

Technical Specifications

ABS Edgebanding

1. Product name:

ABS (Acrylonitrile Butadiene Styrene) Edgebanding

2. Producer

TECE Dekor A.S.

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3. Description

- Any kind of MDF and chipboard edge band
- Perfect stick with hotmelt glue
- Colorized opaque base
- Original wood pattern and colors
- Available surface finishes :
 - Smooth
 - High Gloss
 - Matrix
 - Pearl
 - Ashpore
 - Woodpore
 - Woodline
- Excellent protection to physical damages
- Edging applied to panels in all sort of furniture production.
- Chlorine-free plastic: Possibility to be recycled or incinerated with general waste.

4. Specifications:

Color: Due to the fact that sample and the actual product have been produced at different times, there will be slight color variation.

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 delta E*.

Color Fastness: All our products are printed with inks with woolscale of 6-8.

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

- High Gloss Solid Colors : ± 93
- High Gloss Woodgrains : ± 93
- Woodgrains : ± 17
- Embossed Surface : ± 7

Dimensional Stability: During 1 hour at 80 °C the shrinkage is $<0,5\%$, according to own method.

Density: Range between 1.05 gr/cm³ and 1.10 gr/cm³ according to the standard DIN 53479.

Characteristics	Test standard	Tece ABS edgeband
Shore hardness D	DIN 53 505/ISO 868	72 \pm 4
Resistance to warping under heat Vicat B 50 (Deflection temperature underload, Softening Temperature)	DIN 53 460 / ISO 306 B	100 \pm 2 °C
Impact resistance 23°C (Izot)	ISO 179/2C	13 \pm 2 kJ/m ²
Tensile strength	ASTM D 638 M	46 MPa
Tensile elongation	ASTM D 638 M	% 40
Flammability		HB
Width	-	X* mm \pm 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 68 861	Good (Class 1B)
Static charge	-	Low

*19mm-260 mm width

5. Available Sizes

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

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

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

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

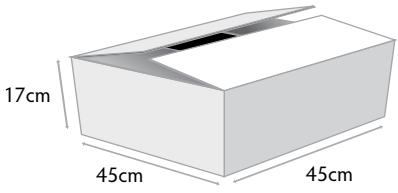
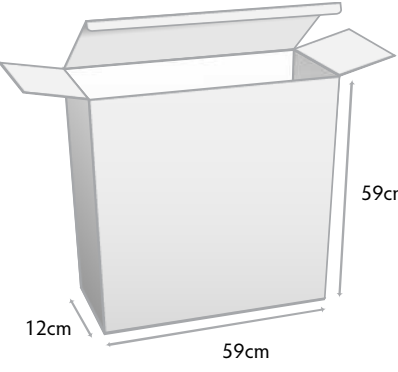
The standard length of 2mm thickness ABS roll is 100 mt.

6. Application Instructions

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

7. 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?
0.4 mm - 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	W100cm L100cm H181cm	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	W120cm L120cm H150cm	2mm x 29mm = 400 meter 2mm x 22mm = 500 meter 2mm x 19mm = 600 meter

8. Storage:

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

9. Technical Services

In case you need any technical support, please contact TECE at

Tel: +90 224 242 2100

Fax: +90 224 243 8525

10. 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.

11. Whitening Edges

During processing of above thickness 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.

12. 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 staff.

Problem	Suggested Solution
For thickness above 0.8mm, the color tone in the trimmed side is becoming white or getting slightly lighter...	<ul style="list-style-type: none"> 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...	<ul style="list-style-type: none"> 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.

The information provided is above based on the information of our suppliers and our own experience. Issues that can occur without our control, we shall not be held liable. Our ABS materials should be test and inspected before running into standard production. This file was prepared on January 2016.