

### 1. Manufacturer

REHAU, Inc.  
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### 2. Product Description

Recommended Uses: As one of the top innovators in edging, REHAU is constantly pushing the boundaries in product development and applications. The consistently updated range allows for surface applications in kitchens, offices, retail, living areas and general interior design. On many types of furniture, stylish colors and patterns are used to create colorful highlights and lead a sense of depth to the edge. REHAU edgeband can be used in both straight and curved applications.

Product Composition: PVC – no other polymer is as versatile. For decades it has been indispensable for its price to performance ratio. REHAU PVC edgeband continues to be a popular edging solution. The material can be recycled, is self-extinguishing and has a UV light fastness ISO 4892-2 rating of 7. Semi-rigid PVC is capable of making light radii on contour processing machinery.

ABS is another thermoplastic material. This impact resistant, tough material has many economic and processing advantages. It can be recycled or incinerated. REHAU ABS edgeband is highly heat resistant, has a UV light fastness ISO 4892-9 rating of 6 and can be processed on standard edgebanders.

Polypropylene edgeband has become very popular in the furniture industry in recent years. This material, with its soft cross-linked surface is environmentally sound. It requires very little energy to manufacture and can be recycled or incinerated. During incineration, it produces only carbon dioxide and water (as does natural gas). REHAU PP edgeband is suitable for use on standard edgebanders or on contour processing machinery. Our universal primer system guarantees optimum bonding of the edging with hotmelt adhesive made of EVA/PA or PUR. The edgeband has a UV light fastness ISO 4892-9 rating of 7. It is extremely resistant to heat and solvents, and has low shrinkage. PP is capable of making tight radii on contour processing machinery.

Acrylic (PMMA) is a high quality, proven thermoplastic material. PMMA has excellent light transmission and outstanding resistance to weathering and aging. In addition, PMMA has a high surface hardness and scratch resistance, does not contain cadmium or lead and fulfils PAH Category 2.

Basic Limitations: REHAU edgeband is not suitable for a cold gluing process. To prevent adhesion between layers, the storage temperature of edgeband should not exceed 77° F (25° C).

Colors: With a constantly updated and expanded color range, there is no doubting REHAU's design competence. Our North America edgeband collection encompasses more than 3,200 designs that are matched in texture, form, and appearance to the laminates produced by leading international manufacturers. All REHAU edgeband is produced to tight visual tolerances compared to the master sample. Slight color variation specifically from lot / lot is typical. Visual inspections are made in a controlled light setting with Cool White Fluorescent as the default source unless otherwise requested.

**Finishes:** The gloss level is measured using a 60° gloss meter. Standard gloss range is 9-15 but varies per customer request. Embossing of the edgeband surface will affect the gloss reading. Gloss readings for non-embossed surfaces should not be compared to embossed surfaces. Gloss level targets are achieved by applying a lacquer to the edgeband surface. The lacquer cure is monitored by checking with a solvent wipe test.

**Standard Stock Size:**

SpectraEdge Rigid - Thin	SpectraEdge Rigid - Thick	FlexEdge Semi-Rigid Thick
3/4 x .018	7/8 x 2mm	15/16 x 3mm
5/8 x .018	15/16 x 2mm	1-5/16 x 3mm
7/8 x .018	15/16 x 3mm	
15/16 x .018	1-5/16 x 3mm	
1-5/16 x .020		
15/16 x 1mm		

**Size Availability:**

**Rigid PVC, FlexEdge PVC & ABS Dimensions**

Thickness	Deviation for Non-Embossed	Additional Deviation for Embossed
0.016" to 0.031" (0.4 – 0.8 mm)	± 0.002" (0.05 mm)	NA
0.035" to 0.039" (0.9 – 1.0 mm)	± 0.004" (0.10 mm)	-0.002" (0.05 mm)
0.043" to 0.063" (1.1 – 1.6 mm)	± 0.006" (0.15 mm)	-0.002" (0.05 mm)
0.067" to 0.118" (1.7 – 3.9 mm)	± 0.006" (0.15 mm)	-0.004" (0.10 mm)
0.122" to 0.197" (4.0 – 5.0 mm)	± 0.008" (0.20 mm)	-0.004" (0.10 mm)
0.200" and up (5.1 mm and up)	± 0.012" (0.30 mm)	-0.004" (0.10 mm)

Width (min)	Width (max)	Edgeband Thickness ≤	Edgeband Thickness ≥
	11/16" (17 mm)	± 0.020" (0.5 mm)	± 0.008" (0.2mm)
>11/16" (17 mm)	1-5/16" (33 mm)	± 0.020" (0.5 mm)	± 0.012" (0.3mm)
>1-5/16" (33 mm)	1-9/16 (40 mm)	± 0.020" (0.5 mm)	± 0.016" (0.4mm)
>1-9/16" (40 mm)		± 0.020" (0.5 mm)	± 0.020" (0.5mm)

Pretension for edgeband <0.079" (2mm) is 0.012" (0-0.3mm)

Pretension Width (min)	Width (max)	Rigid PVC & ABS ≥ 0.079	FlexEdge PVC & ABS ≥ 0.079 (2mm)
	11/16" (17 mm)	0 – 0.004" (0.10 mm)	0 – 0.012" (0.30 mm)
>11/16" (17 mm)	29/32" (23 mm)	0 – 0.006" (0.15 mm)	0 – 0.020" (0.50 mm)
>29/32" (23 mm)	1-5/16" (33 mm)	0 – 0.008" (0.20 mm)	0.004" (0.10 mm) – 0.023" (0.60 mm)
>1-5/16" (33 mm)	1-9/16" (40 mm)	0 – 0.010" (0.25 mm)	0.008" (0.20 mm) – 0.031" (0.80 mm)
>1-9/16" (40 mm)	3-5/32" (80 mm)	0 – 0.012" (0.30 mm)	0.012" (0.30 mm) – 0.039" (1.0 mm)
>3-5/32" (80 mm)		0 – 0.012" (0.30 mm)	0.012" (0.30 mm) – 0.59" (1.5 mm)

**Straightness or curvature of length**

- Rigid PVC and ABS edgeband ≤ 0.023" (0.6 mm) the maximum allowable is 1.18" (30 mm) over 6'7" (2 m)
- Rigid PVC and ABS edgeband ≥ 0.023" (0.6 mm) but ≤ 0.031" (0.8 mm) the maximum allowable is 0.788" (20 mm over 6' 7" (2 m)
- Rigid PVC and ABS edgeband ≥ 0.031" (0.8 mm) but ≤ 0.067" (1.7 mm) the maximum allowable is 0.236" (6mm) over 6' 7" (2 m)
- Rigid PVC and ABS edgeband ≥ 0.067" (1.7 mm) the maximum allowable is 0.079" (2 mm) over 6'7" (2 m)
- FlexEdge PVC the maximum allowable is 1.57" (40 mm) over 6' 7" (2 m)

### Packaging

- 600 ft coils are standard for edgeband  $\leq 0.031''$  (0.8 mm)
- 400 ft coils are standard for edgeband 0.079'' (2 mm)
- 300 ft coils are standard for edgeband 0.118'' (3 mm)

### 3. Technical Data

#### Physical Properties of ABS Edgeband

Characteristics	Test Standard	REHAU ABS Edgeband
Light fastness for indoor applications	ISO 4892-2	>6
Indentation Hardness	DIN 53 456	103
Shore Hardness D Sensitivity to mechanical forces	DIN 53 505	70 $\pm$ 4
Resistance to warpage under heat – Vicat B 50	DIN ISO 306	185°F (85°C)
Shrinkage (in %)	194°F (90°)* & 230°F (110°C)*	<0.3% & <1.7% respectively
Chemical resistance	24-hour test with domestic cleaning agents	Resists a 24-hour test with domestic cleaning agents and is impervious to stains. The surfaces can be washed, are hygienically clean, and resistant to moisture.
Static charge	-	Very low
Disposal characteristics	-	May be recycled or incinerated
Physiological characteristics	-	No known source of harm to general health

\*Test carried out in loose storage for one hour (bonding reduces shrinkage)

#### Physical Properties of PVC Edgeband

Characteristics	Test Standard	REHAU PVC Edgeband
Light fastness for indoor applications	ISO 4892-2	7 to 8
Indentation Hardness	DIN 53 456	95
Shore Hardness D Sensitivity to mechanical forces	DIN 53 505	79 $\pm$ 4
Resistance to warpage under heat – Vicat B 50	DIN ISO 306	162°F (72°C)
Shrinkage (in %)	194°F (90°)* & 230°F (110°C)*	<0.3% & <1.7% respectively
Chemical resistance	24-hour test with domestic cleaning agents	Resists a 24-hour test with domestic cleaning agents and is impervious to stains. The surfaces can be washed, are hygienically clean, and resistant to moisture.
Static charge	-	Low
Disposal characteristics	-	May be recycled
Physiological characteristics	-	No known source of harm to general health

\*Test carried out in loose storage for one hour (bonding reduces shrinkage)

Physical Properties of PP Edgeband

Characteristics	Test Standard	REHAU PP Edgeband
Light fastness for indoor applications	ISO 4892-2	7 to 8
Indentation Hardness	DIN 53 456	98
Shore Hardness D Sensitivity to mechanical forces	DIN 53 505	73 ± 3
Resistance to warpage under heat – Vicat B 50	DIN ISO 306	212°F (100°C)
Shrinkage (in %)	194°F (90°)* & 230°F (110°C)*	<0.1% & <0.2% respectively
Chemical resistance	24-hour test with domestic cleaning agents	Resists a 24-hour test with domestic cleaning agents and is impervious to stains. The surfaces can be washed, are hygienically clean, and resistant to moisture.
Static charge	-	Low
Disposal characteristics	-	May be recycled or incinerated
Physiological characteristics	-	No known source of harm to general health

\*Test carried out in loose storage for one hour (bonding reduces shrinkage)

Physical Properties of PMMA Edgeband

Characteristics	Test Standard	REHAU PMMA Edgeband
Light fastness for indoor applications	ISO 4892-2	> 6
Indentation Hardness	DIN 53 456	-
Shore Hardness D Sensitivity to mechanical forces	DIN 53 505	80 ± 3
Resistance to warpage under heat – Vicat B 50	DIN ISO 306	> 80°C
Shrinkage (in %)	230°F (110°C)*	≤ 1.0%
Chemical resistance	24-hour test with domestic cleaning agents	Resists a 24-hour test with domestic cleaning agents and is impervious to stains. The surfaces can be washed, are hygienically clean, and resistant to moisture.
Static charge	-	Low
Disposal characteristics	-	May be recycled or incinerated
Physiological characteristics	-	No known source of harm to general health

\*Test carried out in loose storage for one hour (bonding reduces shrinkage)

**4. Technical Services**

For samples, literature, questions, or technical assistance, please contact us toll-free:

**Eastern US**  
(888)-734-2810

**Western US**  
(800) 944-1011

**Eastern Canada**  
(800)-361-0830

**Western Canada**  
(800)-668-1173

**Northern Mexico**  
(818)-121-0130

**Central and Southern Mexico**  
(800)-917-3428

**Central America**  
(507)-830-5257