



## BASIC INFORMATION

**Material**

PP (Polypropylene)

**Hygienic Certificate**

Edges are certified by the National Institute of Hygiene in Warsaw

**Application**

Recommended storage in manufacturer's packaging in a horizontal position - max. 5 boxes. The place of storage should be protected against moisture, UV light and dust. Storage temperature should be between 17-25°C and should not change too much.

ATTENTION! Storage at too low a temperature may adversely affect the physical properties of the edging.

**Gluing**

Before commencing work, the edge and glued elements should be held at room temperature for a minimum of 24 hours (in autumn and winter even for 72 hours). The air temperature in the room in which the gluing process takes place should be  $\approx 18^{\circ}\text{C}$ . The edge on the working side (bottom) with the applied adhesive layer (Primera) allows the edge to adhere to hot melt adhesives, i.e. EVA, PUR (see the product range of the glue). The amount of glue applied depends on the recommendations of the manufacturer of the edge banding machine and the glue. It is recommended to test the adhesion of the furniture edge to the material to be covered.

**Notes for gluing**

The temperature of the glue used to join the edges and furniture boards depends on the type of glue and the feed speed, therefore it is absolutely necessary to follow the recommendations and standards given by the manufacturers of machines and adhesives. For optimal adhesion to the board, both the edge and the furniture boards should be dry and free from contamination. The dampness of the glued elements should not exceed 7-10%.

**Cleaning**

PP edge is an ecological material, and thus it is not possible to use NITRO solvents (see the product range of cleaning products). The edges are resistant to moisture - for cleaning you can use a damp cloth together with available cleaning products for furniture.



**Thickness  
(tolerance)**

Thickness:  
0.4 - 1.0 mm  
1.1 - 2.0 mm  
2.1 - 3.0 mm

Tolerance:  
+/- 1%  
+/- 1%  
+/- 1%

**Length  
(tolerance)**

Thickness:  
0.5 mm  
0.8 mm  
2 mm  
other

Length:  
300 mb  
150 mb  
100 mb  
non-standard

Tolerance:  
+/- 1%  
+/- 1%  
+/- 1%  
+/- 1%

**Width  
(tolerance)**

Regardless of size

+0.1/-0.1 mm

**Primer**

With added UV agent.

Protect the material against water, moisture, chemicals and any liquid dirt. After drying, the edge from the side of the primer will not regain its original properties.

**Storage**

MAX. 2 years

FREQUENTLY ENCOUNTERED PROBLEMS	DIAGNOSIS OF THE PROBLEM AND PROPOSED SOLUTION
The edge can easily be torn away from the board. The hot melt glue remains at the edge of the furniture.	Too low temperature of the board and/or edge. Too high temperature difference between the edge, the board, or the glue. Too high board temperature. Too low pressure of the glue application roll.
The edge can easily be torn away from the board. The hot melt glue remains on the chipboard.	Not enough glue has been applied. Too low temperature in the room. Too low temperature of the edge material (stored outside). Too low feed speed. Too low temperature of the hot melt glue. The type of hot melt glue should be checked.
Visible milling marks.	Too high feed speed. Too low cutting speed. Milling and polishing should be used in the final machining. Conventional milling should be used. The number of knives on the milling machine should be increased.
Breaking of the edge.	Too low storage temperature.
Deformation of the edge.	Too high gluing temperature. Too high edge storage temperature.
Lightening on roundings during machining.	Too low milling speed. Different setting for the smoothing and/or polishing function. Imprecise setting of card scrapper. Any change of color resulting from milling can be overcome using polishing discs.

Do not use products containing NITRO for cleaning PP edging.  
Suggested chemicals:

