

DÖLLKEN ABS Edgebands Processing Information

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1. What is ABS?

ABS (acrylonitrile butadiene styrene) is an impact resistant, mechanically and thermally resilient, high quality thermoplastic which is ecologically sound. For over 20 years now, this chlorine-free plastic has been successfully used in the furniture industry. It is the outstanding application, processing and disposal characteristics, in particular, of ABS that contribute to its extensive impact on the furniture manufacturing market.

2. Applications for Döllken ABS edgebands

There is an almost unlimited range of applications for Döllken ABS edgebands - from the office to bathrooms and kitchens, exhibition stand and shop fitting, general living areas and general interior design. The material formulation of Döllken ABS, which is particularly suitable for machining and processing, means that it can be used in straight processing, as well as on any curved furniture items, on both internal and external radii.

Given their excellent disposal characteristics, ABS edgebands are often required by specification regulations in calls for tender in both the public and private sectors.

3. Döllken ABS edgebands

Döllken ABS edgebands are extrusion-manufactured and through coloured. Consistent through colouring of the material means that clean radiusing of the edgeband does not pose any problems. The impact resistance of the Döllken ABS material means that the life of milling and other types of cutting tools is not unnecessarily shortened. On the rear of the Döllken ABS edgebands is a universal bonding agent giving perfect adhesion when used with any suitable hot melt or solvent-based adhesive.

4. Working with the edgebands

a) Machining

ABS edgebands can be processed on all edgeband gluing machines (straight-processing and CNC machining centres) using hot melt adhesive techniques. Gluing, cross-cutting, milling, scraping and post-process buffing with polishing wheels or processing with hot air dryers to give a high quality surface finish can all be done without any problems. To ensure a clean and permanently robust application of the edgeband, some major processing parameters must be adhered to, these being partly dependent on the materials used (edgebands, glue, boards/panels), the edgeband gluing machine and the ambient temperature. For example the edgeband needs a special temperature to be worked on machines otherwise the melt would cool down too quickly. It is therefore recommended that trials be undertaken to determine the relevant optimum settings in each case. The guidelines issued by the manufacturers for the intended application in question should also be followed.

Adhesives

Döllken ABS edgebands can be processed using any

standard hot melt adhesives (EVA, PA, APAO, PUR). Adhesives resistant to high temperatures, in tandem with the low-shrink materials formula of Döllken ABS give good adhesion, even on edgebands of thickness in excess of 3 mm. Adhesives that are particularly heat resistant are recommended for applications involving high temperatures, in the vicinity of cooking appliances in kitchens or for exporting furniture in containers, for instance. Even before gluing, Döllken ABS edgebands have very low shrinkage characteristics. Another good feature of ABS edgebands in this regard is their resistance to warping (dimensional stability). Softening of the material only occurs above 94 (± 2) °C (Vicat B 50).

When gluing, checks always need to be carried out that there is sufficient glue in the container to ensure constant temperature as it is being applied.

The working temperature of the adhesive varies between 90 and 220 °C depending on type.

It should be borne in mind that the thermostats in the hot melt container are often inaccurate and may vary considerably from the actual temperature on the application roller. It is recommended that the temperature be taken on the adhesive application roller. Döllken ABS edgebands cannot be glued using ordinary white glues.

Working temperature

For best results when applying edgebands, boards or panels and the edgebands should be processed at room temperature (not below 18 °C). If the materials have been stored outdoors, they should be warmed up over night. If the boards or edgebands are too cold, the hot melt adhesive will set before the edgeband is applied to the board. For this reason draughts should also be avoided.

Wood moisture

For processing, optimum wood moisture in the boards is between 7 and 10 %.

Feed rate

The particular material formulation of Döllken ABS edgebandings are designed for feed rates both in low volume processing and in major manufacturing situations. Speeds of 10 to 100 m/min are possible using edgeband gluing machines. On modern portal-type machining centres, speeds of 30 m/min are feasible depending on the geometry.

Rates of glue application

Please follow the adhesive manufacturer's instructions. The adhesive should be applied evenly and in sufficiently small quantities so that no beads of adhesive get pressed out from the edges of the freshly glued edgebands, and that any gaps in the wood of the boards or panels are filled. The amount of glue required depends on the density of the chipboard and the type of adhesive.

Press rollers

Bearing in mind the specifics of the machine, check that these are of the correct number and check the pressure setting, so that optimum seam appearance can be obtained. Extraction

Thermoplastic edgebands require higher extraction power than duroplastic edgebands. One advantage of the Döllken ABS edgebands is their lower static charge compared to other thermoplastic materials.

Milling

If possible, you should use 3- to 6-edge cutters with a diameter of approximately 70 mm, at speeds of between 12,000 and 18,000 rpm. Incorrect speeds or blunt tools can damage the edgebands. If any smears should occur, the speed of the cutter should be reduced or the edgebands should be conventionally milled (if necessary increase the rate of feed).

Scraping

Because ABS as a material tends to fade in colour after scraping, the scraper blade should be a maximum of 0.1 to 0.2 mm. The milling needed for this, which should be as free as possible of chatter marks, must be carried out using cutters with high true running characteristics. The use of diamond-edged cutters is of help here.

To optimise scraping, particularly where colour quality is critical, hot-air units can be used.

Buffing

Döllken ABS edgebands are easily buffed in a radius with a polishing wheel. Any colour fading resulting from scraping can easily be buffed away using polishing wheels, and the colour on the radius will match that of the edgeband surface. On through-feed edgeband gluing machines, the glue remnants can also be removed with a polishing wheel. In addition, glue remnants can also be removed using electronically controlled separating agent spray units, which are in standard industrial use. This also gives better scraper blade finish.

b) Manual processing

Manual processing of Döllken ABS edgebands is also unproblematic, by using a gluing press or edgeband press for instance. Recommended adhesives here are acrylic-based two-component dispersion glues or suitable contact adhesives. Please contact your adhesive manufacturer direct. Ordinary single component white wood glues cannot be used. When gluing by hand, special lacquer adhesives, solvent-based adhesives and cartridge glues (PU) can be used. On request, we will be glad to supply you with a list of suitable types.

Gluing should be carried out at room temperature. When using contact adhesives, care needs to be taken to ensure that the curing time after applying adhesive to the board and edgeband is adhered to, so as to give optimum edgeband bonding. Once this has happened, the edgeband is tapped on. When using dispersion glues there should not be any heat applied to accelerate bonding (e.g. heat tracks).

After the bond has set (up to 6 hours depending on the adhesive) further processing can be undertaken (See item 4a for this).

5. Seam appearance

Because the Döllken ABS edgebands are supplied with factory-set pretensioning and plane-parallelity, the seam

will always be tight and as good as invisible to the eye. Pretensioning also ensures optimum bonding in that any excess adhesive is taken up at the midpoint of the back of the edgeband and the anchor points of the adhesive to the chipboard.

6. Mechanical characteristics

Resistance to abrasion

The surface of printed SURTECO ABS edgebands is sealed with UV-hardened acrylic varnish to give a scratch-resistant finish. The printed patterns also have excellent resistance to scratching and abrasion. They are classified under Stress Group 2E, DIN 68861, Part 2.

Indentation hardness/Shore hardness D

Based on DIN 53456 and DIN 53505, SURTECO ABS edgebands also feature excellent surface hardness.

Resistance to warping under heat

With a value of $94 (\pm 2) ^\circ\text{C}$ (as per Vicat B 50), SURTECO ABS edgebands are superbly suited to applications in the furniture industry and interior design.

Varnishing

Döllken ABS edgebands in unicolours can easily be varnished in the colour of your choice without any need for pretreating. Use PUR varnish or acrylate-based varnish. Avoid nitro-cellulose varnish. You can get more detailed information on the most suitable type of varnish from your own varnish manufacturer.

7. Chemical characteristics

Döllken ABS edgebands are DIN 68861 Part 1 resistant to all standard domestic cleaning agents and substances (e.g. food acids). In addition Döllken ABS edgebands have been tested by the LGA in Nuremberg and are classified under Stress Group 1 B.

Döllken ABS edgebands are also combustible just as any other wood materials. Thermal decomposition does not start until around $300 ^\circ\text{C}$.

8. Lightfastness

Döllken ABS edgebands are subjected to continual testing for lightfastness in the Döllken Technical Department using a special process. With lightfastness of wool colour scale 6-7, Döllken ABS edgebands are very suitable for use indoors (DIN 53388).

9. Cleaning

Döllken ABS edgebands should be cleaned with special plastics cleaners. Highly solvent-based or alcoholic substances should not be used.

10. Storage

Döllken ABS edgebands do not rot and can therefore be stored for almost unlimited periods at room temperature in an area protected from the weather. Insulation and sealing strips can be stored for approximately six months.

11. Disposal

Döllken ABS edgeband remnants can be incinerated

with other wood shavings in authorised plants. No chlorine compounds are produced. Strict TA-Luft limits (Technical Guidelines on Air Quality) must be met. Waste chipboard on which Döllken ABS edgeband processing has been started can also be disposed of by your chipboard manufacturer. There is no need for time-consuming sorting or separation of the edgebands and boards.

12. Quality/tolerances

The consistently high quality of Döllken ABS edgebands is due to comprehensive quality assurance procedures, such as ongoing improvements to raw materials characteristics by our own Technical Department. Manufacturing tolerances for edgebands are narrowly defined and are regularly checked during each manufacturing run:

a. Width tolerances:

Width	ABS
0 – 30 mm	± 0,5 mm
> 30 mm	± 0,5 mm

b. Thickness tolerances:

Thickness	ABS
0 – 1,0 mm	+ 0,10 mm - 0,15 mm
1,1 – 2,0 mm	+ 0,10 mm - 0,20 mm
2,1 – 4,0 mm	+ 0,15 mm - 0,25 mm
> 4,0 mm	+ 0,20 mm - 0,30 mm

c. Pretensioning tolerances:

Thickness	Width up to 30 mm
0 – 1,0 mm	0,00 – 0,50 mm
1,1 – 2,0 mm	0,00 – 0,30 mm
2,1 – 4,0 mm	0,10 – 0,20 mm
4,1 – 6,0 mm	0,00 – 0,20 mm
> 6,0 mm	0,00 – 0,10 mm

Thickness	Width from 30 mm
0 – 1,0 mm	0,00 – 0,70 mm
1,1 – 2,0 mm	0,00 – 0,35 mm
2,1 – 4,0 mm	0,10 – 0,30 mm
4,1 – 6,0 mm	0,00 – 0,25 mm
> 6,0 mm	0,00 – 0,15 mm

d. Plane-parallelity:

Thickness	Maximum deviation
0 – 1,0 mm	max. 0,10 mm
1,1 – 2,0 mm	max. 0,10 mm
2,1 – 4,0 mm	max. 0,15 mm
> 4,0 mm	max. 0,20 mm

e. Longitudinal warpage:

3.00 mm distortion maximum per 1 m length.

The information as supplied, and our advice with regard to applications, both verbal, written and as a result of thralling, are given according to the best of our knowledge, but they are not binding, especially with regard to eventual property rights of third parties. The advice we give here does not remove the need for you to check our current items of advice, particularly with regard to our safety data sheets and technical information, nor obviate the need to check our products with regard to their suitability for the procedures and purposes envisaged. Application, use and processing of our products and of the products manufactured by you based on our technical advice regarding applications are outside the scope of our own control, and responsibility for these is therefore solely in your hands. Sale of our products is subject to our current General Terms and Conditions of supply and payment (please see next page also).

13. Summary of technical data

Characteristics	Test standard	Döllken ABS edgebands
Useful characteristics		
Lightfastness for indoor applications	DIN 53 384C DIN 53 388	6-7 on wool colour scale Ideal for indoor applications.
Indentation hardness	DIN 53 456	100 -120 (N/mm ²)
Shore hardness D (Sensitivity to mechanical forces)	DIN 53 505/ ISO 868	74 (± 4) Good scratch resistance and surface hardness. Physical damage can be easily rectified by buffing.
Linear thermal expansion coefficient	DIN 52 328	100 (1/K × 10-6) Dimensional stability of the glued edgeband is good (if the appropriate adhesive systems are used).
Resistance to warpage under heat - Vicat B 50	DIN 53 460/ ISO 306	94 (± 2) °C
Shrinkage (in%)	SURTECO Factory Standard	< 0.3 % Ideally suited to applications in the furniture industry. In critical temperature ranges, the use of a highly heat resistant adhesive is critical for the dimensional stability and temperature resistance of the finished furniture item.
Resistance to chemicals	DIN 68 861	Good – classification 1B Resistant to all standard domestic cleaning agents. Limited resistance to solvents. Tested by LGA Nuremberg.
Surface quality		Super matt to high sheen
Static charge		Very low
Processing characteristics ¹		
<ul style="list-style-type: none"> • Cross cutting • Milling direction² • Roughing • Radius milling • Profiling • Scraping • Buffing • Gluing radii • Bonding with hot melt adhesives 		Good GLL/GGL ² Good Good Good Good Good Good All standard edgeband thermoplastic adhesives (EVA, PA, APAO, PUR) can be used, depending on heat resistance of the adhesive. Good ¹ Low Good (acrylic/PUR varnish) Good
Disposal characteristics		Edgeband remnants can be incinerated with shavings in suitable plant. TA-Luft limits (Technical Guidelines on AirQuality) must be observed.
Physiological characteristics		No source of harm to general health

¹Optimisation of machines may be required.

²Conventional milling is recommended on all thermoplastics materials:
GLL = Climb milling, GGL = Conventional milling

14. Trouble-shooting: Tips and information for problems encountered in processing

Problem	Problem diagnosis and suggested solutions
1 Edgeband can be easily pulled away by hand. Hot melt adhesive remains on the chipboard. The grid pattern of the gluing roller is visible.	<ul style="list-style-type: none"> • Not enough glue applied • Room temperature too low • Edgeband material too cold (stored outdoors) • Hot melt adhesive temperature too low • Feed rate too low • Pressure exerted by the press rollers too low
2 Edgeband can be easily pulled away by hand. Hot melt adhesive remains on the chipboard. Hot melt adhesive surface smooth all over (edgeband slips off).	<ul style="list-style-type: none"> • Board and/or edgeband too cold ⇒ Check hot melt adhesive type ⇒ Check application of bonding agent
3a. Edgeband can be pulled away by hand. Hot melt adhesive remains on the edgeband for the most part.	<ul style="list-style-type: none"> • Temperature of the board material too high as a result of previous processing steps (e.g. veneering)
3b. Glue seam is not closed (edgebanding machine).	<ul style="list-style-type: none"> • Pressure exerted too low • Adhesive too cold ⇒ Increase application temperature or preheat board or increase feed rate • Edgebands either have no pretensioning or pretensioning is askew
3c. Glue seam is not closed (machining centre).	<ul style="list-style-type: none"> • Pressure exerted is too low • Edgeband was fed in too cold and can't be squeezed • Restoring forces of edgeband material too high ⇒ Increase heater power or reduce feed rate ⇒ Increase geometry or use a thinner edgebanding • Material not suitable for use on machining centres – adhesion under heat too low • Adhesive does not set quickly enough ⇒ Reduce adhesive application temperature
3d. Edgebands are only bonded at the edges.	<ul style="list-style-type: none"> • Pressure exerted is too low • Milled seam at the joint with the board has gaps • Pretensioning of edgebands too high
4 Inadequate bonding of the glued edgeband at the front edge of the board, or the edgeband is split at the front edge.	<ul style="list-style-type: none"> • Not enough adhesive applied due to gluing roller being incorrectly laid out ⇒ Increase adhesive application quantity
5 Milling marks are visible.	<ul style="list-style-type: none"> • Feed rate too high • Cutting speed of the cutters too low ⇒ Post-process with scrapers and buffing ⇒ Use conventional milling ⇒ Increase number of cutters on router ⇒ Increase r.p.m.
6 On thick edgebands the colour fades slightly in the milled areas (stress whitening).	<ul style="list-style-type: none"> • Warm up the milled area on the hot-air station (can be reworked) • Scraper blade is too thick ⇒ Post-process on buffing station ⇒ Reduce scraper blade (max. 0.1 – 0.2 mm)
7 Evidence of stress whitening in the radius during machine centre processing.	<ul style="list-style-type: none"> • Edgeband fed in too cold ⇒ Increase heater power or reduce feed rate ⇒ Increase geometry or use a thinner edgebanding

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