



Technical Specifications ABS Edgebanding

Product Name

ABS (Acrylonitrile Butadiene Styrene) Edgebanding

Producer

TECE Dekor A.S.

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Description

- Suitable for edging of MDF and chipboard panels
- Excellent adhesion with hot-melt adhesives
- Colorized opaque base
- Original wood pattern and colors
- **Available surface finishes :**
 - Smooth
 - High Gloss
 - Matrix
 - Pearl
 - Ashpore
 - Woodpore
 - Woodline
- Excellent resistance to physical damage
- Edging applied to panels in all sort of furniture production.
- Chlorine-free plastic: Possibility to be recycled or incinerated with general waste.

Specifications

Color : Due to production at different times, slight color variations may occur between samples and final products.

Color Variation in Solid-Colors : There will be slight color variation. Maximum allowed deviation from the master sample to the new production is max. 1.0 on ΔE^* .

Color Fastness : All printed products use inks with a light fastness of 6–8 on the blue wool scale.

Gloss : The specified gloss, determined by ISO 2813, is as follows (equipment reading angle 60°)

- High Gloss Solid Colors : ≥ 90 GU
- High Gloss Woodgrains : ≥ 90 GU
- Woodgrains : 15–20 GU
- Embossed Surface : 5–10 GU

Dimensional Stability : During 1 hour at 80 °C the shrinkage is $<0,5$ %, according to internal test method. (Results may vary with edge band thickness and application conditions.)

Density : Range between 1.05 and 1.10 g/cm³, determined according to EN ISO 1183-1.





Characteristics	Test Standard	Tece ABS Edgebanding
Shore Hardness D	ISO 868	75 ± 4
Resistance to warping under heat Vicat B 50 (Softening Temperature)	ISO 306	100 ± 2°C
Impact Resistance 23°C (Charpy)	ISO 179-1	13 ± 2 kJ/m ²
Tensile Strength	ISO 527-2	46 MPa
Scratch resistance	EN 15186	≥ 1,5 Newton
Paint and varnishes-Cross cut test	ISO 2409	Table 1 - Classification of test results - Classification 1
Flammability	UL 94	HB
Width	-	X* mm ± 0,5mm
Thickness	-	0,40 mm +0,02 / -0,04 0,80 mm +0,04 / -0,12 2 mm +0,10 / -0,20
Resistance to Chemicals (except acetone, ethyl butyl acetate)	DIN 68861	Good (Class 1B)
Light Fastness (Xenon Arc, 200 h, BST 65°C, 17 min light / 3 min spray, 50% RH) (EN ISO 4892-2:2013+ A1:2021)	ISO 4892-2	ΔE _{cmc} = 0.4 - 1.4 No cracking, No chalking (Grey Scale ≥ 4)
Static Charge	Internal test	Low (non-antistatic)

* 19 mm - 610 mm width

Available Sizes

The width of the edge banding can be changed based on the customer demand (such as 22 mm, 33 mm, 42 mm, 44 mm or etc).

The standard length of 0,40 mm thickness ABS roll is 300 m.

The standard length of 0,80 mm thickness ABS roll is 150 m.

The standard length of 1 mm thickness ABS roll is 150 m.

The standard length of 2 mm thickness ABS roll is 100 m.

Available Instructions

ABS edge banding can be processed on all types of edge banding machines (straight edgebanders and BAZ machining centers) using hot melt adhesive techniques. For each machine, it might require special adjustment in the process or in the parameters.



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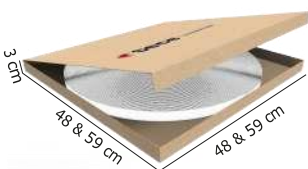
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Packaging

Dimension of the box changes as the width of the product changes.
The standard box dimensions are here below.

Product Thickness	Box Dimensions	# of lines on pallet	# of boxes by pallet	Total Pallet Weight	Pallet Size	What is inside of one box?
0.4mm-1mm Roll length is 300 meter between 0.4mm and 0.6mm of thickness. For 0.6mm - 1mm, it is 150 meter.		9 lines	36 boxes	1,008 kg	W 100 cm L 100 cm H 181 cm	0.4mm x 29mm = 1500 meter 0.8mm x 29mm = 750 meter 1mm x 29mm = 750 meter 0.4mm x 22mm = 2100 meter 0.8mm x 22mm = 1050 meter 1mm x 22mm = 1050 meter 0.4mm x 19mm = 2400 meter 0.8mm x 19mm = 1200 meter 1mm x 19mm = 1200 meter
1.5mm - 2mm Roll length is 100 meter between 1mm and 2mm of thickness		10 lines	40 boxes	1,280 kg	W 120 cm L 120 cm H 150 cm	2mm x 29mm = 400 meter 2mm x 22mm = 500 meter 2mm x 19mm = 600 meter
0,4mm - 2mm		40 lines	160 boxes	960 kg	W 105 cm L 105 cm H 240 cm	0.4mm x 19mm = 300 mt 0.8mm x 19mm = 150 mt 1mm x 19mm = 150 mt 2mm x 19mm = 100 mt 0.4mm x 22mm = 300 mt 0.8mm x 22mm = 150 mt 1mm x 22mm = 150 mt 2mm x 22mm = 100 mt



Storage

The recommended storage temperature is between 18° and 25 °C.
The product should be used up to 24 months after production date.



Cleaning

After the application of edgebanding to the board, remainder of the glue can be cleaned. To clean ABS edgebanding, we recommend using special cleaning materials for ABS. A test of the cleaning material is always recommended. Do not use solvent-base nor alcohol-base cleaning agent to defect the surface of ABS edgebanding.



Whitening Edges

During processing of above thicknesses 1mm, some darker colors (such as Wenge, Cherry) are sometimes prone to whitening on the trimmed edges (Especially, in above thickness of 1mm). This whitening can be removed by making sure that the trimming blades are sharp and the edgebanding machine uses the right polishing and by a subsequent polishing chemical.

Common Issues and Solutions

In the below table, you can see some of the common errors during processing of ABS edgebanding and recommended solutions. After following these instructions, if the problem still persists, please get in touch with Tece technical support.

Problem	Suggested Solution
For thickness above 0.8mm, the color tone in the trimmed side is becoming white or getting slightly lighter...	• Polishing unit must be active with the proper chemicals inside. Polishing makes the edgebanding to get back to the original color. • Make sure that the trimming knives are sharp and set to right position.
When cleaning with the solvent, the ABS surface is getting damaged...	In ABS, unlike PVC, the resistance to solvent is limited. Not all solvent is permitted. Ask your supplier to obtain solvent for ABS.
When turning radius, the turning point is whitening...	ABS's original color can be restored with heat. If you have hair dryer or hot air blower, you can use it on the whiten spot.
Edgebanding is easily being pulled off by hand. And, hotmelt adhesive remains on the chipboard for automated throughfeed edgebander or it remains on the edgebanding for manual edgebander...	• Make sure that the room temperature is minimum 15 °C • Make sure that the hot melt tank is at the right temperature. • Make sure that the hotmelt inside the tank has still its properties intact. When the same hotmelt is heated and then cooled down too many times, it loses its adhesion feature. Remove the tank and fill- in with new hotmelt. • Make sure that the edgebanding and the board are not too cold. Must be above 10 °C • Make sure that there is pressure on the roller. • Make sure that the machine is adjusted To the right thickness.