

**M.A.D.E SRL**

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Cap. Soc. interamente versato €10.000,00
CCIAA di TV REA 358465

1 PP EDGEBANING – General

PP edge banding is a thermoplastic edging developed for the decorative finishing of panels. It has a protective as well as a design function. The edge banding is produced from polypropylene and completely imbued.

2 Adhesion properties

PP edge banding is back side coated with a primer. It can be processed with the current adhesives based on EVA, PO, PUR, PA and APAO. Together with our ALPHA-TAPE® PP edgebanding, these highly heat-resistant adhesives ensure a good and firm adhesive bonded joint. If the furniture product is exposed to high application temperatures (e.g. furniture transport in a container or heat sources in a kitchen such as an oven or a stove; etc.), we recommend to use hot melt adhesives with a higher resistance to thermal distortion.

For the processing with high filled EVA hot melt-adhesives we deeply recommend to contact our technical department for application and processing questions, since a general suitability statement for this adhesives class is not possible. Please pay attention to the processing instructions of your adhesive supplier with special respect to processing temperature and amount of adhesive.

Important notice: The thermostats in the melting pots of the edge banding machines are often imprecise and the final temperature can deviate up to 30°C!

3 Delivery progra

Design / Design / Дизайн

Plain colors coated
Decors coated
Metal Effect, coated

4 Tolerance

Thickness			Width		
	Lower tolerance	Upper tolerance		Lower tolerance	Upper tolerance
0,40 – 0,80 mm	- 0,05 mm	+ 0,05 mm	12,0 – 405,0 mm	- 0,20 mm	+ 0,50 mm
0,90 – 1,00 mm	- 0,15 mm	+ 0,10 mm			
1,10 – 1,60 mm	- 0,20 mm	+ 0,10 mm			
1,70 – 2,00 mm	- 0,25 mm	+ 0,05 mm			
2,10 – 3,20 mm	- 0,30 mm	+ 0,05 mm			

5 Level parallelism

All available widths **< 0,10 mm**

6 Pre-tension

/ Width < 60 mm /	0,00 – 0,35
mm	
/ Width ≥ 60 mm /	> 0,10 m

7 / Longitudinal deformation /

All available widths and lengths	< 3,0 mm / 1
m	

8 Color

	L-value	C-value	ISO QC	Tolerance
White colors	> 90	< 5	dE cmc	0,5
Medium colors	71 – 90	< 60	dE cmc	0,8
Dark colors	30 – 70	< 40	dE cmc	1,5

9 Gloss

	Gloss scale	Tolerance
	5° – 30°	- 2 / +5
	31° – 70°	- 5 / +5

1 **Messwinkel 60°** / Measuring angle 60° / Угломер 60°**10** Processing on CNC machine center

In order to find the suitable PP edging for your required radii application, please contact our technical department for application and processing questions. For certain radii we offer a special PP-CNC-version. We are looking forward assisting you with the optimization of your machine settings/parameters.

11 Properties /

PP EDGEBANING	Value	Standard for testing
Fastness to light	7-8	ISO 4892-2
Softening point	> 120°C	ISO 306
Shrinkage	< 0,5%	MKT standard
Hardness	~ 75	DIN ISO 7619-1
Scratch resistance	4-6 N	standard
Chemical resistance	1 B	DIN 68861, Pt. 1 (LGA tested)

12 Cleaning

For cleaning @PP edge banding we recommend special plastic cleansing agents. Reliability must be tested on a small sample first. Never use alcohol-based or solvent-based cleaners.

13 Storage conditions

Stored under proper conditions – on a dry and cool place (<30°C) and protected from direct sunlight or dust, PP edge banding is applicable for a minimum period of one year.

Information and advice for application, if orally, in writing or by tests, are to the best of our knowledge, however, are not binding, especially in view of possible third party trade mark rights. Consultation with us does not exempt you from executing your own testing for the planned methods and purposes. Application, use and processing of our products, as well as your manufacturing of final goods following our advice are beyond our control and thus lie solely in your responsibility. The sale of our products is carried out according to our general commercial terms and conditions. Indicated data serve for orientation only. They do not represent any specification nor give warranty for edge banding characteristics.