

13. Summary of technical data

Characteristics	Test standard	Doellken PVC edgebands
Useful characteristics		
Lightfastness for indoor applications	DIN 53 384 c/ DIN 53 388	7-8 on wool colour scale Ideal for indoor applications.
Indentation hardness	DIN 53 456	110 - 130 (N/mm ²)
Shore hardness D (Sensitivity to mechanical forces)	DIN 53 505/ISO 868	81 (± 3) Good surface hardness and scratch resistance. Physical damage can be easily rectified by buffing.
Linear thermal expansion coefficient	DIN 52 328	80 (1/K × 10 ⁻⁶) Dimensional stability of the glued edgeband is good (if the appropriate adhesive systems are used).
Resistance to warping under heat Vicat B 50	DIN 53 460/ISO 306	80 (± 2) °C
Shrinkage	Doellken factory standard	< 0.3 % Ideally suited to applications in the furniture industry. In critical temperature ranges, the use of a highly heat resistant adhesive is critical for the dimensional stability and temperature resistance of the finished furniture item.
Resistance to chemicals	DIN 68 861	Very good - classification 1B. Resistant to all standard domestic cleaning agents. Limited resistance to solvents. Tested by LGA Nuremberg.
Surface quality		Super matt to high sheen
Static charge		Low
Processing characteristics¹		
<ul style="list-style-type: none"> • Cross cutting • Milling direction² • Roughing • Radius milling • Profiling • Scraping • Buffing • Gluing radii • Bonding with hot melt adhesives • Buffability¹ • Susceptibility to stress whitening • Varnish capability • CNC compatibility 		<p>Good GLL/GGL² Good Good Good Good Good Good Good Good Good All standard edgeband thermoplastic adhesives (EVA, PA, APAO, PUR) can be used, depending on heat resistance of the adhesive. Good¹ Low Good (acrylic/PUR varnish) Very good</p>
Disposal characteristics		Return system for milling and cutting offcuts.
Physiological characteristics		No known source of harm to general health.

¹ Optimisation of machines may be required.

² Conventional milling is recommended on all thermoplastics materials:
GLL = climb milling, GGL = conventional milling

Unless otherwise indicated, the data specified were taken from standardised test items at room temperature. The data serve as a guide, but not as binding minima. Please remember that characteristics may vary considerably under certain circumstances due to the tool used, specific processing and colour (please see previous page as well).