MOBELKANT

NEW THINKING | BETTER EDGEBANDING

# ABS EDGEBANDS | TECHNICAL SPECIFICATIONS 1/2

## 1 MATERIAL PROPERTIES

| | |
|---|---|
| Embossing: | Various embossing structures are applied according to customer requirements . |
| Wood Decors: | The inks used for the surface printing application have a minimum light fastness grade of 7. The decor is then coated with acrylic UV lacquer for the highest scratch resis tance. |
| Primer: | The back side is primered to suit bonding with all the conventional hot-melt adhesives |

## 2 APPLICATIONS

ABS is a shockproof, high-quality thermoplastic edgeband based on ABS (Acrylonitrile Butadiene Styrene). It can be processed easily on edgebanding machines for covering the edges of carrier materials, mainly chipboards and MDF.

## 3 TECHNICAL CHARACTERISTICS

| PROPERTY | TEST METHOD | VALUE |
|---|---|---|
| Light Fastness | EN 438-2 | 4 |
| Hardness Shore D | DIN 53 505 / ISO 868 | 71 ± 4 |
| Indentation Hardness | ISO 2039-01 (Nt/mm2) | 90-110 N/mm2 |
| Vicat Softening Temperature | DIN 53 460 / ISO 306B | 100 +/- 2˚C |
| Flammability | | HB |
| Impact Strength, 23˚C Notched | ISO 179/2C | 17-19 +/- 2 (Kj/m2) |
| Impact Strength, 23˚C Unnotched | ISO 179/2D | No Break |
| Shrinkage (1h at 80˚C) | Works standard | < 0,7 % |
| Resistance to Chemicals | DIN 68861 | Excellent (Class 1B) |
| Static Charge | | Very low |

## 4 PACKING INFORMATION

| | | |
|---|---|---|
| Product | Thin: 0.40mm-1.20mm | Thick: 1.30mm-3.00mm |
| Method | Calender | Extrusion |
| Core | Plastic | Plastic or None |
| Inner Core Diameter | 6 inches | 15 inches |
| Outside Core Diameter | 430mm | 660mm |
| Length | +/- %2 | +/- %2 |
| Packaging, Labelling and Palleting | All customer requirements are possible | |

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**FACTORIES**
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2 Melek Aras Bul. Tuna Cad. No:10 KOSB Tuzla/İstanbul
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## 5 TOLERANCES

| | | | |
|---|---|---|---|
| **Width** | 18-54mm | +/- 0.45mm | |
| **Thickness** | 0.00mm-1.00mm | +0.15/-0.10mm | |
| | 1.10mm-2.00mm | +0.10/-0.20mm | |
| | 2.10mm-3.00mm | +0.15/-0.25mm | |
| **Pretention** | **Thickness** | **Width<=30mm** | **Width>=30mm** |
| | 0.0mm-0.50mm | 0.0mm-0.40mm | 0.0mm-0.50mm |
| | 0.0mm-0.40mm | 0.0mm-0.30mm | 0.0mm-0.40mm |
| **Parallelism** | **Thickness** | **Deviation** | |
| | 0.00mm-2.00mm | 0.10mm | |
| | 2.10mm-3.00mm | 0.15mm | |
| **Longitudinal Distortion** | **Thickness (0 – 3.0)** | **Max. 3mm/1mt** | |
| **Delta E- Unicolors ( DL, a, b)** | < 1 | | |
| **Gloss Level** | 5-30 | 31-90 | |
| | ± 3 | ± 5 | |

## 6 PROCESSING

ABS edges can easily be processed with all conventional hot-melt adhesives (EVA, PA, PO, PUR) in the edgebanding machines .

| Machining | Suitability |
|---|---|
| Cutting | Very Good |
| Rough Milling | Very Good |
| Radious Milling | Good |
| Profiling | Good |
| Side Scrapping | Good |
| Buffing | Good |
| Polishability | Good |
| Stress Whiting | Low |
| CNC Workability | Very Good |

## 7 STORAGE

ABS edges should not be stored under direct sunlight or in extreme temperatures. Avoiding these extreme conditions, the edge can be stored for a long time with no change to its properties. However, it is important that the material should rest for at least one day at room temperature prior to processing.

## 8 CLEANING

ABS edge is easy to clean using commercially available cleaning agents suitable for plastic surfaces. The use of solvent or alcohol-based subs tances should be avoided as they could partially dissolve the surface.

## 9 HAZARDS INFO

ABS Edge does not contain any materials hazardous to health that can be emitted during processing or storage. The material is suitable for recycling; however it is not suitable for incineration.

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