

TECOLINE S

Softforming edgebanding

Characteristics: TECOLINE S - softforming edgebanding is an endless single-layer edging strip supplied in rolls with a surface finish. Made from non-Fading, specially formulated papers, in plain colours or printed with woodgrain or fancy patterns and impregnated with duroplastic resins.

Types:	<u>Thickness</u>	
	<u>approx. mm:</u>	<u>approx. inch:</u>
Version 1 (radius from 3 mm)		
TECOLINE S 50	0.31 - 0.34 mm	0.012 - 0.013 inch
TECOLINE S 30	0.28 - 0.31 mm	0.011 - 0.012 inch
Version 2 (radius from 4 mm)		
TECOLINE S 70	0.32 - 0.35 mm	0.013 - 0.014 inch
TECOLINE S 50	0.26 - 0.29 mm	0.01 - 0.011 inch
Applications:	Softforming profiles	
Substrates:	Particle board, MDF board, solid wood, etc.	
Processing:	<p>TECOLINE S edging strip can basically be used on any softforming machines. Depending on the edge profile, the machines have to be precision-adjusted as regards temperature, softforming area, hot air blowers and bonding system.</p> <p>Example: EVA hot melt adhesive</p> <p>Wood moisture content: approx. 8-12 %</p> <p>Processing temperature at the roller: approx. 190-210 °C</p> <p>Feed rate: at least 20 m/min.</p> <p>Please follow the instruction of the machine and glue manufacturers. The temperature of the material being processed should not be less than 20 °C.</p>	
Finish:	<p>Lacquered finish in various designs and gloss levels.</p> <p>For the full range of options please refer to our product brochure entitled "Finish designs".</p>	
Embossing:	<ul style="list-style-type: none"> • Mechanical woodgrain pore • Mechanical ash pore • Chemical woodgrain pore (real pore) • Pearl structure 	
Chemical resistance:	Depending on the surface finish TECOLINE S edging strips are chemically resistant as defined by DIN 68861, Part 1B to 1D.	
Fastness to light:	At least 6 on the international wool scale, DIN EN ISO 105-B02	

Backings:	<p>Reverse-sanding: For special processing techniques (e.g. PVAc adhesive bonding).</p> <p>PVAc glue: Pre-coating for edges where heat activation process is used.</p> <p>Primer: Polyurethane primer for secure adhesive bonding of our products with e.g. polyamide hot melt adhesives, urea glues and other adhesive systems.</p> <p>Hotmelt-coating: EVA hot melt adhesives (normal and heat-resistant) and polyamide hot melt adhesives for industry, skilled trade and DIY.</p>	
Form as supplied:	<p>Roll width: 15 mm - 100 mm Special widths available on request</p> <p>Hot melt pre-coating: optionally</p> <p>Internal roll diameter: 150 mm</p> <p>Roll length: without hot melt adhesive approx. 450 m with hot melt adhesive approx. 200 m</p>	
Packaging:	In polyethylene bags in boxes on pallets.	
Storage:	6 months, cool and dry in original packaging (approx. 20 °C, 55-65 % air humidity).	

The information provided in this specification is based on actual practice and on the results of in-house testing and is consistent with the current level of our knowledge. This information is intended merely as a guide and shall not be deemed to provide any warranty of specific product properties or suitability for a specific application. Since we have no influence on materials and processing conditions, we cannot be held liable for anything arising from this specification.

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