

## **End Grain Edge-Banding - Technical Sheet -**

### **1 Measurements:**

1.1 Thickness: 0.9mm ~ 3.5mm ( $\pm 0.1$ mm)

1.2 Width: 17mm ~ 250mm

#### **1.3 Format:**

##### **1.3.1 Rolls:**

1.3.1.1 Min. Length 50m to a max. of 200m, depending on the thickness

1.3.1.2 Internal Diameter: it varies accordingly to the thickness of the material  
(in detail: Ø300mm for thicknesses from 0.9mm to 1.5mm; Ø400mm for  
measures above)

##### **1.3.2 Sheets:**

1.3.2.1 According to the customer's requests

##### **1.3.3 Staves' measures:**

1.3.3.1 Standard stave is variable from 45 to 150mm.

1.3.3.2 Fixed staves are possible with personalized solutions. The length of a single stave  
can vary between 23mm and 250mm.

### **2 Processing:**

2.1 Coupling: with Natural veneer or Fineline

2.2 Glue: Polyurethane

2.3 Sanding: Variable grain sanding on top layer

### **3 Resistances:**

3.1 Heat Resistance: Up to 150°C

3.2 Moisture Resistance (applied on panel): 1.60 MPa after 24h conditioning

3.3 Water Resistance:

3.3.1 Edge-banding only: 60 minutes underwater at 40°C, no problem found

3.3.2 Applied on furniture: 24h underwater at 20°C, no problem found

3.4 Mechanical Resistance: the product can easily withstand continuous processing

### **4 Recommended Conditions:**

4.1 Storage packaging: nylon bag & carton box

4.2 Storage ideal temperature: from 10°C to 15°C

4.3 Working ideal temperature of the edge: 12°C or higher

4.4 Working ideal temperature of the ambient: 12°C or higher

4.5 Working ideal temperature of the panel: 12°C or higher

4.6 If above temperatures are lower than 12°C, River Lab recommends the use of heating phones to  
limit the temperature drop in the section between the spreading roller and the pressure point.

### **5 Post-Processing:**

5.1 Compatible with:

5.1.1 Lacquering

5.1.2 Waxing

5.1.3 Impregnating Oil

### **6 Certification:**

6.1 FSC Certification: Available upon customer's request

### **7 Patent of River Lab:**

7.1 Italian patent number IT0001412563.

7.2 European patent number 3147092.

### **8 Wood essences:**

8.1 All wood essences are available, both natural and smoked, homogeneous or with color  
differences and cracks (rustic).