

PRODUCT DATA SHEET

EGGER MELAMINE EDGING



EGGER melamine edging is decorative edging based on curable resins. EGGER melamine edging has a multilayer structure and consists of decorative paper and one or more core layers. The decorative and core papers are impregnated with melamine resin.

Applications / Application areas

EGGER melamine edging is used for finishing of decorative wood-based materials such as chipboard, MDF, HDF, plywood panels and veneered boards.

For example: carcasses, cabinet fronts, worktops, etc.

Storage / Coating / Processing

STORAGE

EGGER melamine edging should be stored in enclosed, dry spaces, in its original packaging, lying on a pallet, at approx. 20°C and 55% to 65% relative humidity.

COATING

EGGER melamine edging is always sanded, and can then be finished by applying various coatings. The following coatings can be applied:

- EVA - hotmelt adhesive
- PVAC- dispersion adhesive (KA procedure)
- Primer (dispersion bonding agent, exclusively for bonding with EVA hot-melt adhesive)

EGGER melamine edging does not require a bonding agent. For edge thicknesses of 0.50 mm and 0.60 mm, however, we recommend that a primer be used to increase the initial stability of the bond.

If you intend to use polyurethane, polyamide and polyolefin hot-melt adhesives or PVAC dispersion and contact adhesives, then the reverse side of the edging must **not** be coated with primer.

PROCESSING

Before processing, EGGER melamine edging and the coreboard must be conditioned under normal climatic conditions, otherwise they may not bond properly.

EGGER melamine edging can be processed using conventional EVA, polyamide, polyolefin and polyurethane adhesives in edge gluing units. PVAC dispersion, condensation resins and contact adhesives are used in edge presses or for manual processing.

Please follow the machinery and adhesive suppliers' instructions.

Stock Programme

Storage dimensions and sizes are the same as the EGGER ZOOM® and INDUSTRY collections. Other roll lengths and dimensions are manufactured to order; minimum order quantity is 260 m² per format.

Quality characteristics / Technical Data

SCRATCH RESISTANCE / GLOSS LEVEL

Texture designations		Result	
Textures	Structure no.	Scratch resistance [rating] according to EN 438-2:2005	Gloss level [points] 60° Dr. Lange
Wood pore	ST1	3	12 ± 3
Diamond	ST2	3	12 ± 3
Perfect matt	ST9	3	6 ± 3
Office	ST15	3	15 ± 2
Finepore	ST24	3	18 ± 3
Semi matt	SM	2	10 ± 3

The gloss levels indicated are reference values and may deviate depending on the decor. Other textures are available on request.

OTHER QUALITY CHARACTERISTICS

Property	Characteristic	Unit	Result	Standard
Resistance to surface abrasion	Abrasion resistance	Revolutions	≤ 50	EN 438-2:2005
Resistance to water vapour	Appearance	Rating	≥ 4	EN 438-2:2005
Resistance to staining groups 1 and 2	Appearance	Rating	5	EN 438-2:2005
Resistance to staining group 3	Appearance	Rating	4	EN 438-2:2005
Light fastness [Xenon arc lamp]	Contrast	Grey scale	4 to 5	EN 438-2:2005

DIMENSION / TOLERANCES

Edge thickness [mm]	Thickness tolerance [mm]	Edge widths [mm]	Width tolerance [mm]	Roll lengths [m]
0,30 to 0,60	$\leq 0,50 \pm 0,05$ $\geq 0,50 \pm 0,10$	17 bis 25, 27, 28, 30, 32, 35, 40, 42, 45, 52, 55, 65, 96, 110 and 116	$\pm 0,20$	50, 100, 200, 300 and 400

COATING / CORE DIAMETER / ROLL LENGTHS

Coating	Core diameter [mm]		Roll length [m]
	120 *	150	
Sanded [S]	-	•	50, 100, 200, 300 and 400
Primer [P+SP]	•	•	50, 100, 200, 300 and 400
PVAC- dispersion adhesive [KA]	•	•	50, 100, 200, 300 and 400
EVA hot-melt adhesive [RB]	•	•	50, 100 and 200

* Standard – core diameter for coated edging