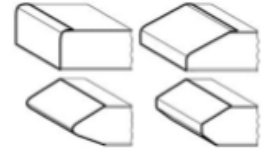


## Technical Datasheet - Döllken melamine edgebands

**Characteristics:** Döllken Softforming edgebands are continuous single layer edgebands off a roll with finish surfaces. Manufactured using lightfast special paper printed in plain colours and impregnated with duroplastic resins.



**Type:**

- Radii from 3 mm
- Thickness: 0.28 – 0.31 mm



**Areas of application:** Softforming profiles

**Base material:**

- Chipboards
- MDF boards
- Solid wood
- etc.

**Processing:** Döllken Softforming edgebands can in principle be processed on all Softforming edgeband machines. Depending on the edgeband profile, the machine temperature, forming path, hot air blower and adhesive system will need to be accurately adjusted.

Example: EVA hot melt adhesive wood moisture: ca. 8 - 12%  
Processing temperature at the roller: ca. 190 - 210°C  
Feed rate: at least 20 m/min

Please heed the machine and adhesive supplier specifications. The temperature of the processed material should not be below 20°C.

**Embossing:**

- Bead texture
- Finish varnishing

**Clear varnish:**

- Good chemical and mechanical resistance
- Limited stability around pores if used as actual pore filler
- Not coatable

**Surface characteristics:** Chemical Stress Group DIN 68861, Part 1B to 1D

**Lightfastness:** At least 6 on the International Wool Scale, DIN EN ISO 105-B02

- Underside preparation: Roughened:  
For special processing methods (e.g. PVAc gluing)
- PVAc glue:  
Pre-coating of the edgebands for processing by thermal activation
- Bonding agent:  
Polyurethane bonding agent for reliable gluing of our products with e.g. Polyamide hot melt adhesive, urea and other gluing systems.
- HSK coating:  
▪ EVA hot melt adhesive (normal and special heat resistance)  
▪ Polyamide hot melt adhesive for the industrial, technical and do-it-yourself.
- Form of delivery:
- 23 x 0.3 mm
  - 33 x 0.3 mm
  - Hot melt adhesive coating: optional
  - Roll inner core diameter: 150 mm
  - Roll length with adhesive: 50 r.m.
  - Roll length without adhesive: 100 r.m.
- Packaging: LDPE packaging bag
- Storage: At least 6 months in cool and dry places in original packaging (ca. 20°C, 55 - 56% humidity).

Information provided in this Datasheet is based on practical experience and on the results of own testing and our current knowledge. It is intended exclusively to serve as information and does not imply any warranty, assurance of specific product characteristics or suitability for specific purposes.

Since we have no influence over materials and processing conditions we accept no liability whatsoever.

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Date: 27.08.15

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