

PVC / ABS Edgebanding Specifications

Size Tolerances

Thin PVC

Thin ABS

a) Width: Products up to 1.000" \pm .010"
 Products up to 3.000" \pm .015"

b) Thickness: Products up to .024" \pm .002"
 Products over .024" \pm .003"

Thick ABS (TBS)

Thick PVC (over 1mm)

a) Width Products up to 30mm \pm 0.3 mm
 Products over 30mm \pm 0.5 mm

TBS Products up to 30mm +/- 0.5mm

TBS Products over 30mm +/- 0.5mm

b) Thickness 0 to 1.0 mm + 0.10mm / - 0.15 mm
 1.1 to 2.0 mm + 0.10mm / - 0.20 mm
 2.1 to 4.0 mm + 0.15 mm / -0.25 mm
 4.1 and over + 0.20 mm / -0.30 mm

Roll Dimensions

Thin PVC – Standard internal core diameter – 12.5 cm (5 inches) unless otherwise specified.

3mm PVC – Standard internal core diameter – 40 cm (16 inches) unless otherwise specified.

2mm PVC – Standard internal core diameter – 50 cm (20 inches) unless otherwise specified.

Curve of Length

Camber of .25" on 48" length is considered acceptable on material up to .040" thick

Camber of 3 mm on 1-meter length is considered acceptable on material over 1mm thick.

Colour

Slight variations may occur. Visual inspection should be evaluated under Cool White Fluorescent. North Sky Daylight (D65) is check secondly. Solid colors have a tolerance limit of DE = 1.0 using CIELAB. All measurements are to be performed using illuminant CWF at a 10° angle.

Gloss

Readings of gloss level should be taken at a 60° angle. Samples of extreme gloss level such as above 85 units should be measured using a 20° angle.

a) UV top coated products
 High gloss - 85 units or higher
 Medium gloss - 15 \pm 3 units
 Low gloss - 8 \pm 3 units

b) Textured and uncoated products - 15 \pm 5 units
 Note: Visual analysis of gloss level is performed in addition to measurement as texture samples are difficult to read accurately.

NOTE: Custom matched products will receive gloss levels matching samples provided, with a \pm 3 unit tolerance.

Solvent Resistance of U.V. Top Coat

Eight double wipes using acetone with a paper towel, not effecting gloss or print values, is considered a pass.

Concave (Primer Side)

| Thickness | Up to 30mm width | Over 30mm width |
|-----------------|------------------|-----------------|
| 0 – 1.0 mm | 0.20 – 0.5 mm | 0.30 – 0.70 mm |
| 1.1 – 2.0 mm | 0.10 – 0.30 mm | 0.15 – 0.35 mm |
| 2.1 – 4.0 mm | 0.10 – 0.25 mm | 0.10 – 0.30 mm |
| 4.1 – 6.0 mm | 0 – 0.20 mm | 0 – 0.25 mm |
| 6.1 mm and over | 0 – 0.10 mm | 0 – 0.15mm |

Maintenance of PVC Edgebanding

All PVC products can be cleaned using normal soap and water. It is recommended that strong solvents such as M.E.K., toluene, acetone or paint thinners are not used for cleaning.

Application Limitations

PVC Edgebanding is manufactured for interior use only. Continuous exposure to sunlight or UV Rays will cause color change.