

**Engineering progress
Enhancing lives**

RAUKANTEX PVC

Technical information



Materials for edgeband processing

REHAU uses the thermoplastic materials PVC (polyvinyl chloride), ABS (acrylonitrile-butadiene-styrene), PP (Polypropylene) and PMMA (polymethylmethacrylate) in its extensive RAUKANTEX edgeband product range. Thermoplastic materials are polymer materials which can be melted and therefore thermoformed, processed and recycled.

PVC as an edgeband material

PVC (polyvinyl chloride) is a widely-used thermoplastic material with excellent material and processing properties and has excellent chemical and ageing resistance. PVC is an impact-resistant mechanically resistant, cadmium and lead-free, high-quality polymer material, which complies with the fire protection class B2 to DIN 4102.

PVC material (polyvinyl chloride)

PVC is an amorphous thermoplastic which is created from the monomer vinyl chloride through the process of polymerisation. As a result of the specific combination of performance enhancers, stabilisers, lubricants, impact-resistant additives and pigments, PVC is a high-impact, mechanically resistant, cadmium and lead-free, high-quality polymer material.

1. Areas of application

The spectrum of applications for the RAUKANTEX PVC is almost limitless: From the office to the bathroom and kitchen, exhibition stand construction and shop fitting, the living area, and through to commercial construction. The processing-friendly RAUKANTEX PVC formulation affords both smooth continuous processing as well as a problem-free use in free-form parts. RAUKANTEX pure PVC edgebands are coated on the reverse with a universal primer which guarantees adhesion of the edgeband to the substrate. This primer allows processing with all suitable hot melt adhesives.

2. Recycling

RAUKANTEX PVC has outstanding durability. The disposal of PVC should generally be carried out at a specialist waste disposal site which caters for the specific material properties.



If PVC is burned in the incorrect way hydrogen chloride is generated which forms hydrochloric acid when combined with water or moisture in the air!

3. Characteristics/Properties

The properties of the RAUKANTEX PVC edgebands fulfil the requirements of the furniture industry. PVC edgeband possesses the following properties:

▪ Shore hardness D

RAUKANTEX PVC edgebands achieve good results with a Shore hardness D of 79 +/- 4 to EN ISO 7619-1.

▪ Heat resistance / Vicat softening temperature

With a value of approx. 67 °C to ISO 306 / B50 RAUKANTEX PVC edgebands are suited for use in the furniture industry.

▪ Abrasion resistance

The surface of RAUKANTEX decorative edgebands in PVC is protected against scratches with a UV lacquer, whereby the decorative designs demonstrate excellent scratch and abrasion resistance.

▪ Chemical resistance

RAUKANTEX PVC edgebands are chemically resistant to all household cleaners to DIN 68861 Part 1 and fulfil stress group 1B.

▪ Light fastness

RAUKANTEX PVC edgebands are regularly tested in an accredited laboratory in line with EN ISO 4892-2 regarding light fastness. An analysis of the colour deviation is then carried out along the lines of EN ISO 105-A02 using the grey scale. With a light fastness of ≥ 6 on the blue scale these edgebands are ideally suited for interior application.

▪ Cleaning

Special plastic cleaners are recommended for cleaning RAUKANTEX PVC edgebands. The use of substances containing solvents and alcohol is strongly advised against.

	PVC	ABS	PP	PMMA
Light fastness In accordance with EN ISO 4892-2	≥ 6	≥ 6	≥ 6	≥ 6
Shrinkage Edgeband 3 mm 1h at 90°C	≤ 1,7 %	≤ 1,7 %	≤ 0,2 %	≤ 1,0 %
Vicat softening point to ISO 306, Method B/50	approx. 67 °C	approx. 90 °C	approx. 100 °C	approx. 80 °C
Hardness Shore D to ISO 7619-1	79 ± 4	70 ± 4	75 ± 4	80 ± 3
Chemical resistance to DIN 68861-1	Very good – 1B	Good – 1B	Very good – 1B	Good – 1B*
Thermal conductivity to DIN 52612	0,16 W/km	0,18 W/km	0,41 W/km	0,18 W/km

* Limited resistance against solvents and alcohols.

4. Storage

If stored properly, RAUKANTEX edgebands can be stored for min. 12 months. For edgebands older than 12 months, however, a processing trial should always be carried out prior to series processing.

Recommended storage conditions are:

- Room temperature (approx. 18 °C to 25 °C)
- Dry
- Clean
- No vapours containing solvents
- Protected from light

5. Standard tolerances

RAUKANTEX pure PVC edgebands are subjected to regular quality checks in order to guarantee the high quality of every production run. In addition to this we are constantly working to improve the raw material properties.

The production tolerances for edgebands are defined exactly and are checked throughout every production run.

The standard tolerances for RAUKANTEX edgebands can be obtained from your contact person on request or you can find them on the internet.

6. Processing

Manual processing

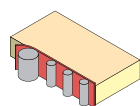
It is possible to process RAUKANTEX pure PVC edgebands manually using edge clamps. Special PVA adhesives, solvent-based adhesives and cartridge adhesives (e.g. Kantol) can be used for gluing by hand. Processing trials should be carried out in order to determine the suitability of the technical application in each case.

Machine processing

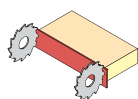
RAUKANTEX PVC edgebands can be processed on all edgebanders (straight line edgebander and BAZ (processing centres) using hot melt adhesive. The various processing steps such as gluing, capping, milling, scraping and also reworking with buffing wheels and hot air are possible without any problems.

To achieve a high-quality and durable edgeband application several important processing parameters have to be considered which depend on the components used (edgeband, glue and boards), the edgebander and the ambient temperature. In order to identify the ideal conditions it is recommended that trials are carried out and that the reference values specified by the relevant manufacturer are observed.

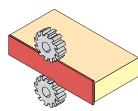
Process steps of machine processing:



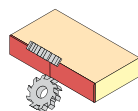
Gluing



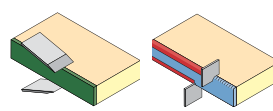
Capping



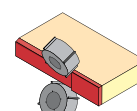
Pre-milling



Radius milling



Scraping



Buffing

Adhesive

RAUKANTEX PVC edgebands can be processed with all commercially available hot melt adhesives (EVA, PA, APAO and PUR). These highly heat-stable adhesives together with the RAUKANTEX pure PVC edgebands guarantee a secure bond.

For products exposed to high ambient temperatures (e.g. containerised transportation) hot melt adhesives with a high softening temperature are recommended. Due to the high heat resistance of the PVC edgebands of approx. 67 °C material softening during general applications does not occur.

During adhesion ensure that the adhesive is applied consistently, and that the glue spreading rollers do not extend too far into the line of the board.

The processing temperature of the adhesive varies depending on the type of adhesive. Be aware that the thermostats in melt containers are often inaccurate and the temperature of the applicator roller can vary by up to 30 °C.

Processing temperature

To achieve the best possible results during edgeband application the boards and edgebands should be processed at a room temperature of > 18 °C otherwise the adhesive sets too quickly. Draughts should also be avoided for this reason.

Wood humidity

The optimum wood humidity of the board material is between 7 and 10%.

Processing feed

RAUKANTEX PVC edgebands are suitable for the common processing rate of feed both in the commercial as well as industrial sector.

Adhesive application

To achieve ideal processing the information provided by the adhesive manufacturer should be observed. The adhesive application should be calculated in such a way that small beads of adhesive are pressed out from the edges of the freshly glued edgebands and the voids between the substrate particles are filled. The amount of adhesive in each case depends on the type of board, the substrate density, the edgeband material, the processing feed and the type of adhesive.

Milling

If possible use a 3 to 6 tooth milling tool with a diameter of 70 mm and 12.000 to 18.000 RPM counter to board travel (up-cutting). Inappropriate speeds or blunt tools can damage the edgebands. If a smear effect occurs the speed of the milling tool or the number of teeth should be reduced. The quality of the milled surface (e.g. chatter marks) can be improved by adjusting the feed, speed and number of blades.

Scraping

PVC exhibits very good quality during scraping, the chip produced by the scraper should be a maximum of 0.1 – 0.15 mm. To obtain a high-quality surface after scraping, aim for milling finish with as few chatter marks as possible.

Buffing

RAUKANTEX PVC edgebands can be buffed to generate a high quality edge radius. Colour deviation (stress whitening) caused during scraping of the edge radius can be eliminated to achieve a consistent finish by using a down-cutting buffing wheel set-up i.e. the wheels rotate with the travel of the board. Additionally, if release and cleaning agents are used during board processing, the buffing wheels will remove any unwanted glue residue.

Processing with invisible joint technology

RAUKANTEX pro/plus PVC edgebands are designed to be processed on edgebanding machines working with the hot air process. Please refer to the technical information for zero-joint edgebands regarding special information.



Processing of RAUKANTEX pro or plus in PVC material using the laser technology is not approved as gases hazardous to health can be formed.

Processing properties		PVC	ABS	PP	PMMA
Capping		good	good	good	good
Milling direction	Straight line processing	Up-cutting	Up-cutting	Up-cutting	Up-cutting
	Processing centre	Down-cutting/ Up-cutting	Down-cutting/ Up-cutting	Up-cutting	Down-cutting/ Up-cutting
Pre-milling		good	good	good	good
Radius milling		good	good	good	good
Contour milling		good	good	good	good
Scraping		very good	good	good	good
Buffing		very good	good	good	good
Gluing		Standard market hotmelts	Standard market hotmelts	Standard market hotmelts	Standard market hotmelts
Polishability		good	good	average	very good
Stress whitening tendency		low	average	low	low
Processing centre capability		very good	good	very good	superior

7. Frequently asked questions

Problem	Diagnosis of the problem
<p>1 The edgeband can easily be removed by hand. The hot melt adhesive remains on the chipboard (straight line) or on the edgeband (processing centre). It is possible to see the marking made by the adhesive application roller.</p>	<ul style="list-style-type: none"> ▪ Adhesive application not sufficient ▪ Room or edgeband temperature too low ▪ Draughty environment ▪ Processing feed too low ▪ Contact pressure of the pressure roller too low
<p>2 The edgeband can easily be removed by hand. Hot melt adhesive remains on the chipboard (straight line). The hot melt adhesive surface is completely smooth.</p>	<ul style="list-style-type: none"> ▪ Board and/or edgeband is too cold. ▪ Check hot melt adhesive type ▪ Check primer application
<p>3a Glue joint is not sealed (straight line)</p>	<ul style="list-style-type: none"> ▪ Adhesive too cold ▪ Adhesive application too low ▪ Contact pressure too low ▪ Edgeband pre-tension is incorrect ▪ Scoring saw alignment is incorrect ▪ Contact between the adhesive application roller and board ▪ Debris not removed from board cross-section
<p>3b Glue joint is not sealed (processing centre).</p>	<ul style="list-style-type: none"> ▪ Contact pressure too low ▪ Curvature of the edgeband too high <p>Measure/Proposal: Application of external heat</p> <ul style="list-style-type: none"> ▪ Check hot melt adhesive type (insufficient heat tack) ▪ Edgeband pre-tension is incorrect ▪ Adhesive does not set in good time <p>Measure/Proposal: Reduce the adhesive temperature</p>
<p>4 The glued edgeband does not show sufficient adhesion at the start.</p>	<ul style="list-style-type: none"> ▪ Adhesive application roller is not positioned correctly ▪ Increase the amount of adhesive
<p>5 Milling lines are visible.</p>	<ul style="list-style-type: none"> ▪ Feed too high ▪ Number of blades too low ▪ Speed too low <p>Measure/Proposal: Rework with scraper and buffing station</p>
<p>6 Edgeband splits during the milling process.</p>	<ul style="list-style-type: none"> ▪ Edgeband vibrates during the milling process ▪ Adhesion insufficient ▪ Edgeband projection too large <p>Measure/Proposal: Check adhesion parameters</p> <p>Measure/Proposal: Check adhesive type</p>
<p>7 Stress whitening of the edgeband in the milled area, principally after scraping.</p>	<ul style="list-style-type: none"> ▪ Chip of the scraper too thick ▪ Scraper set up incorrectly <p>Measure/Proposal: Check for blunting of the scrapers edge</p> <p>Measure/Proposal: Rework with buffing station</p>
<p>8 Stress whitening occurs during processing centre processing</p>	<ul style="list-style-type: none"> ▪ Micro-cracks occur in the radius area due to processing temperature being too cold <p>Measure/Proposal: Application of external heat in the radius area</p> <p>Measure/Proposal: Use of larger radiuses or thinner edgebands</p>

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© REHAU Industries SE & Co. KG
Helmut-Wagner-Straße 1
95111 Rehau

M01673 EN 07.2024