PVC EDGEBANDS *Technical Specifications* *1/3*

MAJOR APPLICATIONS

ROMA 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.

TECHNICAL CHARACTERISTICS

Properties	Standard	Value
Light fastness	EN 438-2	4-5 Grey scale
Shore hardness	DIN EN ISO 868 – Procedure D	78 ± 4
Indentation hardness	ISO 2039-1	100-120 (N/mm^2)
Vicat softening temperature (50°C/h)	EN ISO 306 – Procedure B/50	Approx. 75 °C
Impact strength, 23°C notched	ISO 179/2C	19-21 (kj/m^2)
Impact strength, 23°C unnotched	ISO 179/2D	no break
Shrinkage (1h at 60°C)	Internal test procedure	< 0,5 %
Chemical resistance [1)]	DIN 68861-1	1-B
Static charge		low

1) 1-B only given in combination with protective lacquer

TOLERANCES

Width	12 - 54 mm	± 0.45 mm	
Thickness	0.4 - 0.7 mm	+0.05 / -0.05	
	0.8 - 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	
Pretention	thickness	width < 30 mm	width ≥ 30 mm
	0.4 - 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	
	0.4 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 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 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 PVC edges can easily be processed with all conventional hot-melt adhesives (EVA, PA, PO, PUR) in the edgebanding machines.

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	good
Stress Whitening	low
CNC Workability	very good

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

[2] Adjustment of machines might be required

PACKING INFORMATION

Description	0.40 - 1.30 mm	1.50 - 3.00 mm
Production Method	sheet extrusion	profile extrusion
Type of Core	plastic	none
Inner Core Diameter	150 mm	300 mm
Outside Roll Diameter	avg. 420 mm	avg. 700 mm
Off-size Rolls	15% non-uniform lengths	minimal
Length Tolerance	± 1%	± 1%
Joints	None	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

PVC edges should not be stored under direct sunlight or in extreme temperatures. Roma PVC 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 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.

HAZARDS INFORMATION

ROMA 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.

All the information in this technical datasheet is given in good faith and is the result of our own experience and tests and can only be considered as a guideline for operation.
We guarantee the constant quality of our products but we cannot be held responsible for the results obtained in their use, since the conditions of work are beyond our control. We recommend that tests should be made to determine the suitability of the product for a specific purpose before the production is started.
In spite of the very good resistance to diverse chemicals, the sustained action of various vapors (cigarette smoke, kitchen fumes, etc.) may result in the discoloration of the top lacquer. These discoloration effects are beyond our control and are the result of expected wearing of the product over time.

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