



MAJOR APPLICATIONS :

STELLA DEKOR PLASTİK A.Ş PVC edge is a high-quality, shockproof thermoplastic edge band based on PVC (poly vinyl chloride) and synthetic modifiers. It can be processed easily on edge banding machines for covering the edges of carrier materials, mainly chipboards and MDF.

PHYSICAL PROPERTIES :

Shore Hardness D (DIN 53505) :	76,5 (+/- 3)
Scratch Resistance :	> 1.3 Newton
Light Fastness (DIN 53388) :	> 7 (for indoor applications only)
Gloss Level :	12 (tolerance +/-4)
Vicat Softening Temperature :	81.3 °C (50 N-120 °C /h)
Density (avg.) :	1,49 kg/m ³

SURFACE & BACKSIDE:

Embossing :	Various embossing structures are applied according to customer requirements.
Wood Decors :	The inks used in production have a minimum light fastness grade of 7. The decor is coated with acrylic UV lacquer for the highest scratch resistance.
Primer :	The backside is primed to suit bonding with all the conventional EVA, PA, PO, PUR hot-melt adhesives.

TOLERANCES:

Thickness	Tolerance	Width	Tolerance
0.40 – 0.80 mm	+/- 0.05 mm	16 – 23 mm	+/- 0.10 mm
1.00 – 1.30 mm	+/- 0.10 mm	24 – 45 mm	+/- 0.10 mm
1.50 – 2.00 mm	+0.05 / -0.20 mm		

ROLL LENGTH TOLERANCE*

Tolerance
Nominal Length of the Roll ± 1,5 %

* there can be max. one joint within the roll length. Rolls with joint are marked with red rectangular sticker with wording "joint in the roll" directly on the roll or on the palette

COLOUR TOLERANCES*

Colour Shade	L Value	Internal Test Method
White Shades	L ≥ 90	E ≤ 0,3
Light Colours	70 ≤ L < 90	E ≤ 0,5
Dark Colours	L < 70	E ≤ 1,0

* measured with spectrophotometer with D10* geometry and D65 light exposure.

INSTRUCTIONS FOR USE :

DBANT PVC edges can be easily processed with all the conventional hot-melt adhesives in the edgebanding machines:

Room and Materials Temperature :	18-20°C
Chipboard Humidity :	7-10 %
Application Amount for Adhesive :	200-250 gr/m ²
Processing Temperature :	180-220 °C
Feed Rate :	12-30 m/min

The above processing parameters are intended to serve as a guideline only. Due to the varying nature of carrier materials and hot-melt glues, we advise the customer to carry out his own trials to optimize individual working parameters.



PACKAGING INFORMATION:

Thin Edges: (0.40 – 1.20 mm thickness)

Type of Core :	Cardboard	
Inner Core Diameter :	152,4 mm	
Outside Roll Diameter :	420 – 450 mm	
Roll Label :	On the edgeband	
Length / Roll :	Thickness	Length
	0.40 mm	300 m
	0.50 mm	200 m
	0.60 mm	200 m
	0.80 mm	150 m
	1.00 mm	120 m
	1.20 mm	100 m

(All production batches include 10% non-uniform lengths)

Length Tolerance :	(+/-) 1%
Joints :	Minimal – marked with a red tape
Packaging :	Packed in white printed boxes
Box Size :	465 x 465 x 160 mm (LxWxH)
Rolls / Box :	8 rolls for 19 mm, 7 for 22 mm, 5 for 33 mm etc.
Box Weight :	29 kg average
Labeling :	Customer code and description on all box labels
Pallet Size (Wood) :	EURO-1 120 x 80 cm
Boxes / Pallet :	36 Boxes average
Pallet Info :	Shrink-wrapped with a specific Packing List for the pallet

Thick Edges: (1.50, 2.00 thickness)

Type of Core :	Cardboard
Inside Roll Diameter :	300 mm
Outside Roll Diameter :	450-500 mm
Roll Label :	On the edgeband

Length / Roll :	Thickness	Length
	1.50 mm	200 m
	2.00 mm	100 m

Length Tolerance :	(+/-) 1%
Joints :	None
Packaging :	Packed in white printed boxes
Box Size :	695 x 695 x 90 mm (LxWxH)
Rolls / Box :	5 rolls for 19 mm, 4 for 22 mm, 3 for 33 mm etc.
Box Weight :	37 kg average
Labeling :	Customer code and description on all box labels
Pallet Size (Wood) :	EURO-1 120 x 80 cm
Boxes / Pallet :	20 Boxes average
Pallet Info :	Shrink-wrapped with a specific Packing List for the pallet

HAZARDS INFORMATION:

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

STORAGE:

The 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

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.

T: +90 262 502 24 34

info@stelladekor.com
www.stelladekor.com

Köseler Mah. 20. Sok.
İdari Bina No:23
Dilovası-Kocaeli