

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:	Thickness	
	approx. mm:	approx. inch:
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: 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:**
- 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:	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:	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.
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Storage:	6 months, cool and dry in original packaging (approx. 20 °C, 55-65 % air humidity).
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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. This specification has a validity of 12 months after date of issue.

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