

A photograph showing several curved, light-colored ABS natural finish edgings. One edging is dark brown, while the others are light beige. They are arranged in a circular pattern, overlapping each other. A metal tool, possibly a scraper or a part of a machine, is visible in the background, interacting with the edgings.

## Product Sheet ABS Natural Finish Edgings

ABS natural finish edgings are extruded, thermoplastic edges of high quality with printed decors imitating natural surfaces like wood, stone and others made from a thermal and mechanically stable thermoplastic - ABS (Acrylonitrile-Butadiene-Styrene). It has a protective and decorative function for the edges of furniture boards.

ABS natural finish 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 natural finish 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 natural finish edgings are coated with protective layer with different gloss levels to improve scratch resistance of the surface.

## ABS Natural Finish Edgings - Parameters:

### Thickness Tolerances

Thickness in mm	Tolerance	
0,45 - 1 mm	- 0,15 mm	+ 0,10 mm
1,1 – 1,6 mm	- 0,20 mm	+ 0,10 mm
1,7 – 2,0 mm	- 0,25 mm	+ 0,10 mm
2,1 – 4,0 mm	- 0,30 mm	+ 0,15 mm
4,0 – 5,0 mm	- 0,30 mm	+ 0,20 mm

### Width Tolerances

Width in mm	Tolerance	
All widths	- 0,5 mm	+ 0,5 mm

### Edging Profile Tolerance\*

Profile Tolerance	Internal Test Method
Bottom Side of Edgings	≤ 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	± 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	$\geq 5$	ČSN EN ISO 4892-2
Softening Point (Vicat B 50)	$\sim 95$ °C	ČSN EN ISO 306
Shrinkage	$< 1$ % at 85 °C for 1 hour	Internal Test Method
Hardness (Shore type D)	$\sim 73$	ČSN EN ISO 868
Chemical Resistance*	1 B	Din 68861-1

\* exception of acetone and ethyl-butyl-acetate

## Surface Finish - Top Coat

Structure	Surface Pattern	Tolerance
Coated Surface: 6° - 30° of Gloss	smooth, wooden pore, pearl	$\pm 5^\circ$
Coated Surface: 30° - 60° of Gloss	smooth	$\pm 10^\circ$
Coated Surface: 90° of Gloss	smooth	$\pm 10^\circ$

## Colour Tolerances

Visual comparison with reference sample under following conditions.

- ✓ Evaluation in the light box under day light (D65 – daylight light source)
- ✓ Reference and produced samples are placed at the distance of 2-3 cm to each other.
- ✓ Observation angle between sample and table is 75°, observer is located at the front of the table and the samples are observed from the distance approx. 70cm.
- ✓ It is recommended (due to possible metamerism effect) to evaluate the sample under different light sources (D65 – daylight, A – bulb light, F11 – fluorescent light).

## Application of Function Layer Based on EVA

	Quantity	Tolerance
Colour Shade*	160 g/m <sup>2</sup>	$\pm 10\%$

\* please follow information specified in Product Sheet for Functional Layer (PS ABS 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.  
Minimum recommended thickness of edgings for transparent functional layer is 0,8 mm (please see PS ABS FL ENG – valid version)

## Application of Hot Melt Based on EVA

	Quantity	Tolerance
Colour Shade*	160 g/m <sup>2</sup>	$\pm 10\%$

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

## 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. 50 mm
Bending 1 mm - 3 mm Edging	Yes, radius min. 60 mm

## Application:

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

## Gluing Techniques:

- Machine bonded with use of suitable glues - EVA, PO, PUR and APAO.
- Machine bonded with use of laser, hot air or infra-red heating – ABS edgings with applied functional layer, based on EVA or PO that ensures required adhesion to the boards (please always follow information in Product Sheet for Functional Layer – PS ABS FL ENG – valid version).
- Manual bonding machine with hot air nozzle - ABS edgings with applied functional layer.
- Manually, with use of contact adhesives.

## 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. It is necessary, in case of need of preheating of the materials stored in cold conditions, to eliminate any moisture condensation on the surfaces that would negatively impact strength of bonding. The board and edge must be heated slowly.

## Stress Whitening:

Some colours of ABS natural finish 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 natural finish edgings are evaluated under daylight 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 specs, dots, lumps, dents, cracks, waves, colour changes, gloss level changes, printing defects, etc.

## Cleaning:

For cleaning of ABS natural finish 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 and RI408 for manual cleaning and RI006 LP 163/93 for machine application.

For cleaning of surfaces of ABS plain colour edgings, we recommend standard household cleaners or alcohol (do not use cleaners containing acetone or ethyl-butyl-acetate).

## 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 natural finish edgings older than 12 months after delivery date.

## Disposal:

**ABS natural finish edgings and boards covered with ABS natural finish edgings 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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