

## PRODUCT DATA SHEET

### EGGER ABS EDGING



EGGER ABS edging tape is a thermoplastic edging product with protective and decorative properties for finishing the narrow sides of wood-based panels. EGGER ABS edging is made of ABS and is uniformly coloured through. A universal bonding agent (primer) is applied to the reverse side as standard.

### Uses / Applications

EGGER ABS edging tape is used to finish the narrow sides of laminated wood-based materials such as chipboard, MDF, HDF and Lightweight boards and provides the perfect finishing touch for all decorative surfaces. It can be used in a wide variety of areas: furniture for kitchens, bathrooms, offices and bedrooms, living rooms and teenager rooms, exhibition builds and shopfitting systems, cabinet fronts, furniture carcasses. EGGER ABS edging tape is also suitable for finishing individually shaped freeform furniture components.



### Product Properties

#### MATERIAL

ABS (acrylonitrile–butadiene–styrene) is an impact-resistant and mechanical and thermal-resistant high quality chlorine-free thermoplastic which is ecologically sound. ABS is resistant to acids, alkalis, salts, alcohol and oils but to a limited extent only to organic solvents and petrol. The highly impact-resistant material ensures long tool life for milling and other cutting tools. . EGGER ABS edging possesses excellent resistance to extreme fluctuations in temperature and humidity.

#### PRODUCTION

EGGER ABS edging tape is starting from a thickness of 0.8 mm an extruded product, edging tape thinner than 0.8 mm is made on a calendar machine.

## SURFACES

The surfaces of EGGER ABS edging tape are sealed with scratch resistant UV-hardened synthetic resin lacquers (UV coating process) , and have a high mechanical wear resistance. Further product attributes include high viscosity, notch impact strength, impact resistance, bending strength and surface hardness. After 24 hours of exposure they remain resistant to staining and to almost all household cleaners. The surfaces are wipeable, hygienically safe and moisture-resistant.

## BONDING PROPERTIES

The reverse of EGGER ABS edging tape is coated with a universal bonding agent which, in conjunction with conventional hot-melt adhesives ensures that a firm bond is established between edging tape and substrate. The bonding agent coating has been optimized for use with \*EVA, PA, APAO and PUR hot-melt adhesives. Adhesives that are highly heat resistant should be used where the product is likely to be exposed to critically high temperatures, e.g. in the kitchen or when exporting furniture in shipping containers. Polyurethane hot-melt adhesives are particularly suitable for use in damp conditions. Always follow the instructions of the respective adhesive supplier.

- \* EVA - Ethyl Vinyl Acetate
- PA - Polyamide
- APAO - Amorphous Poly Alpha Olefins (based on polyolefin)
- PUR - Polyurethane

## Quality Features / Technical Data

Any material or process related irregularities must not be apparent at a distance of 0.5 m. Due to the precise pre-tensioning and plane-parallelism of EGGER ABS edging tape a tight, almost invisible seam is achieved. The pre-tensioning also ensures optimum bonding by taking up any excess glue at the midpoint of the back of the edging and anchor points of the glue in the chipboard.

Properties	Unit	Value	Standard
Light fastness (for internal application)	-	> level 6	ISO 877
Indentation hardness	N/mm <sup>2</sup>	90-110	ISO 2039-1
Hardness Shore D	-	70 ±4	ISO868
Impact strength, 23 °C notched	KJ/m <sup>2</sup>	17-19	ISO 179/2C
Impact strength, 23 °C unnotched		No break	ISO 179/2D
Vicat softening temperature (50 °C/h, B 50N)	°C	Approx. 98	ISO 306
Chemical resistance	-	Good 1-B	DIN 68861
Shrinkage (1h at 80°C)	%	<0.6	Works standard
Static charging	-	Very low	-

## PROCESSING CHARACTERISTICS

Machining	Suitability
<ul style="list-style-type: none"> <li>▪ Cutting</li> <li>▪ Milling direction<sup>1)</sup></li> <li>▪ Pre-milling</li> <li>▪ Radius milling</li> <li>▪ Profiling</li> <li>▪ Scraper processing</li> <li>▪ Buffing</li> <li>▪ Bonding</li> <li>▪ Polishability</li> <li>▪ Stress whitening</li> <li>▪ Lacquerability</li> <li>▪ Machining on BAZ processing centre</li> </ul>	<p>good</p> <p>Conventional milling / climb milling <sup>1)</sup></p> <p>good</p> <p>good</p> <p>good</p> <p>good</p> <p>good</p> <p>Any conventional hot-melt adhesive suitable for edging tapes can be used</p> <p>good</p> <p>medium</p> <p>good (Acrylic/PUR-lacquer)</p> <p>good</p>

<sup>1)</sup> Conventional milling is recommended for all thermoplastic edging material

ABS Edgings are good electrical insulators and possess high surface and volume resistivity.

## Tolerances

### EDGE BANDING TAPE WIDTH

Width [mm]	Tolerance [mm]
12 to 54	± 0.45

### EDGE BANDING TAPE THICKNESS

Thickness [mm]	Tolerance [mm]
0 to 1.0	+ 0.15 / - 0.10
1.1 to 2.0	+0.10 / - 0.20
2.1 to 3.0	+ 0.15 / - 0.25

### PRE-TENSIONING

Thickness [mm]	Width tolerance [mm]	
	to 30	from 30
0 to 1.0	0.00 – 0.40	0.00 – 0.50
1.1 to 3.0	0.00 – 0.30	0.00 – 0.40

## PLANE-PARALLELISM

Thickness [mm]	Maximum deviation [mm]
0 to 2.0	0.10
2.1 to 3.0	0.15

## LONGITUDINAL DISTORTION

Thickness [mm]	Maximum distortion for every 1 meter length
0 to 3.0	3 mm

## STORAGE

EGGER ABS edging tape is rot resistant and can therefore be stored for an almost unlimited period of time at room temperature (20 to 25°C) in areas that are protected from the elements. However, tests should be carried out prior to processing any edging material that is more than 12 months old.

## CLEANING

EGGER ABS edging tape is easy to clean using commercially available cleaning agents suitable for plastic surfaces. The use of petrol, thinners, acetic acid, nail polish remover or similar solvent- or alcohol-based substances may partially dissolve the surface, and should therefore be avoided.

## DISPOSAL

In view of the high calorific value, thermal utilization of the product is essentially possible. Various expert opinions have substantiated that this process is not expected to significantly increase harmful emissions. ABS edged work pieces correspond to combustion material class 6 of the 1st BImSchV (First Ordinance on the Implementation of the Federal Emission Control Act (ordinance on small and medium-sized firing plants – 1st BImSchV) of 14th March 1997) and can be disposed of in wood firing plants with a nominal energy content of at least 50 kW. (Energy content is the amount of heat generated by a firing plant which can be utilized in a heating system. The energy content is measured in Kilowatt kW). Waste from EGGER ABS edging tape can be incinerated together with wood chip waste in systems approved for this purpose. The process does not produce chlorine compounds and complies with the stringent TA Luft limit values. Even ABS edged chipboard panels can be disposed of by incineration. There is no need for time-consuming sorting of waste or separation of edge banding and board material.

Information on processing EGGER ABS edge banding tape can be found in our processing instructions!