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Technical Datasheet
PVC Edgeband



1. PVC PHYSICAL PROPERTIES

PHYSICAL PROPERTIES	STANDARD FOR TESTING	VALUE
DENSITY	ISO R 1183	1,29 - 1,35 g/cm ³
VICAT SOFTENING TEMPERATURE (50°C/h, B 50N)	ISO 306	81,3°C
SHORE HARDNESS D	DIN 53505/ISO 868	76,5 +- 3
SHRINKAGE	EN 438-2	4 %
SCRATCH HARDNESS TEST PENCIL WITH VARNISH	(Wolff-Wilborn method) ISO 15184	HB
CHEMICAL RESISTANCE WITH VARNISH	DIN 68861	1B (Good)
LIGHT FASTNESS WITH AND WITHOUT VARNISH	UNE 56875:14V2	≤ 4 gray scale
VARNISH ADHERENCE	CROSS-CUT TEST ISO 2409:2013	0 = Excellent
EDGE BANDING ADHERENCE	UNE 56875	Meet the standard
STATIC CHARGE		Low

2. PVC PROCESSING FEATURES

PROCESSING FEATURES	REMARK
Bonding	With any common glue for edgebanding
Clipper cutting	Good
Pre - milling	Good
Radius milling	Good
Fitting	Good
Polished	Good
Lacquer	Good with common products. Needed test before



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3. PVC THICKNESS TOLERANCES

THICKNESS mm	TOLERANCE mm
0 - 1.0	+0.15/-0.10
1.1 - 2.0	+0.10/-0.20
2.1 - 3.0	+0.15/-0.25

4. PVC WIDTH TOLERANCES

WIDTH mm	TOLERANCE mm
16 - 23	+/- 0.35 mm
24 - 45	+/- 0.35 mm

5. TECHNICAL FEATURES OF CANTISA PVC EDGEBANDING

Polyvinyl Chloride (PVC) is a thermoplastic produced by the polymerization of vinyl chloride. It is a rigid material used in the manufacturing of many products.

Due to its qualities, it is optimal for producing edge banding that covers the sides of furniture panels.

It can be manufactured in thicknesses ranging from 0.4 mm to 3 mm.

Widths vary from 12 mm to 200 mm.

Its composition provides high impact resistance and good mechanical strength.

It becomes brittle at temperatures below +0.5°C.

The maximum continuous exposure temperature is 50°C.

The back side of the PVC is treated with a primer coating, which covers 100% of the back surface. Its presence can be visually verified and ensures adhesion with standard glues.

Its basic composition is:

- PVC resin
- Calcium carbonate
- Calcium-Zinc based stabilizer
- Acrylic modifiers
- Epoxidized soybean oil
- Pigments

PVC edge banding is self-extinguishing and softens at approximately 25°C.

It has good resistance to sunlight in environments with protected sun exposure, such as indoors. If used in outdoor environments, it should be formulated with anti-UVA stabilizers.

It does not contain PFOA and PFOS substances.



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6. PVC APPLICATION RECOMMENDATIONS

Cantisa's PVC edge banding can be used in any standard edge banding machine, whether with EVA-based hot melt adhesives or PUR adhesives.

The technical usage recommendations provided by adhesive and edge banding machine manufacturers must be followed during the edge banding process.

Using adhesives with high temperature resistance and the formulation of our edge bands (with minimal heat shrinkage) will ensure proper bonding.

It is recommended to control the temperature not only in the glue pot but also on the glue application roller.

Both the panel and the edge band to be used should not be at temperatures lower than 18°C.

This can cause bonding issues.

Environmental conditions for edge banding suggest maintaining relative humidity levels below 70%.

The moisture content of the particleboard to be edge-banded should be between 8% and 12%. Edge banding speeds between 10 and 100 m/min are possible depending on the edge banding machine.

We recommend using cutters with 3 to 6 blades, operating at speeds between 12,000 and 18,000 rpm.

Cantisa's PVC edge bands work well with polishing units, and the color of the edge band should match the surface of both the panel and the edge band itself.

7. CLEANING

The use of appropriate cleaning agents is recommended by Cantisa. Certain substances with high solvent and alcohol content can damage the surface and should not be used.

It resists attack from most acids, alkalis, and inorganic salts. It is not affected by oils, alcohols, aliphatic hydrocarbons, and fatty acids. It is attacked (totally or partially) by chlorinated solvents, ketones, aromatic hydrocarbons, and some aldehydes.

8. WASTE DISPOSAL

PVC waste must be separated from other wood scraps.

For disposal, it should be collected by a company competent in handling plastic waste disposal.

9. STORAGE CONDITIONS

To maintain the product's properties, it is recommended to store it in a dry and cool place (below 30°C), protected from direct sunlight and exposure to dust.

Under these proper conditions, the product's properties are maintained for more than one year.



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10. PVC EDGE BAND SAFETY DATA SHEET

10.1. PRODUCT AND COMPANY IDENTIFICATION

- **PRODUCT NAME:** PVC Profile.
- **PRODUCT USE:** Edge banding, calenders, and coped support.
- **COMPANY NAME:** CANTISA S.A.
- **C/. Pintor Joaquín Sorolla n° 8**
- **Polígono Industrial Ciudad Mudeco**
- **46930 Quart de Poblet (Valencia) Spain**
- **EMERGENCY PHONE:** Toxicological Information Service: +34 91 562 04 20

10.2. COMPOSITION/INFORMATION ON COMPONENTS

PVC, extruded or calendared, covered with adhesive, ink, and varnish.

10.3. HAZARD IDENTIFICATION

It poses no danger to humans or the environment. In case of fire, it may release harmful vapors to health.

10.4. FIRST AID

Under normal conditions, no special measures are necessary.

10.5. FIRE FIGHTING MEASURES

- **SUITABLE EXTINGUISHER:** Water, foam, chemical powder, CO2.
- **DANGEROUS COMBUSTIBLE GASES:** Formation of HCl during combustion.
- **SPECIFIC RISKS:** In a fire, the product is considered self-extinguishing and does not propagate flames.
- **PROTECTION EQUIPMENT:** Use of self-contained breathing apparatus.

10.6. MEASURES TO TAKE IN CASE OF ACCIDENTAL SPILL

- **CLEANING:** Proceed to clean up the product.
- **PERSONAL PROTECTION:** No special measures are necessary.
- **ENVIRONMENTAL PROTECTION:** No special measures are necessary. Proceed to collect the product.



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10.7. HANDLING AND STORAGE

- **HANDLING:** No special measures are necessary.
- **STORAGE:** Keep the product away from direct sunlight, in a dry environment, and properly organized and dated.
- **PACKAGING MATERIAL:** Compatible with any standard packaging material.

10.8. EXPOSURE LIMITS / PERSONAL PROTECTION

- **PERSONAL PROTECTION EQUIPMENT:** No special measures are necessary for respiratory protection or protection of hands, eyes, or skin.

10.9. PHYSICAL AND CHEMICAL PROPERTIES

- **FORM / COLOR:** Dimensions and finish according to customer specifications.
- **SMELL:** Odorless.
- **PHYSICAL STATE CHANGE:**
- **Vicat softening temperature:** 78°C.
- **APPARENT DENSITY:** 1.49 g/CC.
- **SOLUBILITY IN WATER (20°C):** Insoluble.
- **SOLUBILITY IN OTHER SOLVENTS:** Soluble in THF.
- **PH VALUE:** Not applicable.
- **FLAMMABILITY:** Non-flammable. Combustion class: BZ1 (does not propagate the initiated combustion).
- **SELF-IGNITION:** The product is not self-igniting.
- **EXPLOSION RISK:** None.
- **VAPOR PRESSURE:** Not applicable.
- **n-OCTANOL/WATER DISTRIBUTION COEFFICIENT:** Not applicable

10.10. STABILITY AND REACTIVITY

- **DECOMPOSITION TEMPERATURE:** Stable under normal usage conditions.
- **HAZARDOUS DECOMPOSITION PRODUCTS:** In case of fire, HCl vapors and other products resulting from the combustion of PVC may be released.

10.11. TOXICOLOGICAL INFORMATION

- The product is biologically inert and non-hazardous.
- Currently, no data is available on toxic effects.



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10.12. ECOLOGICAL INFORMATION

- PERSISTENCE AND DEGRADABILITY: Not biodegradable.
- BIOACCUMULATION POTENTIAL: Not bioaccumulative.
- ECOTOXICITY: The product is biologically inert and non-hazardous. Currently, no data is available on toxic effects.

10.13. CONSIDERATIONS FOR DISPOSAL

Recycling or other forms of valorization are recommended in accordance with community legislation.

10.14. TRANSPORT INFORMATION

Transport according to current regulations.

10.15. REGULATORY INFORMATION

Applicable regulations are in force.

10.16. OTHER INFORMATION

The product should be stored, handled, and used in accordance with current occupational hygiene regulations. The information contained in this Safety Data Sheet is based on our current knowledge and shows, without obligation, the behavior of our products in tests. Under no circumstances do the data in this Safety Data Sheet constitute a guarantee of specific properties.

Cantisa S.A.U.



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