgesi 75. Yil Bulvari No:12
Nilüfer/Bursa/ Turkey
Tel:  +90 224 242 2100(pbxC)
Fax:  +90 224 243 8525

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 woolscale 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

<table>
<thead>
<tr>
<th>Characteristics</th>
<th>Test standard</th>
<th>Tece PVC edgeband</th>
</tr>
</thead>
<tbody>
<tr>
<td>Shore hardness D</td>
<td>DIN 53 505/ISO 868</td>
<td>81 ± 3</td>
</tr>
<tr>
<td>Resistance to warping under heat Vicat B 50 (Deflection temperature underload, Softening Temperature)</td>
<td>DIN 53 460 / ISO 306</td>
<td>80 ± 2 °C</td>
</tr>
<tr>
<td>Impact resistance 23°C (Izot)</td>
<td>ISO 179/2C</td>
<td>20 ± 2 kJ/m²</td>
</tr>
<tr>
<td>Tensile strength</td>
<td>DIN EN ISO 527-1</td>
<td>45 MPa</td>
</tr>
<tr>
<td>Modulus of elasticity</td>
<td>DIN EN ISO 527-1</td>
<td>5 %</td>
</tr>
<tr>
<td>Flammability</td>
<td>ATSM D 635</td>
<td>Self extinguishing</td>
</tr>
<tr>
<td>Width</td>
<td>-</td>
<td>X* mm ± 0,5mm</td>
</tr>
<tr>
<td>Thickness</td>
<td>-</td>
<td>0,40 mm +0,02 / -0,04</td>
</tr>
<tr>
<td>Resistance to chemicals</td>
<td>TS EN 12720 / TS 4980</td>
<td>Very Good</td>
</tr>
<tr>
<td>Static charge</td>
<td>-</td>
<td>Low</td>
</tr>
<tr>
<td>Paint and varnishes-Cross cut test</td>
<td>TS EN ISO 2409</td>
<td>Table1-Classification of test results -Classification 1</td>
</tr>
<tr>
<td>Surface quality</td>
<td>-</td>
<td>Super matt to high sheen</td>
</tr>
<tr>
<td>Resistance to scratch</td>
<td>TS 4757</td>
<td>≥ 1,5 Newton</td>
</tr>
</tbody>
</table>

*19mm–610 mm width

**5. Available Sizes**

The width of the edge banding can 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 edgebanding 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.

7. Packaging:

Dimension of the box changes as the width of the product changes. The standard box dimensions are here below.

<table>
<thead>
<tr>
<th>Product Thickness</th>
<th>Box dimensions</th>
<th># of lines on pallet</th>
<th># of boxes by pallet</th>
<th>Total Pallet Weight</th>
<th>Pallet Size</th>
<th>What is inside of one box?</th>
</tr>
</thead>
</table>
| 0.4 mm - 1mm      | 17cm           | 9 lines              | 36 boxes             | 1,008 kg            | W100cm     | 0.4mm x 29mm = 1500 meter 0.8mm x 29mm = 750 meter 1mm x 29mm = 750 meter ...
|                   | 45cm           |                      |                      |                     | L100cm H181cm | 0.4mm x 22mm = 2100 meter 0.8mm x 22mm = 1050 meter 1mm x 22mm = 1050 meter ...
| 1.5mm - 2mm       | 59cm           | 10 lines             | 40 boxes             | 1,280 kg            | W120cm      | 2mm x 29mm = 400 meter 2mm x 22mm = 500 meter 2mm x 19mm = 600 meter ...
|                   | 12cm           |                      |                      |                     | L120cm H150cm | 2mm x 19mm = 1200 meter 1mm x 19mm = 1200 meter 2mm x 19mm = 600 meter ...

8. Storage:

The recommended storage temperature is between 18º and 25ºC. 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.