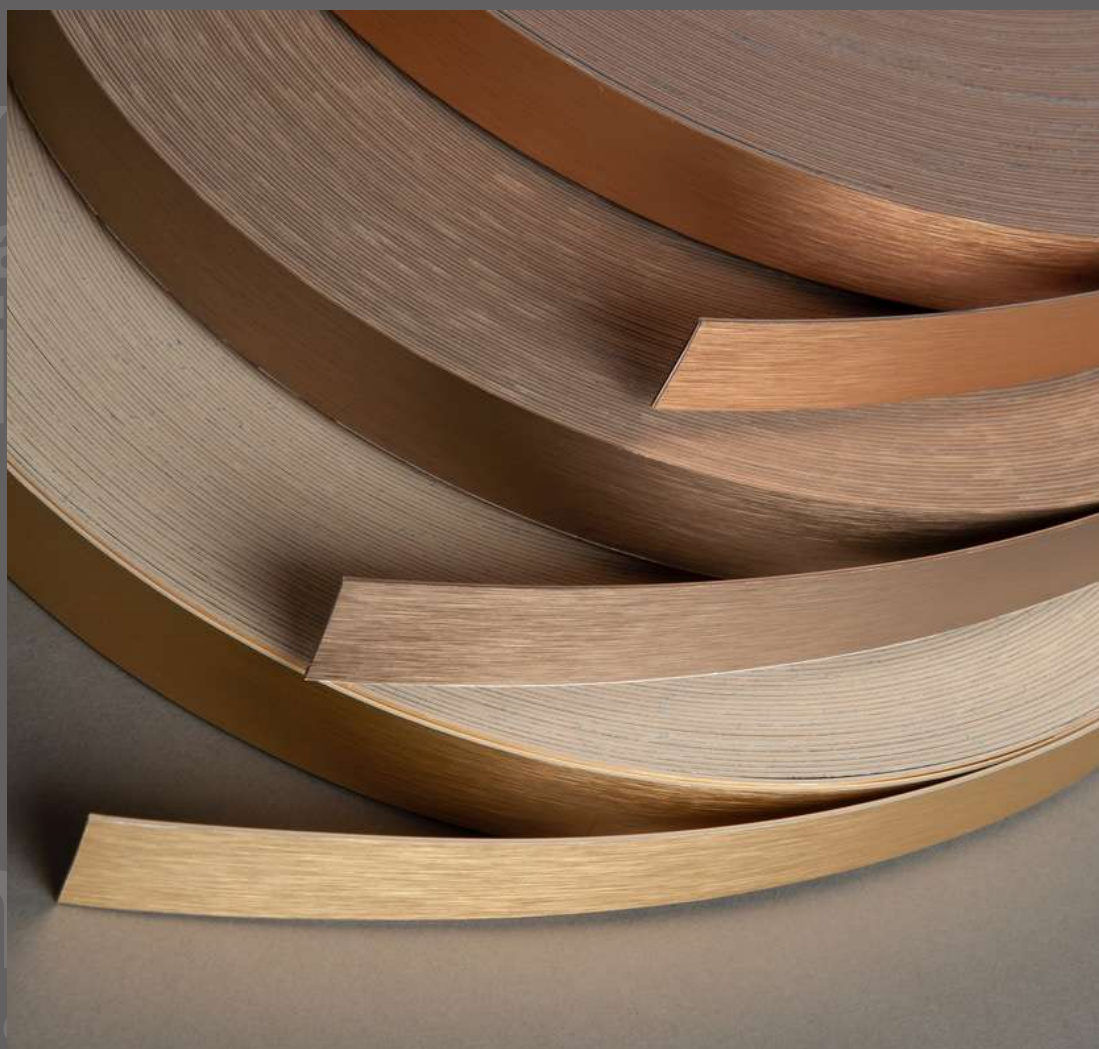




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## **ABS** Technical datasheet



## 1 ABS PHYSICAL PROPERTIES

PHYSICAL PROPERTIES	STANDARD FOR TESTING	VALUE
DENSITY	ISO R 1183	0,98 - 1,04 g /cm <sup>3</sup>
VICAT SOFTENING TEMPERATURE (50°C/h, B 50N)	ISO 306	98°C
SHORE HARDNESS D	DIN 53505/ISO 868	70 +- 4
SHRINKAGE	OWN METHOD (1h at 80°C)	0,7 %
SCRATCH HARDNESS TEST PENCIL WITH VARNISH	(Wolff-Wilborn method) ISO 15184	HB
CHEMICAL RESISTANCE WITH VARNISH	DIN 68861	1B (Goog)
LIGHT FASTNESS WITH AND WITHOUT VARNISH	ISO 4892	6 -7 blue wool scale 4-5 gray scale
VARNISH ADHERENCE	CROSS-CUT TEST ISO 2409:2013	0 = Excellent
EDGEBANDING ADHERENCE	UNE 56875	meet the standard
STATIC CHARGE		low

## 2 ABS PROCESSING FEATURES

PROCESSING FEATURES	REMARK
Bonding	With any common glue for edgebanding
Clipper cutting	Good
Pre - milling	Good
Radius milling	Good
Fitting	Good
Polished	Good
Lacquer	Good with common products. Needed test before.



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### 3 ABS THICKNESS TOLERANCES

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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

### 4 ABS WIDTH TOLERANCES

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WIDTH	TOLERANCE
16 - 23 mm	+/- 0,35 mm
24 - 45 mm	+/- 0,35 mm

### 5 TECHNICAL FEATURES OF CANTISA ABS EDGEBOARDING

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Cantisa ABS edgebands are manufactured by the extrusion process and are fully dyed. Uniform colour of the material permits the radius would have the correct colour. The impact-resistant formulation guarantees the properly processing on the furniture production, and many years' usage as furniture.

Also provides long service lives for cutting tools in the edgebander.

Cantisa ABS edgebands are coated on the back with a primer which permits perfect bonding of the edge with all common hot-melt adhesives.

ABS (acrylonitrile-butadiene-styrene) is one of the most widely known and used synthetics. Edgebanding for the furniture industry have also been used of this material for more than 25 years, with good results.

It has been the very good application processing properties of ABS in particular which have contributed to its market penetration in furniture production.

The variety of applications for Cantisa ABS edgebands is very large for furniture: for the office, bathroom and kitchen, etc.



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## 6 ABS PROCESSING RECOMMENDATIONS

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Cantisa ABS edgebands can be used on any edgebander machines with EVA and PUR glues. The guideline values specified by the manufacturers for the respective applications must be observed.

Adhesives highly resistant to heat, and the low-shrinkage formulation of the Cantisa ABS, guarantee solid bonding. Measuring the temperature at the applicator roller is recommended. You must follow the specifications from glue manufacturers.

Boards and edgebands, to be able to be processed, should be at temperature above 18°C .

The relative humidity in production doesn't be above 70%.

The optimum wood moisture of the board material for processing is between 7 and 10%  
ication areas of Cantisa PVC edgeban.

Rates from 10 to 100 m/min are possible depending on the edgebander. We recommend to use 3 to 6-blade milling cutters with speeds of 12,000 to 18,000 rpm. Cantisa ABS edgebands can be worked very well with the polishing wheel and the colour of the radius must be like the edge surface.

## 7 CLEANING

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The use of special synthetic cleaners is recommended for Cantisa PVC edgebands. Substances with a high solvent content, and alcoholic substances, should not be used. Resist the attack of most acids, alkalis and inorganic salts. It is not attacked by oils, alcohols, aliphatic hydrocarbons and fatty acids. It is attacked (totally or partially) by chlorinated solvents, ketones, aromatic hydrocarbons and some aldehydes.

## 8 WASTE REMOVAL

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Waste from ABS Cantisa edgebanding can be incinerated at the same time with wood waste in systems approved for this matter. The process does not produce chlorine compounds. Even, the boards already edged with ABS can be incinerated without the needed to separate the edgebanding and the chipboard.

## 9 STORAGE CONDITIONS

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Stored under proper conditions, on a dry and cool place (< 30°C) and protected from direct sunlight and dust, Cantisa ABS edgebandings are applicable for a minimum period of one year.





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