



Product Sheet AdvantEdge® – Furniture Edgings for Zero-Joint Bonding

AdvantEdge® (further as AE or AE layer)

AdvantEdge® is furniture edgings additionally coated with specific polymeric material enabling utilisation of Hot Air technology for bonding the edging to the boards without adding any additional glue.

The main advantage of new AE layer is that it can be tinted to the colour of the base ABS edging and thus achieving of zero-joint effect in the final product. Hranipex offers AE layer in almost unlimited colour choice matched to the individual decors of furniture edgings.

Additional advantage of new AE layer in comparison to standard functional layer based on EVA or APAO glues is its higher temperature and moisture resistance.

Application:

- Edge banding of standard furniture parts made of MFC and MDF boards,
- Edge banding of high gloss or matt furniture parts, where the basis is made of MFC or MDF boards,
- Zero-joint effect edge banding.

Edging designation/label:

Edgings with additionally applied AE layer are designated – see label below:



In case of rewinding, the roll may be labeled by a standard white label:



Properties of AE layer

- Softenning point above 150°C (EN 1427 ring&ball)
- Colour according to the based colour of edging

Basic setting recommedations for appliation of edging with AE layer

Bellow mentioned setting are basic general recommendations of individual parameters based on our experiences with our edging in dimension of 22 x 1 mm. Exact settings can differ on individual machines based on specific machine type and it's generation and also based on dimension of edgings used. In case of requirement for specific setting recommendation please contact your sales representative.

Temperature aggregate	Temperature die/nozzle	Air pressure at nozzle	Air volume	Roller pressure
°C	°C	bar	l/min	bar
550–680	420–460	2–3	850–1000	3.5–6

If the first pressure roller after hot air aggregate is not driven it is recommended to reduce the pressure of this roller to minimize the slip of AE layer on the board, due to the resistance of non-driven roller, to eliminate adhesion drop at the from side of the board.



ABS edging parameters:

Suitability for ABS

Thickness in mm	Note
minimum 0.8 mm maximum 2.0 mm	The exception is the Senosan edge collection in thickness 0.7 mm

Edge width

Width in mm	Note
12–65 mm	The width of the applied layer of the hot melt adhesive or functional layer can be up to 1 mm narrower on each side of the applied edge.

Conditions during edge banding:

The humidity of the banded material and edging during edge banding in the range of 8 to 15 %.
Temperature of the banded material, edging and the surrounding area during edge banding: 15 °C or higher.

Cleaning:

For the removal of AE layer residues, we recommend using special cleaners based on hydrocarbons and alcohol, free of aromatic substances and solvents. From Hranipex cleaning products, we recommend Hraniclean 08 and RI 408 for manual use and RI 006 LP 163/93 for machine use.

For edging surface cleaning, we recommend common household cleaners or alcohol (we do not recommend cleaners based on acetone and ethyl-butyl acetate).

The fine surface of the edging (e.g. pearl) is prone to mechanical damage when cleaned using cleaners and fabrics. It can lead to visual whitening of the surface after the cleaner evaporates. This effect is a standard feature of the ABS material and is not a reason for complaint. To restore the original appearance of the edging, we recommend briefly applying heat to the edge surface – e.g. with a hair dryer or hot-air gun.

Storage:

Furniture edging with applied AE layer should be stored at a temperature of 15–25 °C and air humidity of 55–60 %, in closed packaging as light protection. Edging older than 12 months from the date of delivery should be subject to an edge banding adhesion test.

Disposal:

Furniture edging with applied AE layer and boards banded with an ABS edging can be disposed according to the regulation of each country – e.g. incinerated or landfilled.

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HRANIPEX recommends every customer to test the ABS edging parameters in common practice, as different methods of banding and using different types of machines may change the parameters for correct processing of ABS edging. In addition, further processing and use of processed products may have different impacts on these products. Therefore, HRANIPEX does not guarantee the fitness, suitability or appropriateness of the products for any purpose stated by the Buyer or any third party and does not bear any responsibility in this regard. The Buyer is required to test the products and determine whether they are suitable for the intended use.

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