FUJUAN GROUP

SHANGHAI FUJUAN GROUP CO., LTD.

PP EDGEBANDS

Technical Specifications ***1/3***

MAJOR APPLICATIONS :

PP edge bands is the most eco-freindly, thermoplastic edge band based on PP 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)	: 75 (+/- 3)
Scratch Resistance		: > 1.3 Newton
Light Fastness	(DIN 53388)	: > 7 (for indoor applications only)
Gloss Level		: 2-95 (tolerance +/-4)
Vicat Softening Temperature		: 100+/-2 °C
Density (avg.)		: 950 kg/m³

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 primered to suit bonding with all the conventional EVA/PUR Hot melt adhesives.

Tolerances:

Thickness	Tolerance
0.40 – 0.80 mm	+/- 0.05 mm
1.00 – 1.30 mm	+/- 0.10 mm
1.50 – 2.00 mm	+0.05 / -0.20 mm

Width	Tolerance
16 – 23 mm	+/- 0.35 mm
24 – 45 mm	+/- 0.35 mm

INSTRUCTIONS FOR USE :

PP edge bands can be easily processed with all the conventional hot melt adhesives in the edgebander:

Room and Materials Temperature	: 18-20°C
Chipboard Humidity	: 7-10 %
Application Amount for Adhesive	: 200-250 gr/m²
Processing Temperature	: 180-220 °C
Feed Rate	: 30-65 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 adhesive, we advise the customer to carry out his own trials to optimize individual working parameters.

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PACKAGING INFORMATION:

Thin Edges: (0.45 mm thickness)

Type of Core	: Paper inner core
Inner Core Diameter	: 150 – 158 mm
Outside Roll Diameter	: 365 mm
Roll Label	: On the edgeband
Length / Roll	: Thickness Length
	0.45 mm 200 m
	0.55 mm 200 m
	(All production batches include 15% non-uniform lengths)
Length Tolerance	: (+/-) 1%
Joints	: Minimal – marked with a red tape
Packaging	: Packed in white printed boxes
Box Size	: 365 x 365 x 200 mm (LxWxH)
Rolls / Box	:10 rolls for 19 mm,
Box Weight	: 16.3 kgs average
Labeling	: Customer code and description on all box labels

Thick Edges: (1.00, 2.00 mm thickness)

Type of Core	: None
Inside Roll Diameter	: 16 or 19 mm
Outside Roll Diameter	: 365 or 550 mm
Roll Label	: On the edgeband
Length / Roll	: Thickness Length
	1.00 mm 200 m
	2.00 mm 100 m
Length Tolerance	: (+/-) 1%
Joints	: None
Packaging	: Packed in white printed boxes
Box Size	: 55 x 55 x 115 mm (LxWxH)
Rolls / Box	: 5 rolls for 22 mm,
Box Weight	: 21 kg average
Labeling	: Customer code and description on all box labels

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HAZARDS INFORMATION:

PP edge bands do 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:

PP edge bands 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 is important that the material should rest for at least one day at room temperature prior to processing.