

## 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>
<b>Version 1 (radius from 3 mm)</b>		
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
<b>Version 2 (radius from 4 mm)</b>		
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:	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.	
	Example: EVA hot melt adhesive Wood moisture content: approx. 8-12 % Processing temperature at the roller: approx. 190-210 °C Feed rate: at least 20 m/min.	
	Please follow the instruction of the machine and glue manufacturers. The temperature of the material being processed should not be less than 20 °C.	
Finish:	Lacquered finish in various designs and gloss levels.	
	For the full range of options please refer to our product brochure entitled "Finish designs".	
Embossing:	<ul style="list-style-type: none"> <li>• Mechanical woodgrain pore</li> <li>• Mechanical ash pore</li> <li>• Chemical woodgrain pore (real pore)</li> <li>• Pearl structure</li> </ul>	
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:	Reverse-sanding: For special processing techniques (e.g. PVAc adhesive bonding).														
	PVAc glue: Pre-coating for edges where heat activation process is used.														
	Primer: Polyurethane primer for secure adhesive bonding of our products with e.g. polyamide hot melt adhesives, urea glues and other adhesive systems.														
	Hotmelt-coating: EVA hot melt adhesives (normal and heat-resistant) and polyamide hot melt adhesives for industry, skilled trade and DIY.														
Form as supplied:	<table><tr><td>Roll width:</td><td>15 mm - 100 mm</td></tr><tr><td>Special widths available on request</td><td></td></tr><tr><td>Hot melt pre-coating:</td><td>optionally</td></tr><tr><td>Internal roll diameter:</td><td>150 mm</td></tr><tr><td>Roll length:</td><td></td></tr><tr><td>without hot melt adhesive</td><td>approx. 450 m</td></tr><tr><td>with hot melt adhesive</td><td>approx. 200 m</td></tr></table>	Roll width:	15 mm - 100 mm	Special widths available on request		Hot melt pre-coating:	optionally	Internal roll diameter:	150 mm	Roll length:		without hot melt adhesive	approx. 450 m	with hot melt adhesive	approx. 200 m
Roll width:	15 mm - 100 mm														
Special widths available on request															
Hot melt pre-coating:	optionally														
Internal roll diameter:	150 mm														
Roll length:															
without hot melt adhesive	approx. 450 m														
with hot melt adhesive	approx. 200 m														
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.

Our international terms and conditions of sale and delivery apply in all instances. Valid versions of terms and conditions can be found on our website [www.surteco.com](http://www.surteco.com) and can also be sent upon request. Your adverse or deviant business terms do not place any obligation upon us.

**Contact:**

SURTECO GmbH · Robert-Linnemann-Str. 21-27 · 48336 Sassenberg · Deutschland · T: +49 2583 29-0 · [info@surteco.com](mailto:info@surteco.com) · [www.surteco.com](http://www.surteco.com)

Head Office

SURTECO GmbH · Am Brühl 6 · 86647 Buttenwiesen · Deutschland · T: +49 8274 51-0 · F: +49 8274-512 · [info@surteco.com](mailto:info@surteco.com) · [www.surteco.com](http://www.surteco.com)