



Product Sheet

ABS Plain Colour Edgings - UNI

ABS plain colour edgings are extruded, thermoplastic edges of high quality made from a thermal, mechanically stable thermoplastic - ABS (Acrylonitrile-Butadiene-Styrene). It has a protective and decorative function for the edges of furniture boards.

ABS plain colour edgings exhibit good interior colour stability, withstand high mechanical forces, fulfil the most stringent qualitative and ecological standards, are harmless for the human health and do not contain heavy metals and phthalates.

Adhesion Properties:

ABS plain colour edgings are coated with a layer of primer on the reverse that, in connection with suitable glue (based on EVA, PUR, PO or APAO), ensures adhesion to the boards.

Protective Top Coating:

ABS plain colour edgings can be coated with protective layer with different gloss levels to improve scratch resistance to the surface.

ABS Plain Colour Edgings - Parameters:

Thickness Tolerances

Thickness in mm	Tolerance	
0,45 - 0,6 mm	- 0,05 mm	+ 0,05 mm
0,7 - 1 mm	- 0,10 mm	+ 0,10 mm
1,1 - 1,6 mm	- 0,20 mm	+ 0,10 mm
1,7 - 2 mm	- 0,25 mm	+ 0,15 mm
2,1 - 5 mm	- 0,30 mm	+ 0,15 mm

Width Tolerances

Width in mm	Tolerance	
11 - 31 mm	- 0,3 mm	+ 0,5 mm
above 32 mm	- 0,5 mm	+ 0,5 mm

Edging Profile Tolerance*

Profile Tolerance	Internal Test Method
Bottom Side of Edgings	$\leq 0,2$ mm

* slight bent in cross cut profile of the edgings ensures optimal connection to the board due to absorption of the glue in the central part of the edgings and minimizing of the joint between edgings and the board.

Roll Length Tolerance*

	Tolerance
Nominal Length of the Roll	$\pm 1,5$ %

* there can be max. one joint within the roll length. Rolls with joint are marked with green rectangular sticker with wording "joint in the roll" directly on the roll or on the palette.

Plain Linearity

Longitudinal Deformation	Internal Test Method
All Widths	< 3 mm/1 m



Qualitative Characteristics

Properties	Values	Standard
Light Fastness	≥ 6	ČSN EN ISO 4892-2
Softening Point (Vicat B 50)	~ 95 °C	ČSN EN ISO 306
Shrinkage	< 1 % at 85 °C during 1 hour	Internal Test Method
Hardness (Shore type D)	~ 73	ČSN EN ISO 868
Chemical Resistance*	1 B	DIN 68861-1

* exception of acetone and etyl-butyacetate.

Surface Finish - Top Coat

Structure	Surface Pattern	Tolerance
Coated Surface MATT: 3° of Gloss	smooth	-2°/ +3°
Coated Surface: 6° - 60° of Gloss (max 30° for surfaces wooden pore and pearl)	smooth, wooden pore, pearl	-5°/ +5°
Coated Surface High Gloss: 90° of Gloss	smooth	-10°/ +10°

*measured with a gloss meter at the angle of 60 degrees. Coated surfaces 3° and 90° Gloss are produced from the minimum thickness of 0,8mm.

Colour Tolerances*

Colour Shade	L Value	Internal Test Method
White Shades	L ≥ 90	Δ E ≤ 0,8
Light Colours	70 ≤ L < 90	Δ E ≤ 1,0
Dark Colours	L < 70	Δ E ≤ 1,5

* measured with spectrophotometer with D8* geometry and D65 light exposure.

Application of Functional Layer Based on EVA

	Quantity	Tolerance
Colour Shade*	160 g/m ²	± 10%

* please follow information specified in Product Sheet for Functional Layer (PS FL ENG – valid version) – to select right colour and application.

Width of applied functional layer can be max 1mm narrower (from each side of the edgings) then the width of the edgings.

Edges in thicknesses from 0.8 to 2 mm are used for application of the functional layer (please see PS FL ENG – valid version)

Application of Hot Melt Based on EVA

	Quantity	Tolerance
Colour Shade*	160 g/m ²	± 10%

* contact your sales representative for available colours of hot melt layer.



Processing

Technology	Comments
Sawing	yes
Cross Cutting	yes
Top Coating	yes
Radius Milling	yes
Buffing	yes
Pre-Milling	yes
Machine Gluing	yes
Milling Direction	machine direction, opposite direction
Bending 0,45 - 0,9 mm Edging	yes, radius min. 30 mm (min. 50 mm for coated edgings)
Bending 1 mm - 1,5 mm Edging	yes, radius min. 40 mm (min. 60 mm for coated edgings)
Bending 1,6 mm - 2 mm Edging	yes, radius min. 50 mm (min. 60 mm for coated edgings)
Bending 2,1 mm - 3 mm Edging	yes, radius min. 60 mm (min. 60 mm for coated edgings)

Application:

ABS plain colour edgings are suitable for all types of furniture, mainly for areas with high potential of wear. ABS plain colour edgings are specified for interior application.

Gluing Techniques:

- On edgebanding machines using hot-melt adhesives based on EVA, PO, APAO, or PUR.
- On edgebanding machines utilizing HOT AIR technology.
 - ABS edge with an additional layer of special polymer material (AdvantEdge®), ensuring a flawless appearance and optimal adhesion between the edge and the board.
- On edgebanding machines utilizing LASER or HOT AIR technologies.
 - ABS edge with an additional layer of special polymer material (AdvantEdge® Ultra), ensuring a flawless appearance and optimal adhesion between the edge and the board.
- Manual edgebanding using a heat gun – ABS edge pre-coated with EVA-based hot-melt adhesive.
- Manual application using contact adhesive.

Gluing Conditions:

Moisture level of the edgings and boards should be between 8 – 15%.

Temperature of the boards, edgings and environment during gluing: min. 15°C.

Paintable ABS edging:

ABS plain colour edgings can on their top side be modified by secondary primer layer to achieve adhesive properties necessary for additional painting. For best final appearance it is recommended to use ABS plain colours edgings in white colour and smooth surface finish (easiest coverage with additional paint layer) together with white glue based on PO or PUR (smallest possible joint for best final look). It is essential to run compatibility and performance initial trial before entering production with this kind of product. Cleaning of the edge surface before painting should be done without solvents as this would cause loss of adhesive properties of the edge.



Stress Whitening:

Some colours of ABS plain colour edgings can exhibit stress whitening on the worked surfaces (radius milling mainly). Correct settings of gluing machine and additional buffing can minimize this effect. Contact your local sales representative for more information.

Surface Defects:

Potential surface defects of ABS plain colour edgings are evaluated from the distance of 70cm (potential defects should not affect visual appearance of the surface from this distance). Surface defects can be classified like: black specks, dots, lumps, dents, cracks, waves, colour changes, gloss level changes, etc.

Cleaning from the glue residues:

For cleaning of ABS plain colour edgings from the glue residues we recommend special cleaning agents based on hydrocarbons and alcohol (free of aromatic substances and solvents). We recommend cleaning agents Hraniclean 01, Hraniclean 08, and RI408 LP 305/98 for manual cleaning and Hraniclean 106, RI006 LP 163/93 for machine application.

Cleaning of surfaces:

For cleaning of surfaces of ABS plain colour edgings, we recommend Hranipex product Hraniclean Soft Line (do not use cleaners containing acetone or ethyl-butylacetate).

Fine surface structures of ABS plain colour edgings (e.g. pearl) are sensitive to mechanical damage during cleaning process with cleaners and cloths. It can result in white maps on the surface after cleaner evaporation. This effect is standard behaviour of ABS materials and shall not be a reason for quality claim of the product.

Storage Conditions:

Store under appropriate conditions – temperature between 15 - 25°C, relative humidity 55 - 60%, in closed packaging to protect against direct sunlight. We strongly recommend making an application trial for the ABS plain colour edgings older than 12 months after delivery date.

Disposal:

ABS plain colour edgings and boards covered with ABS edgings plain colours can be disposed according to the regulation of each country – e.g. incinerated or landfilled.

Information given in this Product sheet are to the best of our knowledge, however are not binding, especially in view of possible property rights of third parties. Company Hranipex will neither directly nor indirectly participate in any compensation of the customer or third party.

Company Hranipex strongly recommends to every customer to execute its own testing of ABS plain colour edgings for the planned methods and application. Indicated data serves for orientation only and do not represent any specification, nor give warranty to the edge banding characteristics.

We keep the right to change or update information in this Product sheet at any time.

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