



MELTECA EDGETAPE & SOLID EDGING INFORMATION

DESCRIPTION

Melteca Solid Edging

Melteca Solid Edging is made from Rigid ABS (Acrylnitril Butadien Styrol) which contains no fillers or other compounds.

21, 28 & 33mm x 1.8mm & 0.8mm

Preglued & Unglued

Please refer to the Melteca Product offer for colour availability in each size.

Melteca Edgetape

Melteca Edgetape is a single layer melamine impregnated edgetape and can be applied as straight or curved edging.

21 & 42mm x 0.4mm

Preglued & Unglued

Please refer to the Melteca Product offer for colour availability in each size.

DIMENSIONAL STABILITY

Melteca Solid Edging

Melteca Solid Edging has a high dimensional stability and does not shrink over time due to the closed non-porous copolymer structure of ABS.

1 hour 90°C	-0.01% shrinkage
1 hour 100°C	-0.03% shrinkage
2 days 50°C	± 0.0% shrinkage

Melteca Edgetape

Melteca Edgetape has a very high dimensional stability due to its thermosetting properties.

1 hour 90°C	-0.0% shrinkage
1 hour 100°C	-0.0% shrinkage
2 days 50°C	± 0.0% shrinkage

SURFACE HARDNESS

Melteca Solid Edging

Melteca Solid Edging has a hard and highly scratch resistant surface.

Melteca Edgetape

Melteca Edgetape has a high abrasion resistance and scratch resistance. Conforms to DIN68861:2F/4C.

COLOUR FASTNESS

Melteca Solid Edging

Melteca Solid Edging conforms to European standards according to DIN54004, at least Woolscale 6.

Melteca Edgetape

Melteca Edgetape conforms to European standards according to DIN54004, at least Woolscale 6.

FOOD AND DRUG

Melteca Solid Edging

Melteca Solid Edging meets the standards laid down in the foodstuffs and commodities law, recommendation IX/163, BGA-Leaflet 27. Conforms to stringent USA FDA Standards.

Melteca Solid Edging does not leach oils from the surface like some other thermoplastic materials, thus it is safe for use in areas with young children.

Melteca Edgetape

Melteca Edgetape meets the standards laid down in the foodstuffs and commodities law, recommendation IX/163, BGA-Leaflet 27. Conforms to stringent USA FDA Standards.

Not applicable as no materials to leach out.

ANTI-STATIC

Melteca Solid Edging

Melteca Solid Edging is anti-static. This results in much less time spent cleaning machinery as shavings do not cling to panels or machinery.

Melteca Edgetape

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STORAGE

Melteca Solid Edging

Melteca Solid Edging is best stored in dry, temperate conditions to avoid application issues. Techniques such as a dry cupboard with a light running continuously are a common trade practice in the use of plastic films.

Melteca Edgetape

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APPLICATION

Melteca Solid Edging

Melteca Solid Edging is supplied with a glue primer. EVA, PA and PUR Hotmelt adhesives may be used. Pre-production testing is recommended using the edgebander in order to test the quality of adhesion. Recommended glue application temperature of 180 – 190°C, or as cold as possible with the resin type and machine feed rate.

Melteca Solid Edging and core material should be processed at room temperature. If either the edgebanding or board is too cold then poor quality adhesion may result. It is important to avoid draughts as this will cool the resin too quickly and may cause poor quality adhesion. Cold pressing with contact adhesives is unsatisfactory.

Unglued

Melteca Solid Edging must be applied at fast feed rates and temperatures, as recommended by machinery and adhesive suppliers. It is important to note that thermostats in melt containers are often inaccurate and the temperature at the spreader roll can be up to 30°C different. To minimise this effect, it is important to clean the edges around the glue pot to avoid insulation at the centre of the pot.

Preglued Mechanical Edge Bander

Heating of the hot air blower edgebander to 350-380°C is normally required for most machines. Melteca Solid Edging should be applied at fast feed rates. The edgebanding needs to be reasonably flexible to be able to be glued, ie exhibit Thermoplastic properties.

Hand Ironing

Melteca Solid Edging **cannot** be ironed on by hand.

Hot Air Gun

Not recommended for Melteca Solid Edging.

Melteca Edgetape

Melteca Edgetape is supplied ready to accept EVA, PA, and PUR Hotmelts without the need to pre-prime. Recommended glue application temperature of 200 – 210°C.

Melteca Edgetape and core material must be processed at room temperature. If either the edgebanding or board is too cold then poor quality adhesion may result. It is important to avoid draughts as this will cool the resin too quickly and may cause poor quality adhesion.

Unglued

It is important to note that thermostats in melt containers are often inaccurate and the temperature at the spreader roll can be up to 30°C different. To minimise this effect, it is important to clean the edges around the glue pot to avoid insulation at the centre of the pot.

Preglued Mechanical Edge Bander

Melteca Edgetape must be applied at fast feed rates and temperatures, as recommended by machinery and adhesive suppliers.

Hand Ironing

Preglued Melteca Edgetape may be ironed on by hand:

- Ensure iron is adjusted to cotton/linen or hottest temperature setting and the surface is clean.
- A layer of paper between the iron and tape will avoid burning or marking of the Melteca Edgetape surface. Repressing firmly with a cork block whilst still hot will ensure an improved bond is achieved.

Hot Air Gun

As for hand ironing with temperature set to ensure even melting of the resin.

TRIMMING & FINISHING

Melteca Solid Edging

Edgebanders

Ensure that the application speed has an appropriate open time for the Hotmelt adhesive.

- Milling: Best result from 4-blade milling tool with 70mm diameter running at 12,000 rpm.
- Scraper: Follows flush milling to clean up the edge.
- Buffer: May be used with Melteca Solid Edging to polish the edge if required. A hot air blower may assist with polishing on some edgebanders.

Hand Tools

Hand Milling machines with 20 – 30mm milling head diameter running at 12000 – 20000 rpm have proven effective.

Hand Trimming

Not recommended for Melteca Solid Edging.

Melteca Edgetape

Edgebanders

Ensure that the application speed has an appropriate open time for the Hotmelt adhesive. Ensure that the edge trimming, milling, cleaning/buffing/scraper units have been installed as required. By means of precisely adjusted activators for the end trimming (or tracing roller shoes for profiled edge milling) the edge material is processed to the exact contours of the work piece. Beveling of the edging material by means of milling units adjusted to an exact angle (arris) lessens the risk of damage to the edge due to accidental knocks, etc.

- Milling: Ensure blades are sharp to avoid chipping. A slight bevel on the trimming blades will also assist trimming.

Hand Tools

Hand Milling machines with 20 – 30mm milling head diameter running at 12000 – 20000 rpm have proven effective.

Hand Trimming

- Trim flush to the surface using a veneer trimming tool, plane blade or broad chisel.
- Sand lightly along edge using a fine grit sand paper (>240 grit) at an angle to form a slight arris.

CLEANING

Melteca Solid Edging

After processing Melteca Solid Edging, the glue line may be cleaned using Isopropyl Alcohol, White Spirits or an Aliphatic Hydrocarbon solvent such as Mobil Pegasol AA, BP Britolite, & Shellsol 426, to give the best desired result. Do not use any products with esters and ketones such as common paint thinners.

Do not use Paint Thinners, MEK, or Turpentine.

Please refer to the Health and Safety section re solvent use.

Melteca Edgetape

After processing Melteca Edgetape, the glue line may be cleaned using Isopropyl Alcohol, White Spirits or an Aliphatic Hydrocarbon solvent such as Mobil Pegasol AA, BP Britolite, & Shellsol 426, to give the best desired result. Products with esters, ketones and common paint thinners may be used on Melteca Edgetape, but are not recommended for Health & Safety reasons.

Please refer to the Health and Safety section re solvent use.

CHEMICAL RESISTANCE

Melteca Solid Edging

Very good resistance against a number of household cleaning agents, weak acids and dyes, most vegetable and animal fats and oils.

The material is Saliva and Perspiration fast. Conforms to DIN53160 standard.

Aromatic hydrocarbons, strong acids, esters and ketones corrode the material.

Melteca Edgetape

Melteca Edgetape has an exceptionally high chemical resistance. It conforms to DIN68861 – 1C.

Melteca Edgetape is resistant to most solvent cleaners such as thinners.

Extra care is required when using chemical on textured edgings. The solvents will remove the printed surface.

DISPOSAL

Melteca Solid Edging

Melteca Solid Edging can be disposed of through normal waste disposal channels. It can also be burnt together with wood chip waste. It will produce small amounts of Carbon Dioxide when burnt. But it does not produce Dioxin or Hydrochloric gases when burnt. By-products of burning are soot & Carbon Dioxide.

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HEALTH & SAFETY

The main health issues with Melteca Edgings derive from the use of solvents used to clean off excess resin after application which emit harmful vapours. There is an approved Code of Practice for the management of substances hazardous to health in the workplace available from OSH. The document suggests that wherever possible, avoid using substances that create harmful vapours.

The main techniques are to eliminate, isolate and minimise the use of hazardous solvents. OSH suggests this is done by finding another substance which has the right chemical properties to do the job and is known to be considerably less harmful.

Thus, in the setup of an edge bander, it is important to apply enough resin to adhere the edging to the workpiece, while ensuring that excess resin is not applied. This will help avoid the need to use aggressive solvents to remove large amounts of resin. The next step is to use solvents that will remove small amounts of resin from the workpiece that have the lowest possible harmful vapour release.

Solvents should always be used in well-ventilated areas. Protective gloves are also recommended to avoid the absorption of solvents through the skin. Viton or PVA gloves are recommended when using aliphatic, aromatic and halogenated hydrocarbons, acids, animal and vegetable oils. These gloves are manufactured from fluorohydrocarbon rubbers and offer the optimum level of heat and oil resistance.

TECHNICAL SUPPORT

As not all product use options can be described herein, additional end use and specifying information is available as a complimentary service.

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Please contact Fletcher Wood Panels Limited's Customer Services Department to check the currency of information contained in this brochure.

Further information and samples are available by contacting Fletcher Wood Panels Limited Customer Services.

NZ ☎ 0800 800 080

WEBSITE: www.fwp.co.nz

Fletcher Wood Panels Limited will not be liable to any person if the instructions as to storage, use, installation and maintenance of Melteca Solid Edging and Melteca Edgetape as outlined in this brochure are not complied with.

Any proprietary products referred to in this brochure must be used in accordance with the relevant manufacturer's instructions. Fletcher Wood Panels Limited accepts no liability for these proprietary products. Nothing contained in this paragraph or elsewhere in this brochure affects any rights a person may have under the Consumers Guarantees Act 1993.

This brochure supersedes all previous information on Melteca Edgetape and Melteca Solid Edging.



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