

Surteco USA Inc.
 7104 Cessna Drive
 Greensboro, NC 27409, USA
 Phone: (336) 668-9555
 Fax: (336) 668-7795

CANPLAST online
 E-mail: info@canplast.com
 www.canplast.com

Published 09/19/2012

Manufacturing Specifications North America – PVC Edgebanding

Color:

Slight variations may occur. Color must be evaluated visually, using standard lighting as originally used to develop the master. (ASTM D 1729) Tolerances are measured where possible by using CIElab at 10° angle / specular component included.

Gloss:

Gloss is measured by instrument at a 60° angle for smooth products. Tolerances are +/- 5 units.

Embossed surfaces cannot be measured accurately and are therefore visually evaluated.

Solvent Resistance: (coated products)

10 double rubs using a soft cloth wetted with either MEK or MIBK must result in no effect to gloss or print. (Use light hand pressure)

Finish: Must be consistent and without blemishes that are obvious when evaluated at a 3-foot distance from the observer.

Size:

Width	Imperial Tolerance
0 – 1-3/16"	± .012 (Brampton only)
1-1/4" and over	± .020

Width	Metric Tolerance
0 – 30.0 mm	± 0.30 mm
> 30.0 mm	± 0.50 mm

Thickness	Imperial Tolerance
Up to .024"	± .002
.025" to .040"	- 0.006"; + 0.004"
.041" to .080"	- 0.010"; + 0.006"
.081" and over	- 0.012"; + 0.008"

Thickness	Metric Tolerance
Up to 0.6 mm	± 0.05mm
0.7 to 1.0 mm	- 0.15 mm; + 0.15 mm
1.1 to 2.0 mm	- 0.25 mm; + 0.15 mm
2.1mm and over	- 0.30 mm; + 0.20 mm

Plane Parallelism:

Nominal thickness	Thickness Variance
Up to .080 "	≤ .004"
.081" and over	≤ .006"

Nominal Thickness	Thickness Variance
Up to 3.0 mm	≤ .20mm (Brampton only)
2.1mm and over	≤ .25 mm

Concavity:

Nominal Thickness	Concavity range
<i>For Widths up to 1-3/16</i>	
Up to .040"	n/a
.041" - .080"	0.004" to 0.012"
.081" and over	0.004" to 0.008"

Nominal Thickness	Concavity range
<i>For Widths up to 30 mm</i>	
Up to 1.0 mm	n/a
1.1 – 2.0 mm	0.10 mm to 0.30 mm
2.1mm and over	0.10 mm to 0.25 mm

For widths over 1-3/16"	
Up to .040"	n/a
.041" - .080"	0.006" to 0.014"
.081" and over	0.004" to 0.012"

<i>For widths up over 30 mm</i>	
Up to 1.0 mm	n/a
1.1 – 2.0 mm	0.15 mm - 0.35 mm
2.1mm and over	0.10 mm - 0.30 mm

Camber

Nominal Thickness	Camber
Up to .040"	≤ .250" on 36" length
.041" and over	≤ .125" on 36" length (Brampton only)

Nominal Thickness	Camber
Up to 1.0 mm	≤ 6 mm over 1.0 m length
1.1mm and over	≤ 3 mm over 1.0 m length (Brampton only)

Impact

Nominal Thickness	Gardner Impact
Up to .060"	≥ 20 in/lbs

Nominal Thickness	Charpy Impact
2.1 mm and over	10 J or higher