PMMA EDGEBANDS *Technical Specifications* *1/3*

MAJOR APPLICATIONS

ROMA PMMA (poly-methyl-methacrylate) is a shockproof, high-quality thermoplastic edgeband. It can be processed easily on edgebanding machines for covering the edges of carrier materials, mainly chipboards and MDF.

TECHNICAL CHARACTERISTICS

Properties	Test Method	Value
Light fastness	ISO 877	7
Hardness Shore D	ISO 868	80 ± 4
Indentation Hardness	ISO 2039-1	> 70 (N/mm^2)
Vicat Softening Temperature (50°C/h, B 50N)	ISO 306	100°C
Impact Strength, 23°C notched	ISO 179/2C	7-8 (kj/m^2)
Impact Strength, 23°C unnotched	ISO 179/2D	70 (kj/m^2)
Shrinkage (1h at 80°C)	own method	< 1.0 %
Resistance to Chemicals	DIN 68861	good (1B)
Static Charge		low

TOLERANCES

Width	12 - 54 mm	± 0.45 mm	
Thickness	1.0 - 1.5 mm	+0.10 / -0.10	
	1.6 - 2.0 mm	+0.10 / -0.20	
	2.1 - 3.0 mm	+0.15 / -0.25	
Pretension	thickness	width < 30 mm	width ≥ 30 mm
	1.0 mm	0.00 - 0.40 mm	0.00 - 0.50 mm
	1.1 - 3.0 mm	0.00 - 0.30 mm	0.00 - 0.40 mm
Parallelism	thickness	deviation	
	1.0 mm - 2.0 mm	0.10 mm	
	2.1 mm - 3.0 mm	0.15 mm	
Longitudinal Distortion	< 3 mm / 1 m (or < 12 mm / 2 m)		
Gloss Level	5 - 30	31 - 90	
	± 3	± 5	

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MATERIAL PROPERTIES

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

Wood Decors : The inks used for the 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 backside is primered to suit bonding with all the conventional hot-melt adhesives.

High-Gloss Lacquer : A UV-based lacquer with strong scratch-resistance characteristics is used for High-Gloss applications.

PROCESSING CHARACTERISTICS

ROMA strongly recommends the use of high-end hot-melt adhesives like an EVA-based adhesive with no filling materials or PUR adhesive for the processing of PMMA edges.

Machining	**Suitability**
Cutting	Good
Milling direction	GL /GGL [1]
- Rough milling	Good
- Radius milling	Good
- Profiling	Good
Side Scraping	good [2]
Buffing	good [2]
Polishability	very good
Stress Whitening	medium
CNC Workability	Good

[1] GGL: Conventional Milling, GL: Climb Milling. Conventional milling is recommended.

[2] Adjustment of machines might be required

PACKING INFORMATION

Description	**1.00 - 2.00 mm**
Production Method	extrusion
Type of Core	carton
Inner Core Diameter	200 mm
Outside Roll Diameter	avg. 420 mm
Off-size Rolls	minimal
Length Tolerance	± 1%
Joints	None
Packaging (all)	brown printed boxes
Labeling (all)	customer code and description on all box labels
Pallet Info (all)	shrink-wrapped with a specific Packing List for the pallet

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STORAGE

PMMA edges should not be stored under direct sunlight or in extreme temperatures. Roma PMMA edgeband is rot resistant and can therefore be stored at room temperature (64-68°F [18-20°C]) in a weatherproof room. Under conditions of excessive moisture and humidity adhesion of the primer may be affected.

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.

CLEANING

ROMA PMMA 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.

HAZARDS INFORMATION

ROMA PMMA edge does not contain any materials hazardous to health that can be emitted during processing or storage.

Small chips could fly off while cutting the edgeband; eyes should be protected in such a case.

The material is suitable for recycling; it is also suitable for incineration in approved incineration plants.

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