

**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 <sup>3</sup>             |

**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 <sup>2</sup> |
| 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-1120 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-1120 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