

MELAMINE EDGE BANDS

Technical Specifications 1/2

MAJOR APPLICATIONS

ROMA Melamine edge is a high-quality, thermosetting edgeband based on refined cellulose and synthetic resins. It can be used universally for covering the edges of carrier materials, mainly chipboards and MDF.

PHYSICAL PROPERTIES

Properties	Value
Paper Weight	170 gr.
Surface Type	environmentally friendly E1 finish lacquering based on water soluble lacquers
Light Fastness	> 7 for all colors and decors
Ink Type	water soluble inks
Resin Content	min. 45 - max 52 %
Moisture Content	min. 2.5 - max. 3.1 %
Gloss Level	18
Flexibility	min. 9 - max 12 mm
Top Coat Weight	min. 7.5 - max. 15 gr/m ²

TOLERANCES

Width	12 - 54 mm	± 0.35 mm
Delta E	< 1.0	
Gloss Level	± 4	

PROCESSING CHARACTERISTICS

ROMA Melamine edges can be easily processed with all conventional hot-melt adhesives in the edgebanding machines.

Description	Value
Room & Materials Temperature	18-20°C
Application Amount for Adhesive	200-240 gr/m ²
Temperature	180-220°C
Feed Rate	20-60 m/min.

The feed speed should be at least 20 m/min so that the adhesive does not cool down prematurely and is still fluid enough to wet the entire surface of the edge strip.

The above processing parameters are intended to serve as a guideline only. Due to the varying nature of carrier materials and hot-melt glues, we advise the customer to carry out his own trials to optimize individual working parameters.



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PACKING INFORMATION

Description	Slitted Edges	Pre-glued Edges
Type of Core	plastic	none
Inner Roll Diameter	150 mm	110 mm
Outside Roll Diameter	avg. 400 mm	avg. 240 mm
Off-size Rolls	variable roll sizes; avg. 350 m	none
Length Tolerance	± 1%	± 1%
Joints	minimal; marked with a red tape	marked with a red tape
Packaging (all)	white printed boxes	
Labeling (all)	customer code and description on all box labels	
Pallet Info (all)	shrink-wrapped with a specific Packing List for the pallet	

STORAGE

Melamine edges will be best preserved in dry and moderate temperature storage areas. Under these conditions the edgeband can be conserved for at least 6 months with no deterioration in its properties.

HAZARDS INFORMATION

ROMA Melamine edge does not contain any materials hazardous to health that can be emitted during processing or storage.

All the information in this technical datasheet is given in good faith and is the result of our own experience and tests and can only be considered as a guideline for operation.

We guarantee the constant quality of our products but we cannot be held responsible for the results obtained in their use, since the conditions of work are beyond our control. We recommend that tests should be made to determine the suitability of the product for a specific purpose before the production is started.

In spite of the very good resistance to diverse chemicals, the sustained action of various vapors (cigarette smoke, kitchen fumes, etc.) may result in the discoloration of the top lacquer. These discoloration effects are beyond our control and are the result of expected wearing of the product over time.