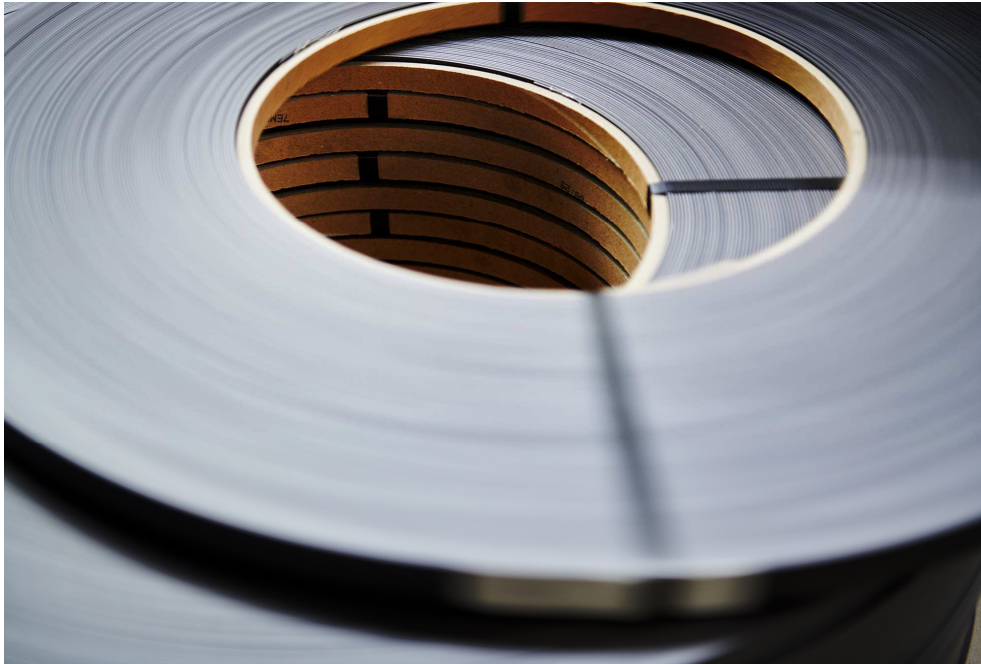




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Any production work may be carried out by qualified personnel only.	
Read all instructions first before commencing any work.	
Do not drink any alcohol or take any drugs before or during work with the products and follow the safety instructions carefully.	

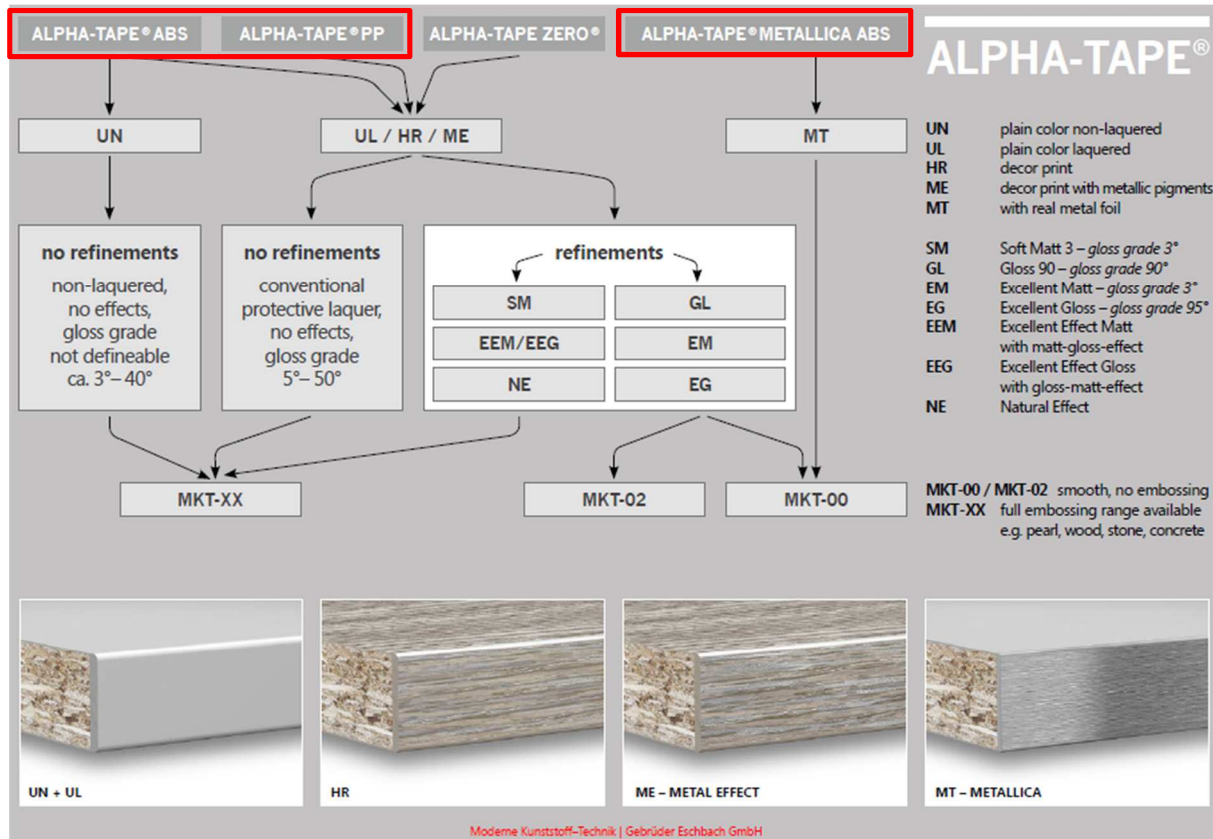
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ALPHA-TAPE® ABS/PP

1. Scope of Delivery

The information below provides a general product overview. – More detailed information and possible deviation can be found in the order form.



Alpha-Tape® ABS and Alpha-Tape® PP:

Profile type	Width		Thickness
KB Edge banding	12.0 – 60.0 mm	½" – 2 ½"	0.60 – 3.20 mm
	60.0 – 105.0 mm	2 ½" – 4 ¼"	0.60 – 2.00 mm
SR Jumbo Roll (for slitting)	up to 405.0 mm	up to 15 ¾"	0.60 – 3.20 mm

Alpha-Tape® metallica ABS

Profile type:	Width		Thickness
KB Edge banding	12.0 – 110.0 mm	½" – 4 1/3"	0.50 – 2.0 mm ¹

¹ incl. real metal foil

Our Alpha-Tape® excellent gloss and high gloss edge bandings are generally protected by a PE-protection foil.

Protective foil transparent

Protective foil black/white, plain

Protective foil black/white



Alpha-Tape® excellent matt, excellent effect, soft matt 3 and gloss 90 are delivered unprotected. However, protective PE foil can be ordered separately as an option.

Tools (e.g. cutting knife, milling cutters, buffing discs) required for processing the Alpha-Tape® edge bands are not included in any order. For the tools that will be needed, please contact the machine manufacturer of the edge-banding machine.

2. Transportation

Edge bands are transported on rolls, which in turn are placed on pallets, as shown below. The optional timber support beams inside are recommended to prevent shifting of the rolls during transport.



It is recommended to use the following one-way-pallets:

Maximum pallet height: 55.118 inches (1400 mm)

Material height: 47.24 inches (1200 mm)

2 roll piles for edging in thickness ≤ .079 inches (2.00 mm)

1 roll pile for edging in thickness > .079 inches (2.00 mm)

Cardboard cover for each roll pile, fixed with wooden bars and straps and wrapped in PE stretch film.



Danger of suffocation due to the packaging film, keep away from children!



A sample for each item should be attached to the pallet – see standard specifications in Appendix (Chapter 11, pp. 36) for type of labelling.

To deliver cargo to the customer the rolls ordered should be unpacked from the pallet.
Repack the rolls as needed:

1 roll will be delivered in a small box and 5 rolls in a larger box.

More than 5 rolls will be delivered on a pallet.

Pack the rolls on a provided pallet as a pile, get them fixed and wrapped in PE stretch film as previously described.

Use a forklift or a manual lift truck to move pallets and rolls!

Caution! A forklift truck should only be operated by authorized persons!



Wear protective clothes!



Do not transport the cargo in an open delivery truck. Protect it from direct sunlight, rain and dust.

The storage temperature of the edge bands should not exceed 86°F or go below 32°F. Keep edge bands at room temperature 24h before processing.

3. Handling

Pay attention to the machine and wear protective clothes!	 CAUTION Wear protective equipment.
---	--

During processing the edge-band material and the surface coatings on the processed material are shattered and pulverized and the dust formed may contain particles of respirable size. Apply edge bands in a well-ventilated area only. If handling results in dust generation, special ventilation may be needed to minimize dust exposure.

In case of dust generation wear dust mask!	 WARNING Wear dust mask and operate dust collector when using this equipment.
--	--

Avoid all possible sources of ignition (spark or flame).

Dust combined with air can form an explosive mixture!	 DANGER COMBUSTIBLE
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Edge bands can accumulate static charges during processing, which can cause an incendiary electrical discharge. Affected parts of the machines should be grounded.

The material is able to heating-up during processing activities due to friction or incorrect settings of the energy source.

Processing machines should be equipped with separate extractors including filters. For more information contact the machine manufacturer.

If the material is extremely overheated, gaseous decomposition products can be released!	
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Appropriate emergency showers and eye showers should be provided. A fire extinguisher should be on site during operation.

Cut-resistant and heat-resistant protective clothes should be worn.	 CAUTION Wear protective equipment.
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4. Storage

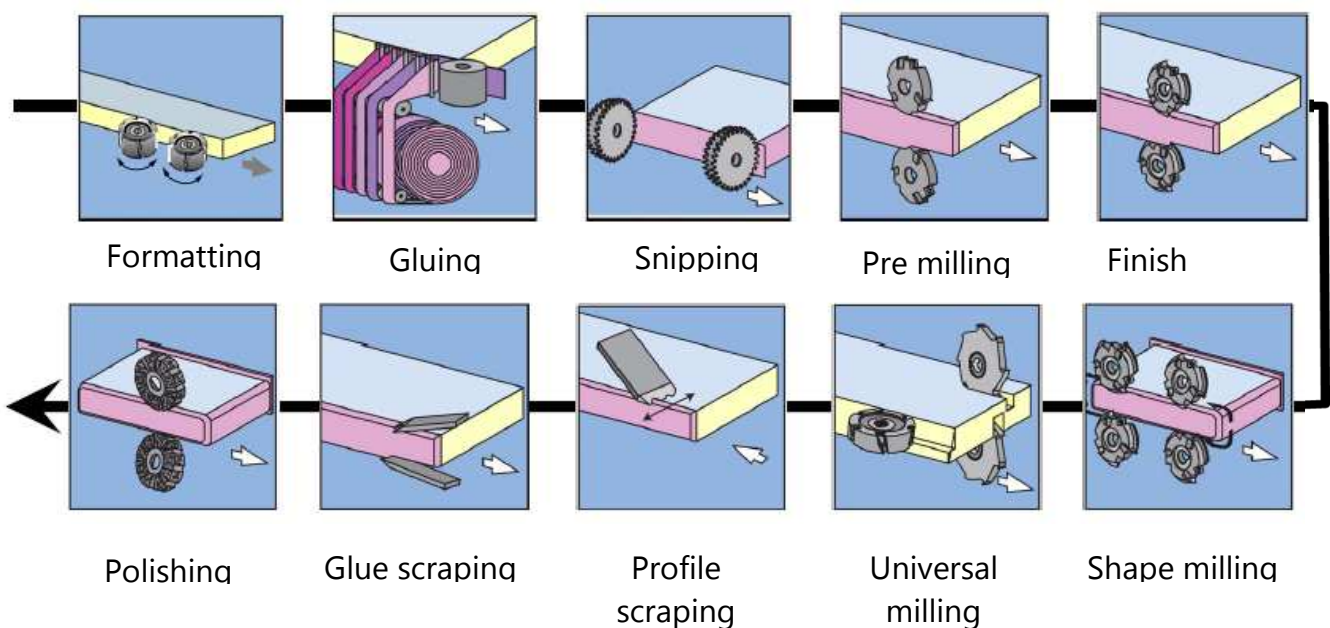
Store the edge bands in a dry and cool place (<86°F), protected from direct sunlight and dust. Alpha-Tape® edge bandings need to be utilized within a year after production. The date of production is noted on the product label.

Avoid extreme heat and ignition sources (sparks, open flames) to prevent damage or ignition of the material. Permanently high temperatures can damage the coating of the edge band material and may cause damages (e.g. loss of adhesion, visible changes of color).

5. Operations

Processing of Alpha-Tape® Edge Banding:

- MKT edge banding can be processed on standard edge banding machines with hot-melt technology (for straight and radii processing on edge banding machines, through-feed or CNC lines for inner and outer radii).
- Gluing, cutting, trimming, scraper processing and polishing with buffing discs for high-quality surfaces can be applied. Alternatively, we recommend specifying the optimum setting parameters and sequences by testing.
- Process steps Edging:



- Observe feeding transportation of the edge band in order to avoid damaging of the edge band's surface. Rubberized rollers are best suitable for this purpose.
- The following plant conditions should be taken in consideration:
 1. The type of material (edge banding, glue, board)
 2. The type of processing equipment (edge banding machine, BAZ)
 3. Environmental conditions (temperature, humidity)

Remove the protective foil after processing!



Adhesives

MKT ABS and PP edge bands are coated underneath with a universal bonding agent (primer), which permits bonding to the majority of standard hot-melts available on the market. The primer layer is aligned for application with EVA, DO, APAO and PUR hot melt glues. Processing with special dispersion adhesives is also feasible, contact an application technician for further information.

For applications with high temperature requirements, for example with kitchen furniture or for furniture exports in containers, a particularly highly heat-resistant adhesive should be used. When applied material softening starts above approximately 212°F.

Glue application should be evenly applied and in adequate quantity to fill any gaps between chips and edge. During gluing, a sufficient quantity of adhesive should be available from the pre-melt tank in order to guarantee even application as well as constant temperature.

Depending on the type of hot-melt used, the applied quantity should be between 140 and 220 g/m². The required glue quantity depends on the density of the chipboards as well as the type of hot-melt.

The processing temperature of the hot hot-melt varies between 194° and 428°F, depending on the type. Observe required processing temperature in accordance with manufacturer's specification. The thermostats at the pre-melt container may be inaccurate. Measure directly at the transfer roller.

Processing Temperature

Boards and edge bands should be processed at temperatures not below 64.4°F.

Wood Moisture

The moisture percentage of the wooden based panels for further processing should be between 7% and 10%.

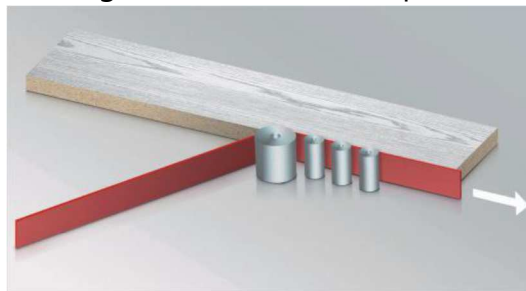
Feed Rate

MKT Alpha-Tape® ABS and PP edge bands can be applied at speeds from 32 feet per min. (10 m/min.) up to 393 feet per min. (120 m/min.), depending on the individual edge banding machine used.

MKT Alpha-Tape® Metallica can be applied at speeds from 32 feet per min. (10 m/min.) to 98 feet per min. (30 m/min.).

Press Rollers

Considering the specifications of the machine a sufficient number of press rollers is required, as well as a correct pressure setting to achieve the best possible seam.

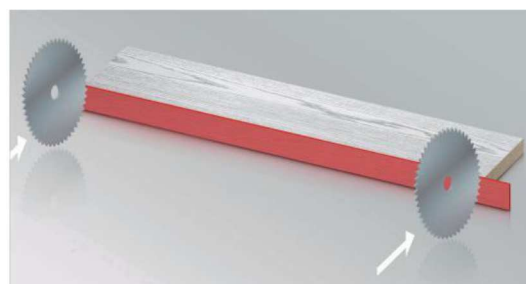


Cutting Knife

The cutting knife should have a sharp blade to separate the edge banding material without splintering, leaving a minimum of excess material for crosscut milling to make copy milling easier afterwards.

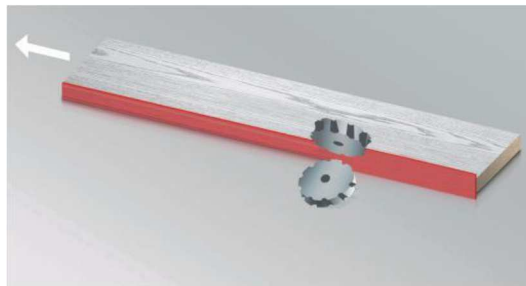
Cutting

The cut-off saw should run into the edging material at an adapted feed rate without any splintering. Usage of serrated cut-saw blades is recommended.



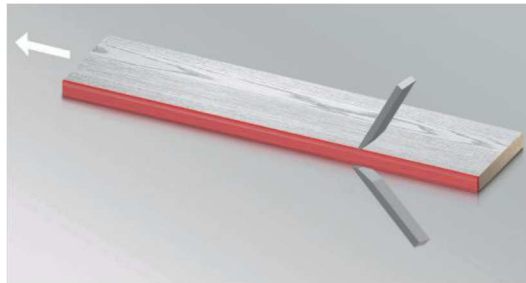
Milling

Plastic edge bands should always be milled in reverse rotation. The excess length of the edge should be even on both sides, approximately .059 inches [1.5 mm]; however, not more than the thickness of the edge band. It is recommended to apply four to six edged milling cutters with a diameter of 2 ¾" [70 mm] and operate with a milling speed of 12,000 to 18,000 r.p.m. Inappropriate speed or blunt tools may cause damage to the edge bands. If any smearing or melting occurs, the speed should be reduced, or the feeding be increased. Alternatively, milling cutters with a larger axial angle should be used. High rotation accuracy of the milling cutter will avoid chatter marks.



Scraping

For a high-quality result, the scraper chip should be at maximum .004 - .008 inches [0.1 – 0.2 mm] thick.



Buffing

MKT ABS and PP edge bands can be finished with buffing discs. In through-feed mode, any glue residue can be removed with buffing discs. For removal of glue residue electronically controlled release agent spray units can also be used, which simultaneously improve the scraping of the chip.



Lacquering

If MKT PP edge bands are supplied with special lacquers or painted after application of a special primer, the usage of a corona plasma flame is recommended to improve the result. The board material should be exactly masked off when applying the primer to avoid blemishes in the surface finish. The primer should also completely cover the milled radius.

Protective Foil

For high gloss, excellent gloss and metallica surfaces protective foils should be used, both during transportation as well as during processing.

6. Cleaning

For cleaning Alpha-Tape® ABS and Alpha-Tape® PP edge bandings MKT recommends special plastic cleansing agents. Test first reliability on a small sample. Never use alcohol-based or solvent-based cleaners.

7. Disposal

Dispose all materials in accordance with local regulations.



8. Trouble Shooting

Problem	Potential Causes	Recommended Action
The edge band can be pulled off by hand. Hot-melt glue remains on the chipboard. The grid structure of the glue application roller is visible.	- Room temperature too low or draughts in the area of the hot-melt application and pressure roller. - Edge band material too cold (because of external storage). - Hot-melt temperature too low. - Feed rate too slow. - Contact pressure of the application rollers too low. - Glue application quantity not sufficient.	

The edge band can be easily pulled off by hand. Hot-melt glue remains on the chipboard. The hot-melt surface is completely smooth (edge band slides away).	• Board or/and edge band too cold. • Type of hot-melt is not suitable.	• Check edge band or application of primer respectively.
The edge band can be pulled off by hand. Hot-melt glue remains mostly on the edge.	• Board material stores too much energy (e.g. after previous veneering or laminating the board surfaces).	• Type of hot-melt glue possibly not suitable.
The glued edge band is not bonding to the front edge of the panel or the edge band is for a few millimeters chipped.	• Glue application is not in alignment with the board. Because the roller is strongly springing back at the front edge of the board, no glue is applied to the board edge at its beginning.	• Increase glue application quantity.
Milling shafts are visible at the radii.	• Feed rate too slow. • Cutting speed too low.	• Milling in reverse rotation. • Increase the number of cutting edge of the cutter. • Increase speed of the milling cutter. • Use scraper blades and buffing discs for re-working.
Color shade brightening in milling zones of thick edge bands	• Cutting speed too low.	• Optimizing of the scraper blade unit (maximum 0.004 - 0.008 in.). • Re-working with buffing unit. • Warm up milling area using hot air heating (retrofit possible).
Stress whitening during BAZ processing in radius.	• Edge band too cold when applied.	• Increase radiator output or reduce feed rate. • Increase geometry or apply thinner edge banding material.

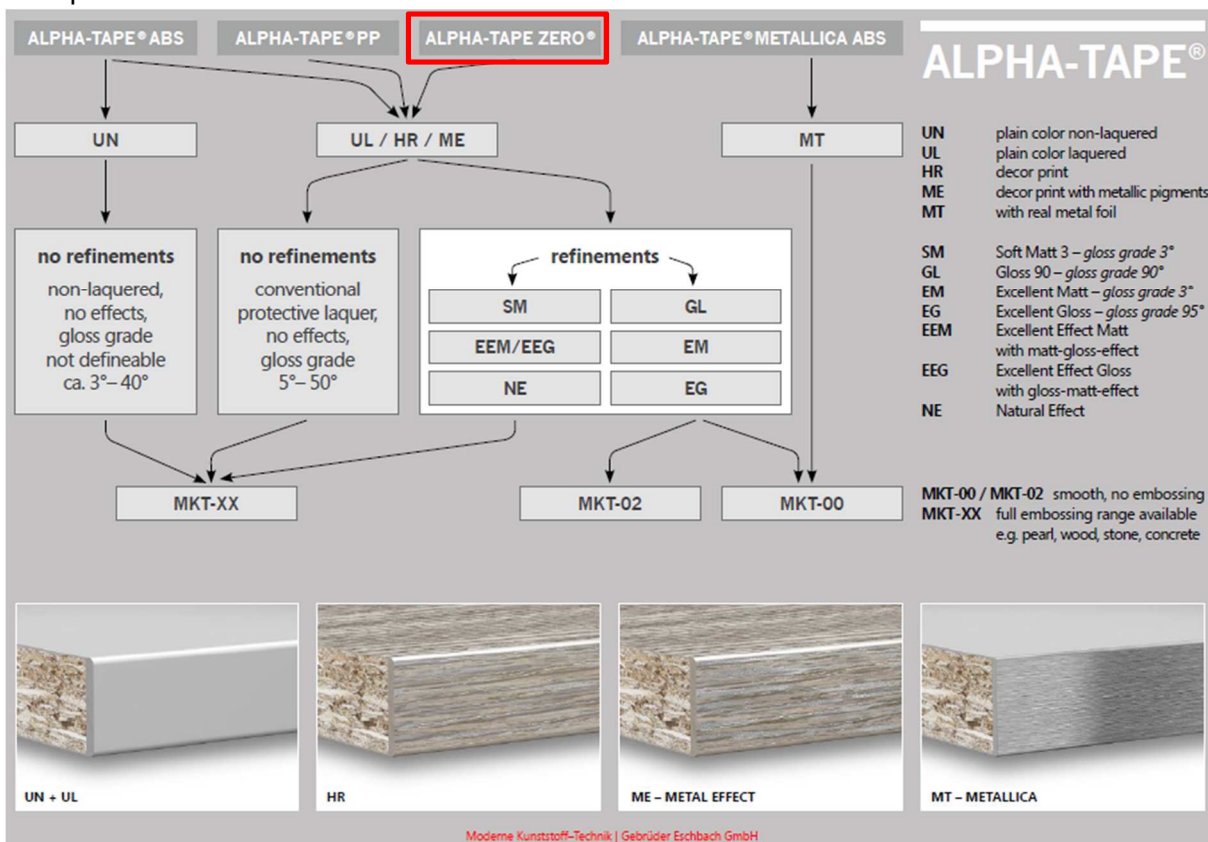
9. Representation & Warranties / Disclaimer

CUSTOMER ACKNOWLEDGES THAT THE PRODUCTS ARE PROVIDED "AS IS". MKT SPECIFICALLY DISCLAIMS, WITHOUT LIMITATION, ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, OF ANY KIND, INCLUDING, WITHOUT LIMITATION, THE IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, NON-INFRINGEMENT, AND THOSE WARRANTIES ARISING FROM A COURSE OF PERFORMANCE, A COURSE OF DEALING OR TRADE USAGE.

ALPHA-TAPE ZERO® PP

1. Scope of Delivery

The information below provides a general product overview. – More detailed information and possible deviation can be found in the order form



Alpha-Tape Zero® PP:

Profile type	Width		Thickness
KB Edge banding	12.0 – 60.0 mm	½" – 2 ½"	0.40 – 3.20 mm
	60.0 – 105.0 mm	2 ½" – 4 ¼"	0.40 – 2.00 mm
SR Jumbo Roll (for slitting)	up to 405.0 mm	up to 15 ¾"	0.40 – 3.20 mm

Our Alpha-Tape® excellent gloss and high gloss edge bandings are generally protected by a PE-protection foil.

Protective foil transparent

Protective foil black/white, plain

Protective foil black/white



Alpha-Tape® excellent matt, excellent effect, soft matt 3 and gloss 90 are delivered unprotected. However, protective PE foil can be ordered separately as an option.

Tools (e.g. cutting knife, milling cutters, buffing discs) required for processing the Alpha-Tape® edge bands are not included in any order. For the tools that will be needed, please contact the machine manufacturer of the edge-banding machine.

2. Transportation

Edge bands are transported on rolls, which in turn are placed on pallets, as shown below. The optional timber support beams inside are recommended to prevent shifting of the rolls during transport.



It is recommended to use the following one-way-pallets:

Maximum pallet height: 55.118 inches (1400 mm)

Material height: 47.24 inches (1200 mm)

2 roll piles for edging in thickness ≤ .079 inches (2.00 mm)

1 roll pile for edging in thickness > .079 inches (2.00 mm)

Cardboard cover for each roll pile, fixed with wooden bars and straps and wrapped in PE stretch film.



Danger of suffocation due to the packaging film, keep away from children!



A sample for each item should be attached to the pallet – see standard specifications in Appendix (Chapter 11, pp. 36) for type of labelling.

To deliver cargo to the customer the rolls ordered should be unpacked from the pallet.
Repack the rolls as needed:

1 roll will be delivered in a small box and 5 rolls in a larger box.

More than 5 rolls will be delivered on a pallet.

Pack the rolls on a provided pallet as a pile, get them fixed and wrapped in PE stretch film as previously described.

Use a forklift or a manual lift truck to move pallets and rolls!

Caution! A forklift truck should only be operated by authorized persons!



Wear protective clothes!



Do not transport the cargo in an open delivery truck. Protect it from direct sunlight, rain and dust.

The storage temperature of the edge bands should not exceed 86°F or go below 32°F. Keep edge bands at room temperature 24h before processing.

3. Handling

Pay attention to the machine and wear protective clothes!	 CAUTION Wear protective equipment.
---	---

During processing the edge-band material and the surface coatings on the processed material are shattered and pulverized and the dust formed may contain particles of respirable size. Apply edge bands in a well-ventilated area only. If handling results in dust generation, special ventilation may be needed to minimize dust exposure.

In case of dust generation wear dust mask!	 WARNING Wear dust mask and operate dust collector when using this equipment.
--	---

Avoid all possible sources of ignition (spark or flame).

Dust combined with air can form an explosive mixture!	 DANGER COMBUSTIBLE
---	--

Edge bands can accumulate static charges during processing, which can cause an incendiary electrical discharge. Affected parts of the machines should be grounded. The material is able to heating-up during processing activities due to friction or incorrect settings of the energy source.

Processing machines should be equipped with separate extractors including filters. For more information contact the machine manufacturer.

If the material is extremely overheated, gaseous decomposition products can be released!	
--	--

Appropriate emergency showers and eye showers should be provided. A fire extinguisher should be on site during operation.

Cut-resistant and heat-resistant protective clothes should be worn.	 CAUTION Wear protective equipment.
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4. Storage

Store the edge bands in a dry and cool place (<86°F), protected from direct sunlight and dust. Alpha-Tape® edge bandings need to be utilized within a year after production. The date of production is noted on the product label.

Avoid extreme heat and ignition sources (sparks, open flames) to prevent damage or ignition of the material. Permanently high temperatures can damage the coating of the edge band material and may cause damages (e.g. loss of adhesion, visible changes of color).

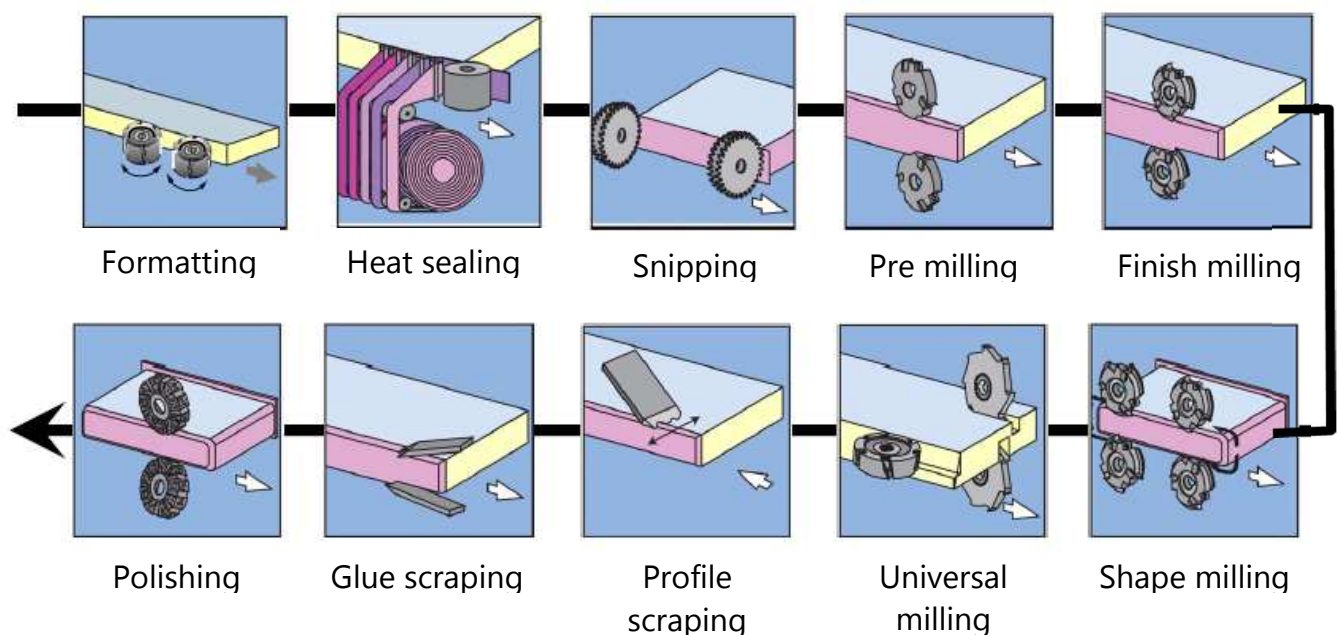
5. Operations

MKT Alpha-Tape Zero® edge banding can be processed on all standard edge banding machines with zero-joint-technology, including the diode laser, hot-air and NIR processes (for straight and radii processing on edge banding machines, through feed or CNC lines for inner and outer radii).

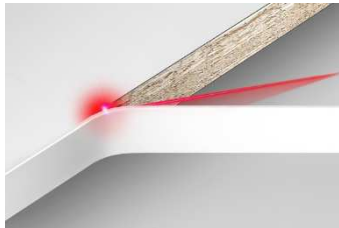
MKT Alpha-Tape Zero® edge bands possess a special coextruded functional layer. During processing the functional layer gets molten and cements with the work piece.

Cutting, trimming, scraper processing and polishing with buffing discs for high-quality surfaces can be applied. The optimum setting parameters and sequences can be achieved by testing.

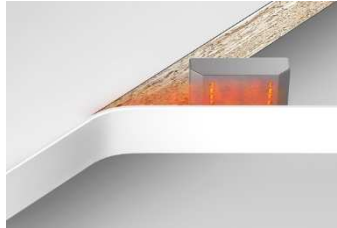
Process Steps Laser Edging:



a. Laser technology: A laser beam activates the functional layer



b. Hot air technology: Hot, compressed air melts the functional layer



c. NIR technology: Thermal energy can be transferred with the near infrared technology



Observe feeding transportation of the edge band in order to avoid damaging of the edge band's surface. Rubberized rollers are best suitable for this purpose.

The following plant conditions should be taken in consideration:

1. The type of material (edge banding, board)
2. The type of processing equipment (edge banding machine, BAZ)
3. Environmental conditions (temperature, humidity)

Remove the protective foil after processing!



a. Processing Parameters for the Laser Process

The specific energy required should be used for processing Alpha-Tape Zero® with diode lasers is in J/cm² and printed on every roll on the inside label.

For example:

Color Index	Specific Energy
Light-colored (e.g. white)	E = 22 J/cm ²
Medium-colored (e.g. fawn)	E = 19 J/cm ²
Dark-colored (e.g. black)	E = 14 J/cm ²

Example of inside label:



b. Processing Parameters for the Hot-Air Process

The following machine settings are recommended for processing with straight-line machines when edging 9/10 inches x 1.2 mm [23 mm x 1.2 mm] and with the specified feed rates.

	BIESSE Air-Force-System Feed rate: 46 feet per min. [14m/min]
Hot-Air Reservoir	1382°F [750°C]
Air Nozzle Temperature	932°F [500°C]
Air Pressure	4-5 bar [58-73 psi]
Air Tube	932°F [500 °C]

	HEBROCK Air-Tronic Feed rate: 27 - 33 feet per min. [8.5 - 10m/min]
Hot Air Reservoir	1112°F [600°C]
Air Nozzle Temperature	662°F [350°C]
Air Volume	370 l/min

	HOMAG Air-Tec Feed rate: 66 feet per min. [20m/min]
Hot-Air Reservoir	1202°F [650°C]
Air Nozzle Temperature	842°F [450°C]
Air Pressure	4-5 bar [58-73 psi]

	SCHUGOMA System GmbH Feed rate: 66 feet per min. [20m/min]
Hot-Air Reservoir	1112°F [600°C]
Air Nozzle Temperature	716°F [380°C]
Air Pressure	6.00 bar [87 psi]

For all other hot-air sources on the market, the setting parameters should be requested from the machine manufacturer.

Please contact our Technical Department for application or processing questions:
info@mkt-gmbh.com

c. Processing Parameters for the Near-Infrared Process

When applying the NIR technology, use the following parameters as a guideline.

HOLZ-HER	Color Index	Feed rate	Power
	Light-colored (e.g. white)	32 feet per min. (10 m/min.)	E = 3.60 K/W
		59 feet per min. (18 m/min.)	E = 5.60 K/W
	Medium-colored (e.g. fawn)	32 feet per min. (10 m/min.)	E = 3.20 K/W
		59 feet per min. (18 m/min.)	E = 5.15 K/W
	Dark-colored (e.g. black)	32 feet per min. (10 m/min.)	E = 2.35 K/W
		59 feet per min. (18 m/min.)	E = 3.75 K/W

(Setting parameters should be requested from the respective machine manufacturer).

Please contact our Technical Department for application or processing questions:
info@mkt-gmbh.com

6. General Parameters for Processing Alpha-Tape Zero® PP

Processing Temperature

Boards and edge bands should be processed at temperatures not below 64.4°F.

Wood Moisture

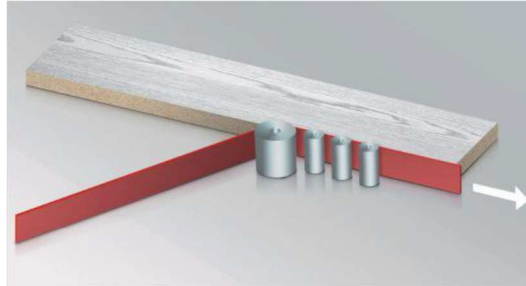
The moisture percentage of the wooden based panels for further processing should be between 7% and 10%.

Feed Rate

MKT Alpha-Tape® ABS and PP edge bands can be applied at speeds from 32 feet per min. (10 m/min.) up to 393 feet per min. (120 m/min.), depending on the individual edge banding machine used.

Press Rollers

Considering the specifications of the machine a sufficient number of press rollers is required, as well as a correct pressure setting to achieve the best possible seam.

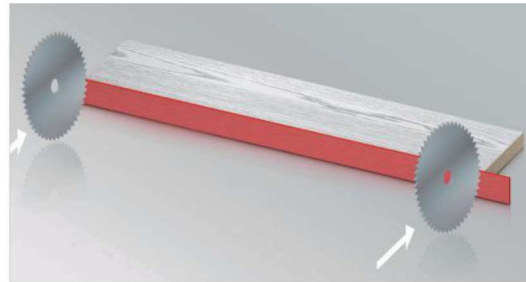


Cutting Knife

The cutting knife should have a sharp blade to separate the edge banding material without splintering, leaving a minimum of excess material for crosscut milling to make copy milling easier afterwards.

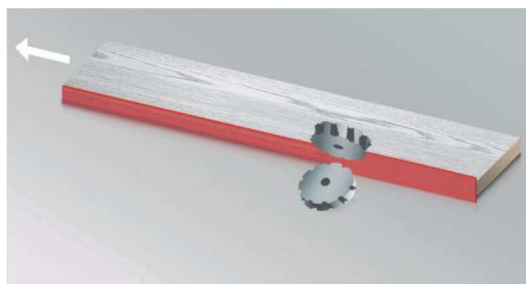
Cutting

The cut-off saw should run into the edging material at an adapted feed rate without any splintering. Usage of serrated cut-saw blades is recommended.



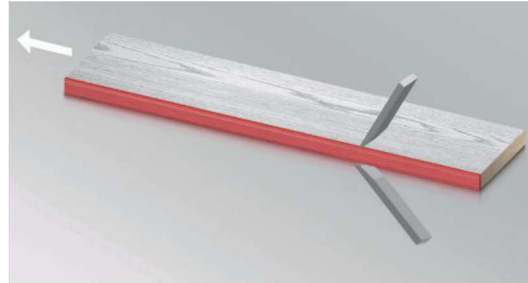
Milling

Plastic edge bands should always be milled in reverse rotation. The excess length of the edge should be even on both sides, approximately .059 inches [1.5 mm]; however, not more than the thickness of the edge band. It is recommended to apply four to six edged milling cutters with a diameter of 2 3/4" [70 mm] and operate with a milling speed of 12,000 to 18,000 r.p.m. Inappropriate speed or blunt tools may cause damage to the edge bands. If any smearing or melting occurs, the speed should be reduced, or the feeding be increased. Alternatively, milling cutters with a larger axial angle should be used. High rotation accuracy of the milling cutter will avoid chatter marks.



Scraping

For a high-quality result, the scraper chip should be at maximum .004 - .008 inches [0.1 – 0.2 mm] thick.



Buffing

MKT ABS and PP edge bands can be finished with buffing discs. In through-feed mode, any glue residue can be removed with buffing discs. For removal of glue residue electronically controlled release agent spray units can also be used, which simultaneously improve the scraping of the chip.



Lacquering

If MKT PP edge bands are supplied with special lacquers or painted after application of a special primer, the usage of a corona plasma flame is recommended to improve the result. The board material should be exactly masked off when applying the primer to avoid blemishes in the surface finish. The primer should also completely cover the milled radius.

Protective Foil

For high gloss, excellent gloss and metallica surfaces protective foils should be used, both during transportation as well as during processing.

7. Cleaning

For cleaning Alpha-Tape Zero® PP edge bandings MKT recommends special plastic cleansing agents. Test first reliability on a small sample. Never use alcohol-based or solvent-based cleaners.

8. Disposal

Dispose all materials in accordance with local regulations.



9. Trouble Shooting

a. Laser Technology

Problem	Diagnosis
The edge band shows an open joint over the entire length of the edge.	• Incorrect laser coverage setting. • Incorrect pressure zone setting. • Incorrect angle at form cutting.
The edge band shows an open joint in the copying corner.	• Edge and board feed not synchronized. • Edge overhang too long/short. • Laser radiation start/end not compatible.
The edge band can be easily pulled off by hand.	• Functional layer thickness outside tolerance. • Pressure zone setting incorrect (lift/pressure). • Energy specification not compatible with the edge.
The functional layer starts to burn or heavily forms smoke.	• Energy specification not compatible with the edge. • Dirty or missing functional layer.
The edge band jams in the hopper.	• Lengthwise warping or width fluctuation of the edge. • Retaining device set too slow.
The machine temperature sensor switches off.	• Incorrect laser coverage setting • Laser penetration due to insufficient coloring of the edge.

b. Hot-Air Technology

Problem	Diagnosis
The edge band shows an open joint over the entire length of the edge.	• Pressure supply too low. • Incorrect pressure zone setting. • Incorrect angle at form cutting.
The edge band shows an open joint in the copying corner.	• Edge and board feed not synchronized. • Edge overhang too long/short. • Heat input start/end not compatible.
The edge band can be easily pulled off by hand.	• Functional layer thickness outside tolerance. • Pressure zone setting incorrect (lift/pressure). • Heat input not compatible with the edge.
The functional layer of the edge band smudges.	• Temperature setting not compatible with edge coating (correct specifications for Alpha-Tape® Zero PP). • Nozzle pressure too high.
The edge band jams in the hopper.	• Lengthwise warping or width fluctuation of the edge. • Retaining device set too slow. • Functional layer jams on edge guide (pull edge back during work breaks).
The machine pressure sensor switches off.	• Check compressed air supply.

10. Representation & Warranties / Disclaimer

CUSTOMER ACKNOWLEDGES THAT THE PRODUCTS ARE PROVIDED "AS IS". MKT SPECIFICALLY DISCLAIMS, WITHOUT LIMITATION, ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, OF ANY KIND, INCLUDING, WITHOUT LIMITATION, THE IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, NON-INFRINGEMENT, AND THOSE WARRANTIES ARISING FROM A COURSE OF PERFORMANCE, A COURSE OF DEALING OR TRADE USAGE.

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- II. Standard Specifications Alpha-Tape® COILS**
- III. Technical data sheet Alpha-Tape® ABS**
- IV. Technical data sheet Alpha-Tape® PP**
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- VIII. Safety Data Sheet Alpha-Tape® ABS**
- IX. Safety Data Sheet Alpha-Tape® PP**
- X. Safety Data Sheet Alpha-Tape ZERO® PP**

EN **Standard specifications**
ES **Especificaciones estándar**
FR **Spécifications standards**

1 Roll details / Detalles de los rollos / Spécificités des rouleaux

Thickness Grosor Épaisseur	Roll length Longitud del roll Longueur des rouleaux	Inner core Ø Ø interior Ø intérieur du carton	Outer diameter (aprox..) Ø exterior (aprox.) Ø extérieur (ca.)
0.015 in	1'476.378 ft	7.874 in	20.472 in
0.024 in	1'148.294 ft	7.874 in	22.047 in
0.027 in	984.252 ft	7.874 in	22.047 in
0.031 in	984.252 ft	7.874 in	23.228 in
0.039 in	656.167 ft	7.874 in	21.653 in
0.047 in	656.167 ft	7.874 in	23.228 in
0.051 in	492.126 ft	7.874 in	21.259 in
0.059 in	492.126 ft	7.874 in	22.440 in
0.067 in	410.105 ft	7.874 in	21.653 in
0.079 in	328.084 ft	11.811 in	23.228 in
0.118 in	328.084 ft	15.748 in	29.134 in
0.40 mm	450 m	200 mm	520 mm
0.60 mm	350 m	200 mm	560 mm
0.70 mm	300 m	200 mm	560 mm
0.80 mm	300 m	200 mm	590 mm
1.00 mm	200 m	200 mm	550 mm
1.20 mm	200 m	200 mm	590 mm
1.30 mm	150 m	200 mm	540 mm
1.50 mm	150 m	200 mm	570 mm
1.70 mm	125 m	200 mm	550 mm
2.00 mm	100 m	300 mm	590 mm
3.00 mm	100 m	400 mm	740 mm

2 Short shipment and/or overdelivery / Control para rollos cortos / Sous et/ou Surlivraison**Max. 20 % per item per thickness**

Máx. 20 % por artículo y por grosor

Max. 20% par article, par épaisseur

3 Agreement on shorter rolls / Control para rollos cortos / Règle des petits rouleaux

Shorter rolls shall measure at least 50 % of the stipulated roll length, cut every 196.85 in (5 m) and labeled accordingly. Their proportion shall not exceed 20% of the total order.

Los rollos cortos deben medir al menos un 50 % de la longitud estipulada por rollo, ir cortados cada 196.85 in (5 m) y etiquetados adecuadamente. Su proporción no debe exceder el 20 % del pedido total.

Les petits rouleaux doivent mesurer au moins 50% de la longueur des rouleaux stipulée ci-dessus, coupés tous les 196.85in (5 m) et conformément étiquetés. Leur quantité ne doit pas excéder 20% de la commande totale.

Standard specifications

Especificaciones estándar

Spécifications standards

4 Technical data / Datos técnicos / Données techniques

Please, observe our technical data sheets! For more information revert to: <https://www.mkt-gmbh.com>

Consulte nuestras fichas técnicas. Para más información, diríjase a: <https://www.mkt-gmbh.com>

Veuillez-vous référer à nos fiches techniques ! Plus d'informations sur notre site : <https://www.mkt-gmbh.com>

5 Protective foil / Película protectora / Film de protection

Our Alpha-Tape® excellent gloss and high gloss edge banding is generally protected by a PE-protection foil. Alpha-Tape® excellent matt and excellent effect as well as soft matt 3 and gloss 90 are generally unprotected by a PE-protection foil. If you are in need of a protection foil, please contact our application technology. If possible, we will recommend a protective foil for your individual needs during processing.

We strongly recommend to remove the protection foil immediately after processing!

Nuestras cantoneras Alpha-Tape® excellent-gloss y high gloss se entregan protegidas generalmente con una película de protección de polietileno. Alpha-Tape® excellent mat y excellent effet, así como soft matt 3 y gloss 90 no llevan por lo general dicha película de PE. Si necesita la película de protección, póngase en contacto con nuestro Dep. de Aplicación Técnica. Si es posible, le recomendaremos una protección personalizada a sus necesidades durante el procesamiento.

¡Le recomendamos que retire la película protectora inmediatamente después del procesamiento!

Nos chants Alpha-Tape® excellent gloss- et high-gloss sont généralement livrés avec un film de protection poléthylène. Alpha-Tape® excellent mat et excellent effet ainsi que soft mat 3 et gloss 90 sont généralement livrés sans film de protection. Si vous avez cependant besoin d'un film de protection pour ces versions, veuillez communiquer avec notre Service Application Technique. Il s'agit, dans la mesure du possible, de proposer une variante de film de protection optimale pour votre process d'usinage.

Nous recommandons d'enlever le film de protection immédiatement après l'usinage !

6 Roll packaging / Embalaje de los rollos / Emballage des chants

Cardboard inner core

Núcleo interior de cartón de grosor

Epaisseur du rouleau en carton intérieur

0.19 in

5 mm

Exception: edging thickness ≥ 0.12 in (≥ 3 mm)

Excepción: cintas ≥ 0.12 in (≥ 3 mm)

Exception : chants ≥ 0.12 in (≥ 3 mm)

without core

sin núcleo

sans rouleau

Fixation on the cardboard inner core with double-faced adhesive tape

Fijación del rollo de cartón interior: adhesivo de doble cara

Fixation du rouleau de carton intérieur : avec un adhésif double-face

Crepé tape for fastening the outside end of the rolls

Tira de papel crepé para la fijación del extremo del rollo (exterior)

Bande de papier crêpe pour la fixation de l'extrémité du rouleau (extérieure)

2 straps for fixation

2 tiras de fleje para la fijación

2 bandes de cerclage pour la fixation

Labeling inside the roll's inner core; Size

Etiquetado dentro del rollo de cartón interior: dimensiones

Etiquette sur le rouleau du carton intérieur ; dimensions

0.67 in x 3.54 in

17 mm x 90 mm

Layout and inscription / Diseño y especificaciones / Données et inscription

 Alpha-Tape® ABS Grau DG 06281 KB-UN0925 MKT-43 28x1,00 G./Film./ -	FA: 21394/000 - 10 C:1 - S:1 R: 100 m
---	--

Standard specifications

Especificaciones estándar

Spécifications standards

7 Palettenverpackung / Embalaje de los palés / Emballage sur palettes

Fixed rolls piled up on pallets; Timber support inside inner core against shifting of rolls during transport.

Los rollos van apilados sobre palés; soporte de madera en la parte interna para evitar que los rollos se desplacen durante el transporte.

Les rouleaux sont empilés sur les palettes ; Support en bois à l'intérieur du carton intérieur pour éviter que les rouleaux ne glissent durant le transport.



Pallet packaging

Embalaje sobre palé

Emballage sur palettes

Size

Dimensiones

Dimensions

Euro pallet for Germany, Belgium, The Netherlands, Austria, Switzerland

Palé europeo para Alemania, Bélgica, Países Bajos, Austria y Suiza

Palettes Europe pour l'Allemagne, la Belgique, les Pays-Bas, l'Autriche et la Suisse

47.244 in x 31.496 in

1200 mm x 800 mm

One-way-pallet for other EU or third countries

Palé americano para el resto de países de la UE o fuera de la UE

Palette perdue pour les autres pays de l'Union Européenne ou du monde

47.244 in x 31.496 in

1200 mm x 800 mm

Pallet height

Altura de los palés

Hauteur des palettes

55.118 in

1400 mm

Material height

Altura del material

Hauteur du matériel

47.244 in

1200 mm

2 roll piles for edging in thickness

2 pilas de rollos para espesor de bordes

2 piles de rouleaux pour l'épaisseur

≤ 0.079 in

≤ 2.00 mm

1 roll pile for edging in thickness

1 pila de rollos para espesor de bordes

1 pile de rouleaux pour l'épaisseur

> 0.079 in

> 2.00 mm

Standard specifications

Especificaciones estándar

Spécifications standards

Cardboard cover for each roll pile; fixed with wooden bars and straps; wrapped in PE stretch film.

Cubierta de cartón para cada pila de rollos; va fijada con listones de madera y flejes; envuelta con película de PE flexible.

Chaque pile est recouverte de carton ; fixée avec du bois et des sangles; emballée avec un film stretch PE.



A sample for each item is attached to the pallet – See point 6 (roll packaging) for type of labelling

Se adjunta con el palé una muestra de cada elemento. Para el tipo de etiquetado, consulte el punto 6 (embalaje de los rollos).

Chaque article un échantillon visuel sur la palette – Etiquetage voir point 6 – Conditionnement du rouleau.

8 Pallet labelling / Etiquetado de palés / Etiquettage des palettes

Label visible on the pallet; size / Etiqueta visible en el palé; dimensiones

5.90 in x 3.93 in

150 x 100 mm

Etiquette visible sur la palette; dimension

Layout and inscription / Diseño y especificaciones / Données et inscription

Versand Standard		Datum: 26.09.2018	
MKT		Kundenname	
		Lieferort	
		Kd.Best.Nr.:	
		Kd.Art.Nr.:	
		MKT Nr. b. Kd.:	
Art.Nr. MKT: AKB017582		KA: 21731000 - 10	
Alpha-Tape® PP Weiss			
DG08079 KB-UL 1199 MKT-00 23x1,00 G:10 Film/-			
4 Rolle(n)	50 lfm/Rolle	200 lfm	16 366 000-10-661 97
	Gesamt	G 200 lfm	01-01-01-01
Gebr. Eschbach GmbH Moderne Kunststoff Technik 99885 Ohrdruf Herrenhöfer Landstraße 2 Tel.: (0 36 24) 3 69 23 Fax.: (0 36 24) 3 13 708 www.mkt-gmbh.com			
Netto (kg): 4 / Paletten-Nr.: 1			
Made in Germany			

Standard specifications

Especificaciones estándar

Spécifications standards

9 Mode of dispatch / Modo de entrega / Mode d'expédition

US-stock	By parcel service or truck, depending on size of the order, delivery time depending on shipping service and distance between the states Por grupaje o camión dependiendo del volumen del pedido Plazo de entrega dependiendo del servicio de entregas y la distancia entre estados Par service de colis ou camion, selon la taille de la commande, le délai de livraison est en fonction du service d'expédition et la distance entre les États
Import Importación Importation	State-specific, needs to be agreed individually Necesidades específicas de importación en los estados se deben acordar individualmente Spécifique à l'État, doit être convenue individuellement

EN

Standard specifications for coils

ES

Especificaciones estándar para bobinas

FR

Spécifications standards pour les bobines mères

1 Roll details / Detalles de los rollos / Spécificités des rouleaux

Thickness Grosor Épaisseur	Roll length Longitud del roll Longueur des rouleaux	Inner core Ø Ø interior Ø intérieur du carton	Outer diameter (aprox.) Ø exterior (aprox.) Ø extérieur (ca.)
0.015 in	1'476.378 ft	7.874 in	20.472 in
0.024 in	1'148.294 ft	7.874 in	22.047 in
0.027 in	984.252 ft	7.874 in	22.047 in
0.031 in	984.252 ft	7.874 in	23.228 in
0.039 in	656.167 ft	7.874 in	21.653 in
0.047 in	656.167 ft	7.874 in	23.228 in
0.051 in	492.126 ft	7.874 in	21.259 in
0.059 in	492.126 ft	7.874 in	22.440 in
0.067 in	410.105 ft	7.874 in	21.653 in
0.079 in	328.084 ft	11.811 in	23.228 in
0.118 in	328.084 ft	15.748 in	29.134 in
0.40 mm	450 m	200 mm	520 mm
0.60 mm	350 m	200 mm	560 mm
0.70 mm	300 m	200 mm	560 mm
0.80 mm	300 m	200 mm	590 mm
1.00 mm	200 m	200 mm	550 mm
1.20 mm	200 m	200 mm	590 mm
1.30 mm	150 m	200 mm	540 mm
1.50 mm	150 m	200 mm	570 mm
1.70 mm	125 m	200 mm	550 mm
2.00 mm	100 m	300 mm	590 mm
3.00 mm	100 m	400 mm	740 mm

2 Short shipment and/or overdelivery / Control para rollos cortos / Sous et/ou Surlivraison

Max. 20 % per item per thickness

Máx. 20 % por artículo y por grosor

Max. 20% par article, par épaisseur

3 Agreement on shorter rolls / Control para rollos cortos / Règle des petits rouleaux

Shorter rolls shall measure at least 50 % of the stipulated roll length, cut every 196.85 in (5 m) and labeled accordingly. Their proportion shall not exceed 20% of the total order.

Los rollos cortos deben medir al menos un 50 % de la longitud estipulada por rollo, ir cortados cada 196.85 in (5 m) y etiquetados adecuadamente. Su proporción no debe exceder el 20 % del pedido total.

Les petits rouleaux doivent mesurer au moins 50% de la longueur des rouleaux stipulée ci-dessus, coupés tous les 196.85in (5 m) et conformément étiquetés. Leur quantité ne doit pas excéder 20% de la commande totale.

4 Technical data / Datos técnicos / Données techniques

Please, observe our technical data sheets! For more information revert to: <https://www.mkt-gmbh.com>

Consulte nuestras fichas técnicas. Para más información, diríjase a: <https://www.mkt-gmbh.com>

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Standard specifications for coils

Especificaciones estándar para bobinas

Spécifications standards pour les bobines mères

5 Protective foil / Película protectora / Film de protection

Our Alpha-Tape® excellent gloss and high gloss edge banding is generally **protected** by a PE-protection foil. Alpha-Tape® excellent matt and excellent effect as well as soft matt 3 and gloss 90 are generally **unprotected** by a PE-protection foil. If you are in need of a protection foil, please contact our application technology. If possible, we will recommend a protective foil for your individual needs during processing.

We strongly recommend to remove the protection foil immediately after processing!

Nuestras cantoneras Alpha-Tape® excellent-gloss y high gloss se entregan protegidas generalmente con una película de protección de polietileno. Alpha-Tape® excellent mat y excellent effet, así como soft matt 3 y gloss 90 no llevan por lo general dicha película de PE. Si necesita la película de protección, póngase en contacto con nuestro Dep. de Aplicación Técnica. Si es posible, le recomendaremos una protección personalizada a sus necesidades durante el procesamiento.

¡Le recomendamos que retire la película protectora inmediatamente después del procesamiento!

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Nous recommandons d'enlever le film de protection immédiatement après l'usinage !

6 Roll packaging / Embalaje de los rollos / Emballage des chants

Cardboard inner core Núcleo interior de cartón de grosor Epaisseur du rouleau en carton intérieur	0.19 in	5 mm
Plastic adhesive tape for fastening the outside end of the rolls, width Cinta de plástico adhesivo para fijar el exterior de los rollos, de ancho Ruban adhésif pour la fixation de l'extrémité du rouleau (extérieure), largeur de	0.40 in	10 mm
Label; size / Etiquetado; dimensiones / Etiquette; dimension	5.90in x 3.93 in	150 x 100 mm

Layout and inscription / Diseño y especificaciones / Données et inscription



Kundenname

Art.Nr. Kunde:

Alpha-Tape® ABS Weiß
DG05863 KB-UN0405 MKT-07 415x2.00 G:/ Film/-

Art.Nr. MKT: **AKB013721** FA: **28159/000 - 10**

Stk./Rolle: 1 x 100 m

Menge: 100 m

Coil-Nr.: 37

Made in Germany

Gebr. Eschbach GmbH
Moderne Kunststoff Technik
99885 Ohrdruf
Herrenhöfer Landstraße 2
Tel.: (0 36 24) 3 09 23
Fax.: (0 36 24) 3 13 708
www.mkt-gmbh.com

Standard specifications for coils

Especificaciones estándar para bobinas

Spécifications standards pour les bobines mères

7 Palettenverpackung / Embalaje de los palés / Emballage sur palettes

Pallet packaging

Embalaje sobre palé
Emballage sur palettes

Size

Dimensions
Dimensions

Euro pallet for Germany, Belgium, The Netherlands, Austria, Switzerland

Palé europeo para Alemania, Bélgica, Países Bajos, Austria y Suiza
Palettes Europe pour l'Allemagne, la Belgique, les Pays-Bas, l'Autriche et la Suisse

47.244 in x 31.496 in
1200 mm x 800 mm

One-way-pallet for other EU or third countries

Palé americano para el resto de países de la UE o fuera de la UE
Palette perdue pour les autres pays de l'Union Européenne ou du monde

47.244 in x 31.496 in
1200 mm x 800 mm

Pallet height

Altura de los palés
Hauteur des palettes

55.118 in
1400 mm

Material height

Altura del material
Hauteur du matériel

47.244 in
1200 mm

2 roll piles for edging in thickness

2 pilas de rollos para espesor de bordes
2 piles de rouleaux pour l'épaisseur

≤ 0.079 in
≤ 2.00 mm

1 roll pile for edging in thickness

1 pila de rollos para espesor de bordes
1 pile de rouleaux pour l'épaisseur

> 0.079 in
> 2.00 mm

Cardboard cover for each roll pile; fixed with wooden bars and straps; wrapped in PE stretch film.

Cubierta de cartón para cada pila de rollos; va fijada con listones de madera y flejes; envuelta con película de PE flexible.
Chaque pile est recouverte de carton ; fixée avec du bois et des sangles; emballée avec un film stretch PE.



Standard specifications for coils

Especificaciones estándar para bobinas

Spécifications standards pour les bobines mères

A sample for each item is attached to the pallet – See point 6 (roll packaging) for type of labelling

Se adjunta con el palé una muestra de cada elemento. Para el tipo de etiquetado, consulte el punto 6 (embalaje de los rollos).

Chaque article un échantillon visuel sur la palette – Etiquetage voir point 6 – Conditionnement du rouleau.

8 Pallet labelling / Etiquetado de palés / Etiquetage des palettes

Label visible on the pallet; size / Etiquetado visible en el palé; dimensiones

5.90 in x 3.93 in

150 x 100 mm

Etiquette visible sur la palette; dimension

Layout and inscription / Diseño y especificaciones / Données et inscription

Versand Standard		Datum: 26.09.2018	
		Kundenname	
		Lieferort	
		Kd.Best.Nr.:	
		Kd.Art.Nr.:	
		MKT Nr. b. Kd.:	
Art.Nr. MKT: AKB017582		KA: 21731000 - 10	
Alpha-Tape® PP Weiss			
DG08079 KB-UL1199 MKT-00 23x1,00 G:10 Film:/ -			
4 Rolle(n)	50 lfm/Rolle	200 lfm	16366000-10-66197
	Gesamt	Q 200 lfm	01-01-01-01
Netto (kg): 4 / Paletten-Nr.: 1 Made in Germany			
Gebr. Eschbach GmbH Moderne Kunststoff Technik 99885 Ohrdruf Herrenhöfer Landstraße 2 Tel.: (0 36 24) 3 69 23 Fax.: (0 36 24) 3 13 708 www.mkt-gmbh.com			

9 Mode of dispatch / Modo de entrega / Mode d'expédition

US-stock

By parcel service or truck, depending on size of the order, delivery time depending on shipping service and distance between the states

Por grupaje o camión dependiendo del volumen del pedido Plazo de entrega dependiendo del servicio de entregas y la distancia entre estados

Par service de colis ou camion, selon la taille de la commande, le délai de livraison est en fonction du service d'expédition et la distance entre les États

Import

Importación
Importation

State-specific, needs to be agreed individually

Necesidades específicas de importación en los estados se deben acordar individualmente

Spécifique à l'État, doit être convenue individuellement

EN **Technical data sheet**
ES **Ficha técnica**
FR **Fiche technique**

1 Alpha-Tape® ABS – General / Información General / Généralités

Alpha-Tape® ABS edge banding is a thermoplastic edging developed for the decorative finishing of panels. It has a protective as well as a design function. The edge banding is produced from acrylonitrile-butadiene-styrene and completely imbued.

Las cintas Alpha-Tape® ABS constituyen cintas termoplásticas para el recubrimiento decorativo de superficies estrechas de materiales de trabajo de madera y adoptan una función de protección y diseño. Cintas de borde se fabrican de Acrilo-nitrilo-Butadieno-Estireno y están completamente teñidas.

Bandes de chants Alpha-Tape® ABS sont des chants thermoplastiques pour le recouvrement décoratif des chants des panneaux et assurent une fonction de protection et de design. Les bandes de chants sont fabriquées en Acrylonitrile butadiène styrène et sont teintées dans la masse sur toute la surface.

2 Adhesion properties / Propiedades adhesivas / Propriétés d'adhésion

Alpha-Tape® ABS edge banding is back side coated with a primer. It can be processed with the current adhesives based on EVA, PO, PUR, PA and APAO. Together with our Alpha-Tape® ABS edge banding, these highly heat-resistant adhesives ensure a good and firm adhesive bonded joint. If the furniture product is exposed to high application temperatures (e.g. furniture transport in a container or heat sources in a kitchen such as an oven or a stove; etc.), we recommend to use hot melt adhesives with a higher resistance to thermal distortion.

For the processing with high filled EVA hot melt-adhesives we deeply recommend to contact our technical department for application and processing questions, since a general suitability statement for this adhesives class is not possible. Please pay attention to the processing instructions of your adhesive supplier with special respect to processing temperature and amount of adhesive.

Important notice: The thermostats in the melting pots of the edge banding machines are often imprecise and the final temperature can deviate up to 86°F (30°C)!

Las cintas Alpha-Tape® ABS llevan revestidas en el dorso un agente adhesivo (Primer). Son aplicables mediante pegamentos de termo-fusión de uso comercial basados en EVA, PO, PUR, PA así como APAO (Poli-Alfa-Olefina amorfa). Estos pegamentos altamente resistentes al calor junto con nuestros bordes Alpha-Tape® ABS garantizan una buena y segura unión adhesiva. Si posteriormente los muebles se exponen a altas temperaturas de aplicación (por ejemplo, transporte de muebles en un contenedor, fuentes de calor en cocinas como un horno o estufa), recomendamos el pegamento termo fusible con una mayor resistencia al calor.

Para el procesamiento de pegamentos de termo fusión EVA altamente estirados recomendamos contacten nuestro Departamento de Técnica de Aplicaciones, ya que no nos es posible hacer una declaración general de aptitud para esta clase de pegamento. Rogamos tengan en cuenta las instrucciones de procesamiento, especialmente en cuanto a las temperaturas y cantidades para las aplicaciones.

Importante: Los termostatos en los tanques de fusión de los sistemas a menudo son inexactos y la temperatura final en el rodillo de aplicación puede variar hasta 86°F (30°C).

Les Bandes de chants Alpha-Tape® ABS sont revêtues sur la face arrière d'un primaire d'adhérence. Elles peuvent être usinées avec des colles thermofusibles usuelles sur une base EVA, PO, PUR, PA et également APAO (polyoléfine). Ces adhésifs hautement résistants à la chaleur, associés à nos chants Alpha-Tape® ABS, garantissent une bonne et fiable adhérence. Si le meuble doit par la suite être exposé à des températures d'application élevées (par exemple, transport de meubles dans un Container, sources de chaleur dans les cuisines telles qu'un four ou une cuisinière), nous recommandons un adhésif thermofusible avec une résistance à la chaleur plus élevée. Pour l'usinage avec des colles thermofusibles de composition EVA, nous vous recommandons de prendre contact avec notre service technique, car une préconisation générale n'est pas possible avec ces classes de colles. Veuillez SVP respecter les conseils d'usage des fournisseurs de colles, plus particulièrement concernant les températures et les quantités d'utilisation.

Important: les thermostats dans les bacs de fusion des installations sont souvent imprécis et la température finale sur le rouleau d'application peut dévier jusqu'à 86°F (30°C)!

Technical data sheet

Ficha técnica

Fiche technique

3 Delivery program / Gama de Suministro / Gamme de produits

Design / Diseño / Design

UN plain colors, non coated / Unicolor, no barnizado / Décors unis non laqués

UL plain colors, coated / Unicolor, barnizado / Décors unis laqués

HR decors, coated / Decorado, barnizado / Décors laqués

ME Metal Effect, coated / Metal Effect, barnizado / laqués

Profil type / Typo perfil / Type de profil

Alpha-Tape® ABS

KB edge banding / Cinta de borde
Chants thermoplastique

SR jumbo roll (for slitting) / Rollo matrix (para perforar)
Rouleau géant (pour séparer)

Width
Anchura
Largeur

0.47 – 2.36 in
2.36 – 4.13 in

12.0 – 60.0 mm
60.0 – 105.0 mm

– 15.95 in
– 405.0 mm

Thickness
Grueso de pared
Épaisseur

0.02 – 0.13 in
0.02 – 0.08 in

0.40 – 3.20 mm
0.40 – 2.00 mm

0.02 – 0.13 in
0.40 – 3.20 mm

Further profile types and their technical data are available on our website.

Para encontrar otros tipos de perfiles y sus datos técnicos rogamos busquen en Internet.

Pour voir nos autres produits ainsi que leurs fiches techniques, veuillez SVP vous consulter notre site internet.

4 Tolerance / Tolerancias / Tolérances

Thickness / Grueso de pared / Épaisseur

	Lower tolerance Tolerancia inferior Tolérance mini	Upper tolerance Tolerancia superior Tolérance maxi
0.016 – 0.031 in	- 0.002 in	+ 0.002 in
0.035 – 0.039 in	- 0.006 in	+ 0.004 in
0.043 – 0.063 in	- 0.008 in	+ 0.004 in
0.067 – 0.079 in	- 0.009 in	+ 0.002 in
0.083 – 0.126 in	- 0.012 in	+ 0.002 in
0.40 – 0.80 mm	- 0.05 mm	+ 0.05 mm
0.90 – 1.00 mm	- 0.15 mm	+ 0.10 mm
1.10 – 1.60 mm	- 0.20 mm	+ 0.10 mm
1.70 – 2.00 mm	- 0.25 mm	+ 0.05 mm
2.10 – 3.20 mm	- 0.30 mm	+ 0.05 mm

Width / Anchura / Largeur

	Lower tolerance Tolerancia inferior Tolérance mini	Upper tolerance Tolerancia superior Tolérance maxi
0.47 – 15.94 in	- 0.008 in	+ 0.019 in
12.0 – 405.0 mm	- 0.20 mm	+ 0.50 mm

5 Level parallelism / Paralelismo de plano / Niveau de parallélisme

All available widths / Todos los anchos disponibles / Toutes largeurs disponibles

< 0.004 in

< 0.10 mm

6 Pre-tension / Pre-tensión / Précontrainte

Width < 2.362 in (<60 mm) / Largeur / Anchura

0.00 – 0.014 in

0.00 – 0.35 mm

Width ≥ 2.362 in (≥60 mm) / Largeur / Anchura

> 0.004 in

> 0.10 mm

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7 Longitudinal deformation / Labeado en longitud / Tension longitudinale

All available widths and lengths / Todos los anchos y longitudes disponibles

Valable pour toutes largeurs et épaisseurs disponibles

< 0.12 in / 39.37 in < 3.0 mm / 1,000.0 mm

8 Color / Color / Couleur

Alpha-Tape® ABS

UN *uncoated* / no barnizado / non laqué

UL *coated* / barnizado / laqué

White colors / Colores Blancos / Couleurs clair

Medium colors / Colores Mediano / Couleurs moyenne

Dark colors / Colores Oscuros / Couleurs foncée

L-value

Valor-L

L-valeur

C-value

Valor-C

L-valeur

ISO QC

ISO QC

ISO QC

Tolerance

Tolerancias

Tolérances

> 90

< 5

dE cmc

0.5

70 – 90

< 60

dE cmc

0.8

30 – 70

< 40

dE cmc

1.5

9 Gloss ¹ / Área de brillo / Brillance

Alpha-Tape® ABS

UL ² *coated* / barnizado / laqué

HR *decors* / decorado / décors

ME *Metal Effect* / Metal Effect / Metal Effect

Gloss scale

Unidad de grado de brillo

Degré de brillance

Tolerance

Tolerancias

Tolérances

5° – 30°

- 2 / +5

31° – 70°

- 5 / +5

¹ Measuring angle 60° / Angulo de medición 60° / Angle de mesure 60°

² UN: no fixing of gloss level possible / UN: no es posible una determinación del grado del brillo / UN: pas de détermination du degré de brillance possible

10 Processing on CNC machine center / Procesamiento en Centros de Trabajo CNC

Mise en oeuvre sur les centres d'usinage CNC

In order to find the suitable Alpha-Tape® edging for your required radii application, please contact our technical department for application and processing questions. For certain radii we offer a special ABS-CNC-version. We are looking forward assisting you with the optimization of your machine settings/parameters.

Si desean emplear nuestras cintas Alpha Tape Kanten en un equipo CNC, tienen nuestro Departamento de Técnica de Aplicaciones a su entera disposición. Para exigencias específicas de radios existe una ejecución especial ABS-CNC. Les asistimos gustosamente en la elección de las cintas adecuadas así como en la selección de los ajustes óptimos de las máquinas y sus parámetros.

Afin de trouver les chants adéquats pour le passage de vos rayons, veuillez contacter SVP notre service technique. Ce dernier sera présent pour vous conseiller. Pour des exigences spécifiques de rayons, nous avons une réalisation spécifique ABS qualité CNC. Nous vous aiderons à trouver les chants adéquats ainsi que les meilleurs réglages/paramètres pour vos plaqueuses.

Technical data sheet

Ficha técnica

Fiche technique

11 Properties / Propiedades / Propriétés

Alpha-Tape® ABS	Value Valor Valeur	Standard for testing Norma de comprobación Norme de contrôle
Fastness to light / Resistencia a la luz / Résistance à la lumière	> 6	ISO 4892-2
Softening point (Vicat B50) Punto de ablandamiento / Point de ramollissement	~ 203°F ~ 95°C	ISO 306
Shrinkage / Retractilado / Retrait	< 1%	MKT Standard / Norma MKT / Norme MKT
Hardness (Shore D) / Dureza / Dureté	~ 73	DIN ISO 7619-1
Scratch resistance (Erichsen Test 318 No. 1) ³ Resistencia a los rasguños y rayados / Résistance aux éraflures	4-6 N	MKT Standard / Norma MKT / Norme MKT
Chemical resistance ⁴ Constancia química / Résistance chimique	1 B	DIN 68861, Pt. 1 (LGA tested)

⁴ Not valid for UN *uncoated* / Excepto UN *no barnizado* / Ceci n'est valable que pour les chants UN *non laqué*

⁵ Exception: **acetone, ethyl-butylacetate** / Excepción: Acetona, Etileno-Acetato Butílico / Exception: acétone, ethyl-butylacétate

12 Cleaning / Limpieza / Nettoyage

For cleaning Alpha-Tape® ABS edge banding MKT recommends special plastic cleansing agents. Reliability must be tested on a small sample first. Never use alcohol-based or solvent-based cleaners.

Para la limpieza de cintas Alpha-Tape® ABS recomendamos el empleo de detergentes específicos. Su aptitud debería ser garantizada por pruebas antes de su uso. No se deben utilizar productos que contengan concentraciones altas de alcohol o disolventes.

Pour le nettoyage des bandes de chants Alpha-Tape® ABS, il est recommandé d'utiliser des nettoyeurs synthétiques spéciaux. Des essais devront être effectués au préalable. Les nettoyeurs à base de solvants ou d'alcool ne devront pas être utilisés.

13 Storage conditions / Almacenaje / Conditions de stockage

Stored under proper conditions – on a dry and cool place (<86°F / <30°C) and protected from direct sunlight or dust –, Alpha-Tape® ABS edge banding is applicable for a minimum period of one year.

Las cintas Alpha-Tape® ABS se pueden almacenar profesionalmente, manteniendo en bajas temperaturas (<86°F / <30°C), en ambientes secos, protegidas de la luz del sol y del polvo, durante al menos 1 año.

Les bandes de chants Alpha-Tape® ABS peuvent être stockées au moins un an dans un local approprié : frais <86°F / <30°C) et sec, protégé des rayons UV et des poussières.

Information and advice for application, if orally, in writing or by tests, are to the best of our knowledge, however, are not binding, especially in view of possible third party trade mark rights. Consultation with us does not exempt you from executing your own testing for the planned methods and purposes. Application, use and processing of our products, as well as your manufacturing of final goods following our advice are beyond our control and thus lie solely in your responsibility. The sale of our products is carried out according to our general commercial terms and conditions. Indicated data serve for orientation only. They do not represent any specification nor give warranty for edge banding characteristics.

La presente información y nuestro asesoramiento en cuanto a la técnica de procesamiento por palabra, escrito y mediante pruebas y ensayos se llevan a cabo de buena fe, son considerados como indicaciones sin compromiso, también en relación a posibles derechos de protección de terceros. El asesoramiento no le libera a usted de su propio examen de aptitud en cuanto a sus objetivos e intenciones de procesos. Empleo, utilización y procesamiento de nuestros productos y de los productos fabricados por ustedes mediante nuestro asesoramiento se realizan fuera de nuestras posibilidades de control y por lo tanto quedan exclusivamente en su área de responsabilidad. La venta de nuestros productos se lleva a cabo bajo nuestras Condiciones Generales Comerciales. Los datos indicados se ofrecen como datos aproximados para la orientación. No constituyen especificación o garantía de propiedades.

Les présentes informations et nos conseils d'application sous forme orale, écrite et par démonstration sont donnés de bonne foi, mais ne sauraient revêtir un caractère contractuel, ce qui vaut également pour d'éventuels droits de protection des tiers. Les conseils prodigués ne vous délivrent pas de l'obligation d'effectuer votre propre test d'aptitude par rapport aux processus et applications envisagés. L'application, l'utilisation et la transformation de nos produits ainsi que des produits que vous avez fabriqués sur la base de notre activité-conseil échappent à nos opportunités de contrôle et se situent donc exclusivement dans votre espace de responsabilité. Nos produits sont distribués en conformité avec nos conditions générales de vente. Les données mentionnées le sont à titre indicatif et ont vocation d'orientation. En aucun cas, elles ne sauraient exprimer une spécification ou garantir des propriétés.

EN **Technical data sheet**
ES **Ficha técnica**
FR **Fiche technique**

1 Alpha-Tape® PP – General / Información General / Généralités

Alpha-Tape® PP edge banding is a thermoplastic edging developed for the decorative finishing of panels. It has a protective as well as a design function. The edge banding is produced from polypropylene and completely imbued.

Las cintas Alpha-Tape® PP constituyen cintas termoplásticas para el recubrimiento decorativo de superficies estrechas de materiales de trabajo de madera y adoptan una función de protección y diseño. Cintas de borde se fabrican de Polipropileno y están completamente teñidas.

Bandes de chants Alpha-Tape® PP sont des chants thermoplastiques pour le recouvrement décoratif des chants des panneaux et assurent une fonction de protection et de design. Les bandes de chants sont fabriquées en polypropylène et sont teintées dans la masse sur toute la surface.

2 Adhesion properties / Propiedades adhesivas / Propriétés d'adhésion

Alpha-Tape® PP edge banding is back side coated with a primer. It can be processed with the current adhesives based on EVA, PO, PUR, PA and APAO. Together with our Alpha-Tape® PP edge banding, these highly heat-resistant adhesives ensure a good and firm adhesive bonded joint. If the furniture product is exposed to high application temperatures (e.g. furniture transport in a container or heat sources in a kitchen such as an oven or a stove; etc.), we recommend to use hot melt adhesives with a higher resistance to thermal distortion.

For the processing with high filled EVA hot melt-adhesives we deeply recommend to contact our technical department for application and processing questions, since a general suitability statement for this adhesives class is not possible. Please pay attention to the processing instructions of your adhesive supplier with special respect to processing temperature and amount of adhesive.

Important notice: The thermostats in the melting pots of the edge banding machines are often imprecise and the final temperature can deviate up to 86°F (30°C)!

Las cintas Alpha-Tape® PP llevan revestidas en el dorso un agente adhesivo (Primer). Son aplicables mediante pegamentos de termo-fusión de uso comercial basados en EVA, PO, PUR, PA así como APAO (Poli-Alfa-Olefina amorfa). Estos pegamentos altamente resistentes al calor junto con nuestros bordes Alpha-Tape® PP garantizan una buena y segura unión adhesiva. Si posteriormente los muebles se exponen a altas temperaturas de aplicación (por ejemplo, transporte de muebles en un contenedor, fuentes de calor en cocinas como un horno o estufa), recomendamos el pegamento termo fusible con una mayor resistencia al calor.

Para el procesamiento de pegamentos de termo fusión EVA altamente estirados recomendamos contacten nuestro Departamento de Técnica de Aplicaciones, ya que no nos es posible hacer una declaración general de aptitud para esta clase de pegamento. Rogamos tengan en cuenta las instrucciones de procesamiento, especialmente en cuanto a las temperaturas y cantidades para las aplicaciones.

Importante: Los termostatos en los tanques de fusión de los sistemas a menudo son inexactos y la temperatura final en el rodillo de aplicación puede variar hasta 86°F (30°C).

Les Bandes de chants Alpha-Tape® PP sont revêtues sur la face arrière d'un primaire d'adhérence. Elles peuvent être usinées avec des colles thermofusibles usuelles sur une base EVA, PO, PUR, PA et également APAO (polyoléfine). Ces adhésifs hautement résistants à la chaleur, associés à nos chants Alpha-Tape® PP, garantissent une bonne et fiable adhérence. Si le meuble doit par la suite être exposé à des températures d'application élevées (par exemple, transport de meubles dans un Container, sources de chaleur dans les cuisines telles qu'un four ou une cuisinière), nous recommandons un adhésif thermofusible avec une résistance à la chaleur plus élevée. Pour l'usinage avec des colles thermofusibles de composition EVA, nous vous recommandons de prendre contact avec notre service technique, car une préconisation générale n'est pas possible avec ces classes de colles. Veuillez SVP respecter les conseils d'usage des fournisseurs de colles, plus particulièrement concernant les températures et les quantités d'utilisation.

Important: les thermostats dans les bacs de fusion des installations sont souvent imprécis et la température finale sur le rouleau d'application peut dévier jusqu'à 86°F (30°C)!

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3 Delivery program / Gama de Suministro / Gamme de produits

Design / Diseño / Design

UL plain colors, coated / Unicolor, barnizado / Décors unis laqués

HR decors, coated / Decorado, barnizado / Décors laqués

ME Metal Effect, coated / Metal Effect, barnizado / laqués

Profil type / Typo perfil / Type de profil

Alpha-Tape® PP	Width Anchura Largeur	Thickness Grueso de pared Épaisseur
KB edge banding / Cinta de borde Chants thermoplastique	0.47 – 2.36 in 2.36 – 4.13 in 12.0 – 60.0 mm 60.0 – 105.0 mm	0.02 – 0.13 in 0.02 – 0.08 in 0.40 – 3.20 mm 0.40 – 2.00 mm
SR jumbo roll (for slitting) / Rollo matrix (para perforar) Rouleau géant (pour séparer)	– 15.95 in – 405.0 mm	0.02 – 0.13 in 0.40 – 3.20 mm

Further profile types and their technical data are available on our website.

Para encontrar otros tipos de perfiles y sus datos técnicos rogamos busquen en Internet.

Pour voir nos autres produits ainsi que leurs fiches techniques, veuillez SVP vous consulter notre site internet.

4 Tolerance / Tolerancias / Tolérances

Thickness / Grueso de pared / Épaisseur			Width / Anchura / Largeur		
	Lower tolerance Tolerancia inferior Tolérance mini	Upper tolerance Tolerancia superior Tolérance maxi		Lower tolerance Tolerancia inferior Tolérance mini	Upper tolerance Tolerancia superior Tolérance maxi
0.016 – 0.031 in	- 0.002 in	+ 0.002 in	0.47 – 15.94 in	- 0.008 in	+ 0.019 in
0.035 – 0.039 in	- 0.006 in	+ 0.004 in			
0.043 – 0.063 in	- 0.008 in	+ 0.004 in			
0.067 – 0.079 in	- 0.009 in	+ 0.002 in			
0.083 – 0.126 in	- 0.012 in	+ 0.002 in			
0.40 – 0.80 mm	- 0.05 mm	+ 0.05 mm	12.0 – 405.0 mm	- 0.20 mm	+ 0.50 mm
0.90 – 1.00 mm	- 0.15 mm	+ 0.10 mm			
1.10 – 1.60 mm	- 0.20 mm	+ 0.10 mm			
1.70 – 2.00 mm	- 0.25 mm	+ 0.05 mm			
2.10 – 3.20 mm	- 0.30 mm	+ 0.05 mm			

5 Level parallelism / Paralelismo de plano / Niveau de parallélisme

All available widths / Todos los anchos disponibles / Toutes largeurs disponibles **< 0.004 in** < 0.10 mm

6 Pre-tension / Pre-tensión / Précontrainte

Width < 2.362 in (<60 mm) / Largeur / Anchura **0.00 – 0.014 in** 0.00 – 0.35 mm
Width ≥ 2.362 in (≥60 mm) / Largeur / Anchura **> 0.004 in** > 0.10 mm

Technical data sheet

Ficha técnica

Fiche technique

7 Longitudinal deformation / Labeado en longitud / Tension longitudinale

All available widths and lengths / Todos los anchos y longitudes disponibles

Valable pour toutes largeurs et épaisseurs disponibles

< 0.12 in / 39.37 in

< 3.0 mm / 1,000.0 mm

8 Color / Color / Couleur

Alpha-Tape® PP

UN **uncoated** / no barnizado / non laqué

White colors / Colores Blancos / Couleurs clair

Medium colors / Colores Mediano / Couleurs moyenne

Dark colors / Colores Oscuros / Couleurs foncée

L-value

Valor-L

L-valeur

C-value

Valor-C

L-valeur

ISO QC

ISO QC

ISO QC

Tolerance

Tolerancias

Tolérances

> 90

< 5

dE cmc

0.5

70 – 90

< 60

dE cmc

0.8

30 – 70

< 40

dE cmc

1.5

9 Gloss ¹ / Área de brillo / Brillance

Alpha-Tape® PP

UL ² **coated** / barnizado / laqué

HR **decors** / decorado / décors

ME **Metal Effect** / Metal Effect / Metal Effect

Gloss scale

Unidad de grado de brillo

Degré de brillance

Tolerance

Tolerancias

Tolérances

5° – 30°

- 2 / +5

31° – 70°

- 5 / +5

¹ Measuring angle 60° / Angulo de medición 60° / Angle de mesure 60°

10 Processing on CNC machine center / Procesamiento en Centros de Trabajo CNC

Mise en oeuvre sur les centres d'usage CNC

In order to find the suitable Alpha-Tape® edging for your required radii application, please contact our technical department for application and processing questions. For certain radii we offer a special PP-CNC-version. We are looking forward assisting you with the optimization of your machine settings/parameters.

Si desean emplear nuestras cintas Alpha Tape Kanten en un equipo CNC, tienen nuestro Departamento de Técnica de Aplicaciones a su entera disposición. Para exigencias específicas de radios existe una ejecución especial PP-CNC. Les asistimos gustosamente en la elección de las cintas adecuadas así como en la selección de los ajustes óptimos de las máquinas y sus parámetros.

Afin de trouver les chants adéquats pour le passage de vos rayons, veuillez contacter SVP notre service technique. Ce dernier sera présent pour vous conseiller. Pour des exigences spécifiques de rayons, nous avons une réalisation spécifique PP qualité CNC. Nous vous aiderons à trouver les chants adéquats ainsi que les meilleurs réglages/paramètres pour vos plaqueuses.

Technical data sheet

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11 Properties / Propiedades / Propriétés

Alpha-Tape®PP	Value Valor Valeur	Standard for testing Norma de comprobación Norme de contrôle
Fastness to light / Resistencia a la luz / Résistance à la lumière	7-8	ISO 4892-2
Softening point (Vicat A50) Punto de ablandamiento / Point de ramollissement	> 248°F > 120°C	ISO 306
Shrinkage / Retractilado / Retrait	< 0,5%	MKT Standard / Norma MKT / Norme MKT
Hardness (Shore D) / Dureza / Dureté	~ 75	DIN ISO 7619-1
Scratch resistance (Erichsen Test 318 No. 1) Resistencia a los rasguños y rayados / Résistance aux éraflures	4-6 N	MKT Standard / Norma MKT / Norme MKT
Chemical resistance ² Constancia química / Résistance chimique	1 B	DIN 68861, Pt. 1 (LGA tested)

² **Exception: acetone, ethyl-butylacetate** / Excepción: Acetona, Etileno-Acetato Butílico / Exception : acétone, ethyl-butylacétate

12 Cleaning / Limpieza / Nettoyage

For cleaning Alpha-Tape®PP edge banding MKT recommends special plastic cleansing agents. Reliability must be tested on a small sample first. Never use alcohol-based or solvent-based cleaners.

Para la limpieza de cintas Alpha-Tape®PP recomendamos el empleo de detergentes específicos. Su aptitud debería ser garantizada por pruebas antes de su uso. No se deben utilizar productos que contengan concentraciones altas de alcohol o disolventes.

Pour le nettoyage des bandes de chants Alpha-Tape®PP, il est recommandé d'utiliser des nettoyeurs synthétiques spéciaux. Des essais devront être effectués au préalable. Les nettoyeurs à base de solvants ou d'alcool ne devront pas être utilisés.

13 Storage conditions / Almacenaje / Conditions de stockage

Stored under proper conditions – on a dry and cool place (<86°F / <30°C) and protected from direct sunlight or dust –, Alpha-Tape®PP edge banding is applicable for a minimum period of one year.

Las cintas Alpha-Tape®PP se pueden almacenar profesionalmente, manteniendo en bajas temperaturas (<86°F / <30°C), en ambientes secos, protegidas de la luz del sol y del polvo, durante al menos 1 año.

Les bandes de chants Alpha-Tape®PP peuvent être stockées au moins un an dans un local approprié : frais <86°F / <30°C) et sec, protégé des rayons UV et des poussières.

Information and advice for application, if orally, in writing or by tests, are to the best of our knowledge, however, are not binding, especially in view of possible third party trade mark rights. Consultation with us does not exempt you from executing your own testing for the planned methods and purposes. Application, use and processing of our products, as well as your manufacturing of final goods following our advice are beyond our control and thus lie solely in your responsibility. The sale of our products is carried out according to our general commercial terms and conditions. Indicated data serve for orientation only. They do not represent any specification nor give warranty for edge banding characteristics.

La presente información y nuestro asesoramiento en cuanto a la técnica de procesamiento por palabra, escrito y mediante pruebas y ensayos se llevan a cabo de buena fe, son considerados como indicaciones sin compromiso, también en relación a posibles derechos de protección de terceros. El asesoramiento no le libera a usted de su propio examen de aptitud en cuanto a sus objetivos e intenciones de procesos. Empleo, utilización y procesamiento de nuestros productos y de los productos fabricados por ustedes mediante nuestro asesoramiento se realizan fuera de nuestras posibilidades de control y por lo tanto quedan exclusivamente en su área de responsabilidad. La venta de nuestros productos se lleva a cabo bajo nuestras Condiciones Generales Comerciales. Los datos indicados se ofrecen como datos aproximados para la orientación. No constituyen especificación o garantía de propiedades.

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WARNING AGAINST PATENT INFRINGEMENT! ¡ ADVERTENCIA CONTRA LA VIOLACION DE LA PATENTE ! AVERTISSEMENT CONTRE LES VIOLATIONS DE BREVET !

Alpha-Tape zero®PP edge banding is intended for use outside of Germany only. Delivery of Alpha-Tape zero®PP edge banding and of products provided with Alpha-Tape zero®PP edge banding to Germany is not permitted. The company Moderne Kunststoff-Technik | Gebrüder Eschbach GmbH hereby declares that it does not agree with the delivery of Alpha-Tape zero®PP edge banding or to products provided with Alpha-Tape zero®PP edge banding to Germany.

Las cintas de bande Alpha-Tape zero® PP estan destinados exclusivamente para su utilización fuera de Alemania. El suministro de cintas de bande Alpha-Tape zero® PP y productos que contienen cintas de bande Alpha-Tape zero® PP a Alemania no esta permitido. Por la presente, la Firma Moderne Kunststoff-Technik | Gebrüder Eschbach GmbH declara que no consiente suministros a Alemania de ninguna forma.

Les bandes de chant Alpha-Tape zéro® PP sont destinées exclusivement à l'usage hors d'Allemagne. La livraison de bandes de chant Alpha-Tape zéro® PP et de produits intégrant des bandes de chant Alpha-Tape zéro® PP vers l'Allemagne est interdite. Par la présente, la société « Moderne Kunststofftechnik | Gebrüder Eschbach GmbH » déclare refuser son agrément à la livraison vers l'Allemagne de bandes de chant Alpha-Tape zéro® PP ou de produits ennoblis avec les bandes de chant Alpha-Tape zéro® PP.



Alpha-Tape zero®PP

Edge banding. Cintas de borde. Chants thermoplastique.

EN

Technical data sheet

ES

Ficha técnica

FR

Fiche technique

Alpha-Tape zero®PP

1 Alpha-Tape zero®PP – General / Información General / Généralités

Alpha-Tape zero®PP edge banding is a thermoplastic edging developed for the decorative finishing of panels. It has a protective as well as a design function. The edge banding is produced from polypropylene and completely imbued.

Las cintas Alpha-Tape zero®PP constituyen cintas termoplásticas para el recubrimiento decorativo de superficies estrechas de materiales de trabajo de madera y adoptan una función de protección y diseño. Cintas de borde se fabrican de Polipropileno y están completamente teñidas.

Bandes de chants Alpha-Tape zero®PP sont des chants thermoplastiques pour le recouvrement décoratif des chants des panneaux et assurent une fonction de protection et de design. Les bandes de chants sont fabriquées en polypropylène et sont teintées dans la masse sur toute la surface.

2 Edge properties / Propiedades bordes / Propriétés des chants

The back side of Alpha-Tape zero®PP is provided with a hard, co-extruded functional layer. This layer can directly be melted with all current "zero joint processing methods". These include the following methods: diode-laser, Hot-Air- and NIR (Near-Infra-Red) technology. The Alpha-Tape zero®PP edging bonds very well to the following workpieces: chipboard, MDF-boards and PP-honeycomb boards. If you have further questions regarding carrier material please feel free to contact our technical department for application and processing questions.

El dorso de Alpha-Tape zero®PP está equipada con una capa funcional, duro y coextrusionada, la cual se tiene que aplicar con un procedimiento, de uso comercial, sin juntas. Abarca los procedimientos: Laser diodo y tecnologías Hot-Air y NIR (Near-Infrared-Radiation). La cinta Alpha-Tape zero®PP se fusiona muy bien con los siguientes materiales: Madera aglomerada, DM y placas de panales de plástico PP. Para más preguntas sobre materiales portadores rogamos contacten nuestro Departamento de Técnica de Aplicaciones.

La face arrière du chant Alpha-Tape zéro®PP est pourvue d'une couche fonctionnelle dur et co-extrudée. Laquelle est à coller avec le procédé usuel zéro joint. Pour ceci, nous avons les procédés suivants : Diode ou laser, Air chaud et NIR (Near-Infrared-Radiation). Le chant Alpha-Tape zéro®PP se soude très bien avec les pièces suivantes : Panneaux d'agglomérés, panneaux MDF et nids d'abeille en PP. Si vous avez des questions concernant les supports, veuillez contacter SVP notre service technique

3 Delivery program / Gama de Suministro / Gamme de produits

Design / Diseño / Design

UL plain colors, coated / Unicolor, barnizado / Décors unis laqués

HR decors, coated / Decorado, barnizado / Décors laqués

ME Metal Effect, coated / Metal Effect, barnizado / laqués

VT-TDB.013.1 Technical Data sheet Alpha-Tape zero®PP EN-ES-FR

Autor tk Revision 0 03.2020

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Technical data sheet

Ficha técnica

Fiche technique

Profil type / Typo profil / Type de profil

Alpha-Tape zero®PP

KB edge banding / Cinta de borde
Chants thermoplastique

SR jumbo roll (for slitting) / Rollo matrix (para perforar)
Rouleau géant (pour séparer)

Width
Anchura
Largeur

0.47 – 2.36 in
2.36 – 4.13 in

12.0 – 60.0 mm
60.0 – 105.0 mm

– 15.95 in
– 405.0 mm

Thickness
Grueso de pared
Épaisseur

0.02 – 0.13 in¹
0.02 – 0.08 in¹

0.40 – 3.20 mm¹
0.40 – 2.00 mm¹

0.02 – 0.13 in¹
0.40 – 3.20 mm¹

¹ incl. functional layer / incl. Capa de función / incl. couche fonctionnelle

4 Tolerance / Tolerancias / Tolérances–

Thickness / Grueso de pared / Épaisseur

	Lower tolerance Tolerancia inferior Tolérance mini	Upper tolerance Tolerancia superior Tolérance maxi
0.028 – 0.031 in	- 0.002 in	+ 0.002 in
0.035 – 0.039 in	- 0.006 in	+ 0.004 in
0.043 – 0.063 in	- 0.008 in	+ 0.004 in
0.067 – 0.079 in	- 0.009 in	+ 0.002 in
0.083 – 0.126 in	- 0.012 in	+ 0.002 in
0.70 – 0.80 mm	- 0.05 mm	+ 0.05 mm
0.90 – 1.00 mm	- 0.15 mm	+ 0.10 mm
1.10 – 1.60 mm	- 0.20 mm	+ 0.10 mm
1.70 – 2.00 mm	- 0.25 mm	+ 0.05 mm
2.10 – 3.20 mm	- 0.30 mm	+ 0.05 mm

Width / Anchura / Largeur

	Lower tolerance Tolerancia inferior Tolérance mini	Upper tolerance Tolerancia superior Tolérance maxi
0.47 – 15.94 in	- 0.008 in	+ 0.019 in
12.0 – 405.0 mm	- 0.20 mm	+ 0.50 mm

Thickness of the functional layer

Grueso de la capa de función / Couche fonctionnelle épaisseur

0.008 in

0.20 mm

Tolerance of the functional layer

Tolerancias de la capa de función / Couche fonctionnelle tolérance

+0.004/-0.002 in**+0.10/-0.05 mm**

5 Level parallelism / Paralelismo de plano / Niveau de parallélisme

All available widths / Todos los anchos disponibles / Toutes largeurs disponibles

< 0.10 in

< 0.10 mm

6 Pre-tension / Pre-tensión / Précontrainte

Width < 2.362 in (<60 mm) / Largeur / Anchura

0.00 – 0.014 in

0.00 – 0.35 mm

Width ≥ 2.362 in (≥60 mm) / Largeur / Anchura

> 0.004 in

> 0.10 mm

7 Longitudinal deformation / Labeado en longitud / Tension longitudinale

All available widths and lengths / Todos los anchos y longitudes disponibles

Valable pour toutes largeurs et épaisseurs disponibles

< 0.12 in / 39.37 in

< 3.0 mm / 1,000.0 mm

Technical data sheet

Ficha técnica

Fiche technique

8 Color / Color / Couleur

Alpha-Tape zero®PP <i>UL coated / barnizado / laqué</i>	L-value Valor-L L-valeur	C-value Valor-C L-valeur	ISO QC ISO QC ISO QC	Tolerance Tolerancias Tolérances
White colors / Colores Blancos / Couleurs clair	> 90	< 5	dE cmc	0.5
Medium colors / Colores Mediano / Couleurs moyenne	70 – 90	< 60	dE cmc	0.8
Dark colors / Colores Oscuros / Couleurs foncée	30 – 70	< 40	dE cmc	1.5

9 Gloss ² / Área de brillo / Brillance

Alpha-Tape zero®PP <i>UL coated / barnizado / laqué</i> <i>HR decors / decorado / décors</i> <i>ME Metal Effect / Metal Effect / Metal Effect</i>	Gloss scale Unidad de grado de brillo Degré de brillance	Tolerance Tolerancias Tolérances
	5° – 30° 31° – 70°	- 2 / +5 - 5 / +5

² Measuring angle 60° / Angulo de medición 60° / Angle de mesure 60°

10 Processing on CNC machine center / Procesamiento en Centros de Trabajo CNC

Mise en oeuvre sur les centres d'usinage CNC

In order to find the suitable Alpha-Tape zero® PP edging for your required radii application, please contact our technical department for application and processing questions. PP-edging is highly suitable for radii due to a extremely low stress whitening level. We are looking forward assisting you with the optimization of your machine settings/parameters.

Si desean emplear nuestras cintas Alpha-Tape zero® PP en un equipo CNC, tienen nuestro Departamento de Técnica de Aplicaciones a su entera disposición. Para usos con radios muy estrechos, los PP son especialmente recomendados ya que el material no muestra apenas tendencia a la rotura blanca.

Afin de trouver les chants Alpha-Tape zéro® PP adéquats pour le passage de vos rayons, veuillez contacter SVP notre service technique. Ce dernier sera présent pour vous conseiller. Pour des exigences de rayons étroits, les chants PP sont particulièrement adéquats, car le phénomène de blanchiment sera rare. Nous vous aiderons à trouver les chants adéquats ainsi que les meilleurs réglages/paramètres pour vos plaqueuses.

11 Properties / Propiedades / Propriétés

Alpha-Tape zero®PP	Value Valor Valeur	Standard for testing Norma de comprobación Norme de contrôle
Fastness to light / Resistencia a la luz / Résistance a'la lumière	7-8	ISO 4892-2
Softening point (Vicat A50) Punto de ablandamiento / Point de ramollissement	> 248°F > 120°C	ISO 306
Shrinkage / Retractilado / Retrait	< 0,5%	MKT Standard / Norma MKT / Norme MKT
Hardness (Shore D) / Dureza / Dureté	~ 75	DIN ISO 7619-1
Scratch resistance (Erichsen Test 318 No. 1) Resistencia a los rasguños y rayados / Résistance aux éraflures	4-6 N	MKT Standard / Norma MKT / Norme MKT
Chemical resistance ³ Constancia química / Résistance chimique	1 B	DIN 68861, Pt. 1 (LGA tested)

³ Exception: acetone, ethyl-butylacetate / Excepción: Acetona, Etileno-Acetato Butílico / Exception : acétone, ethyl-butylacétat

Technical data sheet

Ficha técnica

Fiche technique

12 Energy parameter / Parámetros energéticos / Paramètres d'énergie

Alpha-Tape zero®PP	Value Valor Valeur	Dimension Dimensión Dimension	Comment Observació Commentaire
Processing with diode-laser 940-1040 nm Procesamiento con Laser diodo / Usinage avec machine diode White and light colors Blanco y colores claros / Blanc et couleurs claires Black and dark colors Colores negros y oscuros / Noir et couleurs foncées	22	j/cm ²	
Processing with HOT-AIR Procesamiento con Hot-Air / Usinage avec Air chaud (Hot Air) Processing with NEAR-INFRARED-RADIATION Procesamiento con NIR / Usinage avec NIR	14	j/cm ²	
For parameter please contact our application technology Rogamos obtengan los parámetros en nuestro Departamento De Técnica de Aplicaciones SVP renseignez-vous au sujet de ces paramètres auprès de service technique			

13 Cleaning / Limpieza / Nettoyage

For cleaning Alpha-Tape zero®PP edge banding MKT recommends special plastic cleansing agents. Reliability must be tested on a small sample first. Never use alcohol-based or solvent-based cleaners.

Para la limpieza de cintas Alpha-Tape zero®PP recomendamos el empleo de detergentes específicos. Su aptitud debería ser garantizada por pruebas antes de su uso. No se deben utilizar productos que contengan concentraciones altas de alcohol o disolventes.

Pour le nettoyage des bandes de chants Alpha-Tape zero®PP, il est recommandé d'utiliser des nettoyeurs synthétiques spéciaux. Des essais devront être effectués au préalable. Les nettoyeurs à base de solvants ou d'alcool ne devront pas être utilisés.

14 Storage conditions / Almacenaje / Conditions de stockage

Stored under proper conditions – on a dry and cool place (<86°F / <30°C) and protected from direct sunlight or dust –, Alpha-Tape zero®PP edge banding is applicable for a minimum period of one year.

Las cintas Alpha-Tape zero®PP se pueden almacenar profesionalmente, manteniendo en bajas temperaturas (<86°F / <30°C), en ambientes secos, protegidas de la luz del sol y del polvo, durante al menos 1 año.

Les bandes de chants Alpha-Tape zero®PP peuvent être stockées au moins un an dans un local approprié : frais <86°F / <30°C) et sec, protégé des rayons UV et des poussières.

Information and advice for application, if orally, in writing or by tests, are to the best of our knowledge, however, are not binding, especially in view of possible third party trade mark rights. Consultation with us does not exempt you from executing your own testing for the planned methods and purposes. Application, use and processing of our products, as well as your manufacturing of final goods following our advice are beyond our control and thus lie solely in your responsibility. The sale of our products is carried out according to our general commercial terms and conditions. Indicated data serve for orientation only. They do not represent any specification nor give warranty for edge banding characteristics.

La presente información y nuestro asesoramiento en cuanto a la técnica de procesamiento por palabra, escrito y mediante pruebas y ensayos se llevan a cabo de buena fe, son considerados como indicaciones sin compromiso, también en relación a posibles derechos de protección de terceros. El asesoramiento no le libera a usted de su propio examen de aptitud en cuanto a sus objetivos e intenciones de procesos. Empleo, utilización y procesamiento de nuestros productos y de los productos fabricados por ustedes mediante nuestro asesoramiento se realizan fuera de nuestras posibilidades de control y por lo tanto quedan exclusivamente en su área de responsabilidad. La venta de nuestros productos se lleva a cabo bajo nuestras Condiciones Generales Comerciales. Los datos indicados se ofrecen como datos aproximados para la orientación. No constituyen especificación o garantía de propiedades.

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EN **Technical data sheet**
ES **Ficha técnica**
FR **Fiche technique**

1 Alpha-Tape® excellent – General / Información General / Généralités

Alpha-Tape® excellent edge banding is a thermoplastic edging developed for the decorative finishing of panels. It has a protective as well as a design function.

- Alpha-Tape® *high gloss* is a high gloss coated thermoplastic edging with a magnificent scratch resistance
- Alpha-Tape® *excellent gloss* offers an absolute mirror gloss finish with a superb scratch resistance
- Alpha-Tape® *excellent matt* impresses by an extreme low gloss level, with a superb scratch resistance and with anti-fingerprint-effect
- Alpha-Tape® *excellent effect* combines both effects perfectly in one particular edging (matt-gloss-effect)

Las cintas Alpha-Tape® excellent constituyen cintas termoplásticas para el recubrimiento decorativo de superficies estrechas de materiales de trabajo de madera y adoptan una función de protección y diseño.

- Alpha-Tape® *high gloss* – son cintas barnizadas en brillo intenso con una excelente resistencia a los rasguños y rayados.
- Alpha-Tape® *excellent gloss* – ofrecen una superficie de absoluto brillo intenso de espejo con una sobresaliente resistencia a los rasguños y rayados.
- Alpha-Tape® *excellent mate* – convencen por su grado de brillo extremadamente bajo, tacto fabuloso sin efecto “fingerprint” y una resistencia superior a los rasguños y rayados.
- Alpha-Tape® *excellent effect* – combinan ambos efectos perfectamente en una cinta (mate/brillo-efecto).

Alpha-Tape® excellent sont des chants thermoplastiques pour le recouvrement décoratif des chants des panneaux et assurent une fonction de protection et de design.

- Le chant Alpha-Tape® *high gloss* montre traditionnellement une légère peau d'orange et offre un degré gloss plus faible
- Le chant Alpha-Tape® *excellent gloss* offre une surface très brillante « effet miroir », avec une excellente résistance à la rayure
- Le chant Alpha-Tape® *excellent mat* se distingue par son degré gloss extrêmement faible, dont l'effet est particulier
- Le chant Alpha-Tape® *excellent effet* combine les 2 effets en un même chant (mat/brillant)

2 Adhesion properties / Propiedades adhesivas / Propriétés d'adhésion

Please refer to the technical data sheets of Alpha-Tape® ABS, PP or Alpha-Tape zero® PP for detailed information.

Encontrarán información detallada al respecto en las hojas de datos relacionadas con las Alpha-Tape® ABS, PP y Alpha-Tape zero® PP.

Vous trouverez des informations détaillées dans les fiches techniques Alpha-Tape® ABS, PP et Alpha-Tape zéro® PP.

3 Delivery program / Gama de Suministro / Gamme de produits

Design / Diseño / Design

HG-UL *high gloss*
EG-UL *excellent gloss*
EM-UL *excellent matt*
EE-UL *excellent effect*

Plain colors / Unicolor / Décors unis

HG-HR *high gloss*
EG-HR *excellent gloss*
EM-HR *excellent matt*
EE-HR *excellent effect*

Decors / Decorado / Décors

EG-ME *excellent gloss*
EM-ME *excellent matt*
EE-ME *excellent effect*

Metal Effect / Metal Effect / Metal Effect

Available for Alpha-Tape® ABS, PP and Alpha-Tape zero® PP.

Disponible para Alpha-Tape® ABS, PP y Alpha-Tape zero® PP.

Disponible pour Alpha-Tape® ABS, PP et Alpha-Tape zéro® PP.

Technical data sheet

Ficha técnica

Fiche technique

Profil type / Typo profil / Type de profil

Alpha-Tape® excellent	Width Anchura Largeur	Thickness Grueso de pared Épaisseur
KB edge banding / Cinta de borde <i>Chants thermoplastique</i>	0.47 – 2.36 in 2.36 – 4.13 in 12.0 – 60.0 mm 60.0 – 105.0 mm	0.024 – 0.13 in 0.024 – 0.08 in 0.60 – 3.20 mm 0.60 – 2.00 mm
SR jumbo roll (for slitting) / Rollo matrix (para perforar) <i>Rouleau géant (pour séparer)</i>	– 15.95 in – 405.0 mm	0.024 – 0.13 in 0.60 – 3.20 mm

4 Tolerance / Tolerancias / Tolérances

5 Level parallelism / Paralelismo de plano / Niveau de parallélisme

6 Pre-tension / Pre-tensión / Précontrainte

7 Longitudinal deformation / Labeado en longitud / Tension longitudinale

8 Color / Color / Couleur

Please refer to the technical data sheets of Alpha-Tape® ABS, PP or Alpha-Tape zero® PP for detailed information.

Encontrarán información detallada al respecto en las hojas de datos relacionadas con las Alpha-Tape® ABS, PP y Alpha-Tape zero® PP.

Vous trouverez des informations détaillées dans les fiches techniques Alpha-Tape® ABS, PP et Alpha-Tape zéro® PP.

9 Gloss ¹ / Área de brillo / Brillance

Alpha-Tape® excellent	Gloss scale Unidad de grado de brillo Degré de brillance	Tolerance Tolerancias Tolérances
HG-UL, HG-HR <i>high gloss</i>	95°	- 5 / +5
EG-UL, EG-HR, EG-ME <i>excellent gloss</i>	95°	- 5 / +5
EM-UL, EM-HR, EM-ME <i>excellent matt</i>	3°	- 2 / +3
EE-UL, EE-HR, EE-ME <i>excellent effect</i>	—	— ²

¹ Measuring angle 60° / Angulo de medición 60° / Angle de mesure 60°

² EE: no fixing of gloss level possible / EE: no es posible una determinación del grado del brillo / EE: pas de détermination du degré de brillance possible

10 Processing on CNC machine center / Procesamiento en Centros de Trabajo CNC

Mise en oeuvre sur les centres d'usinage CNC

In order to find the suitable Alpha-Tape® edging for your required radii application, please contact our technical department for application and processing questions. PP-edging is highly suitable for radii due to an extremely low stress whitening level. We are looking forward assisting you with the optimization of your machine settings/parameters.

Si desean emplear nuestras cintas Alpha-Tape® en un equipo CNC, tienen nuestro Departamento de Técnica de Aplicaciones a su entera disposición. Para usos con radios muy estrechos, los PP son especialmente recomendados ya que el material no muestra apenas tendencia a la rotura blanca.

Afin de trouver les chants Alpha-Tape® adéquats pour le passage de vos rayons, veuillez contacter SVP notre service technique. Ce dernier sera présent pour vous conseiller. Pour des exigences de rayons étroits, les chants PP sont particulièrement adéquats, car le phénomène de blanchiment sera rare. Nous vous aiderons à trouver les chants adéquats ainsi que les meilleurs réglages/paramètres pour vos plaqueuses.

VT-TDB.014 Technical Data sheet Alpha-Tape® excellent EN-ES-FR Autor tk Revision 0 03.2020

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Technical data sheet

Ficha técnica

Fiche technique

11 Propriétés / Caratteristiche / Propiedades

Please refer to the technical data sheets of Alpha-Tape® ABS, PP or Alpha-Tape zero® PP for detailed information.

Encontrarán información detallada al respecto en las hojas de datos relacionadas con las Alpha-Tape® ABS, PP y Alpha-Tape zero® PP.

Vous trouverez des informations détaillées dans les fiches techniques Alpha-Tape® ABS, PP et Alpha-Tape zéro® PP.

Annotation / Anotación / Annotation

Alpha-Tape® flexible: Chemical resistance deviates³

Deploying a highly flexible coating system enables particularly short radii in the field of softforming. The scratch resistance meets the demands of the MKT standard. For Alpha-Tape® flexible edge bandings the chemical resistance deviates under the 1 B standard for coffee, mustard and red wine. In general, however, the mechanical properties and especially the chemical resistance should be tested regarding its desired specific field of application. Our experts in application technique will be happy to advise regarding the requirements and parameters for the processing of Alpha-Tape® flexible edge bandings.

Alpha-Tape® flexible: La consistencia química difiere³

Debido a la utilización de un sistema altamente flexible de barniz, se permiten radios especialmente cerrados en el área de Softforming. La resistencia contra arañazos cumple la normativa MKT. La consistencia química por debajo de 1 B en los sectores café, mostaza y vino tinto difiere para las cintas Alpha-Tape® flexible. Por regla general sería conveniente comprobar la consistencia química para el área de aplicación explícita del cliente. Nuestro Departamento de Técnica de Aplicaciones les asesora con mucho gusto acerca de las condiciones para el procesamiento de cintas Alpha-Tape® flexible.

Alpha-Tape® flexible : Divergence de résistance chimique³

Grâce à l'utilisation de systèmes de laques de haute souplesse, des rayons particulièrement serrés sont possibles dans le domaine du Softforming. La résistance à la rayure respecte la norme MKT. La résistance aux produits chimiques au point 1 B n'est pas applicable pour le café, moutarde et vin rouge pour les chants Alpha-Tape® flexible. Généralement, la résistance chimique pour les utilisations spécifiques des clients doit être testée et ciblée. Notre Service Application Technique peut volontiers vous conseiller sur les exigences concernant l'usinage des chants Alpha-Tape® flexible.

³ Technical data sheets Alpha-Tape® ABS+PP, paragraph 11 / Ficha técnica Alpha-Tape® ABS+PP, artículo 11 / Fiche technique bandes des chant Alpha-Tape® ABS+PP, paragraphe 11

12 Protective foil / Lámina protectora / Film de protection

Our Alpha-Tape® excellent gloss and high gloss edge banding is generally protected by a PE-protection foil. Alpha-Tape® excellent matt and excellent effect is generally unprotected by a PE-protection foil. If you are in need of a protection foil, please contact our technical department for application and processing questions. If possible, we will recommend a protective foil for your individual needs during processing.

We strongly recommend to remove the protection foil immediately after processing!

Nuestras cintas Alpha-Tape® excellent gloss y high gloss se suministran por regla general con un film de protección PE. Las cintas Alpha-Tape® excellent mate y excellent effect, se suministran básicamente sin film de protección. En caso que necesiten un film de protección para esta variante, rogamos contacten nuestro Departamento de Técnica de Aplicaciones. Nuestros técnicos les recomendarán, en lo posible, un tipo de film de protección óptimo para su procesamiento. Recomendamos quitar el film de protección inmediatamente después de su procesamiento!

Nos chants Alpha-tape® excellent gloss et high-gloss sont généralement livrés avec un film de protection poléthylène. Alpha-Tape® excellent mat et excellent effet sont généralement livrés sans film de protection. Si vous avez cependant besoin d'un film de protection pour ces versions, veuillez communiquer avec notre Service Application Technique. Il s'agit, dans la mesure du possible, de proposer une variante de film de protection optimale pour votre process d'usinage. Nous vous recommandons de retirer le film de protection immédiatement après l'usinage !

Alpha-Tape® excellent

Type of foil

Tipo de lámina protectora

Type de film

HG-UL , HG-HR *high gloss*
EG-UL , EG-HR , EG-ME *excellent gloss*
EM-UL , EM-HR , EM-ME *excellent matt*
EE-UL , EE-HR , EE-ME *excellent effect*

transparent+print / transparente+impresión / transparent+surcharge
transparent+print / transparente+impresión / transparent+surcharge
without foil / sin / sans
without foil / sin / sans

Technical data sheet

Ficha técnica

Fiche technique

13 Cleaning / Limpieza / Nettoyage

14 Storage conditions / Almacenaje / Conditions de stockage

Please refer to the technical data sheets of Alpha-Tape®ABS, PP or Alpha-Tape zero® PP for detailed information.

Encontrarán información detallada al respecto en las hojas de datos relacionadas con las Alpha-Tape®ABS, PP y Alpha-Tape zero® PP.

Vous trouverez des informations détaillées dans les fiches techniques Alpha-Tape®ABS, PP et Alpha-Tape zéro® PP.

Information and advice for application, if orally, in writing or by tests, are to the best of our knowledge, however, are not binding, especially in view of possible third party trade mark rights. Consultation with us does not exempt you from executing your own testing for the planned methods and purposes. Application, use and processing of our products, as well as your manufacturing of final goods following our advice are beyond our control and thus lie solely in your responsibility. The sale of our products is carried out according to our general commercial terms and conditions. Indicated data serve for orientation only. They do not represent any specification nor give warranty for edge banding characteristics.

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EN **Technical data sheet**
ES **Ficha técnica**
FR **Fiche technique**

1 Alpha-Tape® soft matt 3 / gloss 90 – General / Información General / Généralités

Alpha-Tape® soft matt / gloss 90 edge banding is a thermoplastic edging developed for the decorative finishing of panels. It has a protective as well as a design function.

- Alpha-Tape® *excellent matt* impresses by an very low gloss, with a good scratch resistance and with an anti-fingerprint-effect
- Alpha-Tape® *gloss90* is a high gloss coated thermoplastic edging with a good scratch resistance and a very light surfaces structure

Las cintas de borde Alpha Tape® soft mate 3/ gloss 90 constituyen cintas termoplásticas para el recubrimiento decorativo de superficies estrechas de materiales de trabajo de madera y adoptan una función de protección y diseño.

- Las cintas de borde Alpha-Tape® *soft mate 3* convencer con su grado bajo de brillo, con una buena resistencia contra arañazos y efecto anti huellas dactilares.
- Las cintas de borde Alpha-Tape® *gloss 90* constituyen bordes barnizados de alto brillo con una buena resistencia contra arañazos y una estructura ligera de superficie.

Les bandes de chant Alpha-Tape® soft mat 3 / gloss 90 sont des chants thermoplastiques pour le revêtement de surface étroit décoratif des matériaux dérivés du bois et assume une fonction de protection et de design.

- Les chants Alpha-Tape® *soft mat 3* se distinguent par leur très faible degré de brillance, une bonne résistance à la rayure et avec un effet anti-trace de doigt.
- Les chants Alpha-Tape® *gloss 90* sont des chants laqués haute brillance avec une bonne résistance à la rayure et un é de surface plus éclatant.

2 Adhesion properties / Propiedades adhesivas / Propriétés d'adhésion

Please refer to the technical data sheets of Alpha-Tape® ABS, PP or Alpha-Tape zero® PP for detailed information.

Encontrarán información detallada al respecto en las hojas de datos relacionadas con las Alpha-Tape® ABS, PP y Alpha-Tape zero® PP.

Vous trouverez des informations détaillées dans les fiches techniques Alpha-Tape® ABS, PP et Alpha-Tape zéro® PP.

3 Delivery program / Gama de Suministro / Gamme de produits

Design / Diseño / Design

SM-UL *soft matt 3*
GL-UL *gloss 90*

Plain colors / Unicolor / Décors unis

SM-HR *soft matt 3*
GL-HR *gloss 90*

Decors / Decorado / Décors

SM-ME *soft matt 3*
GL-ME *gloss 90*

Metal Effect / Metal Effect / Metal Effect

Available for Alpha-Tape® ABS, PP and Alpha-Tape zero® PP.

Disponible para Alpha-Tape® ABS, PP y Alpha-Tape zero® PP.

Disponible pour Alpha-Tape® ABS, PP et Alpha-Tape zéro® PP.

Technical data sheet

Ficha técnica

Fiche technique

Profil type / Typo profil / Type de profil

Alpha-Tape® soft matt 3
Alpha-Tape® gloss 90**KB edge banding** / Cinta de borde
Chants thermoplastique**SR jumbo roll (for slitting)** / Rollo matrix (para perforar)
Rouleau géant (pour séparer)Width
Anchura
Largeur**0.47 – 2.36 in**
2.36 – 4.13 in12.0 – 60.0 mm
60.0 – 105.0 mm**– 15.95 in**
– 405.0 mmThickness
Grueso de pared
Épaisseur**0.02 – 0.13 in**
0.02 – 0.08 in0.40 – 3.20 mm
0.40 – 2.00 mm**0.02 – 0.13 in**
0.40 – 3.20 mm**4 Tolerance** / Tolerancias / Tolérances**5 Level parallelism** / Paralelismo de plano / Niveau de parallélisme**6 Pre-tension** / Pre-tensión / Précontrainte**7 Longitudinal deformation** / Labeado en longitud / Tension longitudinale**8 Color** / Color / Couleur

Please refer to the technical data sheets of Alpha-Tape® ABS, PP or Alpha-Tape zero® PP for detailed information.

Encontrarán información detallada al respecto en las hojas de datos relacionadas con las Alpha-Tape® ABS, PP y Alpha-Tape zero® PP.

Vous trouverez des informations détaillées dans les fiches techniques Alpha-Tape® ABS, PP et Alpha-Tape zéro® PP.

9 Gloss¹ / Área de brillo / BrillanceAlpha-Tape® soft matt 3
Alpha-Tape® gloss 90Gloss scale
Unidad de grado de brillo
Degré de brillanceTolerance
Tolerancias
Tolérances**SM-UL, SM-HR, SM-ME soft matt 3**
GL-UL, GL-HR, GL-ME gloss 90**3°**
90°**- 2 / +3**
- 5 / +5¹ Measuring angle 60° / Angulo de medición 60° / Angle de mesure 60°**10 Processing on CNC machine center** / Procesamiento en Centros de Trabajo CNC

Mise en oeuvre sur les centres d'usinage CNC

In order to find the suitable Alpha-Tape® edging for your required radii application, please contact our technical department for application and processing questions. PP-edging is highly suitable for radii due to an extremely low stress whitening level. We are looking forward assisting you with the optimization of your machine settings/parameters.

Si desean emplear nuestras cintas Alpha-Tape® en un equipo CNC, tienen nuestro Departamento de Técnica de Aplicaciones a su entera disposición. Para usos con radios muy estrechos, los PP son especialmente recomendados ya que el material no muestra apenas tendencia a la rotura blanca.

Afin de trouver les chants Alpha-Tape® adéquats pour le passage de vos rayons, veuillez contacter SVP notre service technique. Ce dernier sera présent pour vous conseiller. Pour des exigences de rayons étroits, les chants PP sont particulièrement adéquats, car le phénomène de blanchiment sera rare. Nous vous aiderons à trouver les chants adéquats ainsi que les meilleurs réglages/paramètres pour vos plaqueuses.

VT-TDB.015 Technical Data sheet Alpha-Tape® soft matt3 / gloss 90 EN-E

Autor tk Revision 0 03.2020

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Moderne Kunststoff-Technik | Gebrüder Eschbach GmbH

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Technical data sheet

Ficha técnica

Fiche technique

11 Properties / Propiedades / Propriétés

Alpha-Tape® soft matt 3 Alpha-Tape® gloss 90	Value Valor Valeur		Standard for testing Norma de comprobación Norme de contrôle
	ABS	PP	
Fastness to light / Resistencia a la luz / Résistance à la lumière	> 6	7-8	ISO 4892-2
Softening point (ABS: Vicat B50, PP: Vicat A50) Punto de ablandamiento / Point de ramollissement	~ 203°F ~ 95°C	> 248°F > 120°C	ISO 306
Shrinkage / Retractilado / Retrait	< 1,0%	< 0,5%	MKT Standard / Norma MKT / Norme MKT
Hardness (Shore D) / Dureza / Dureté	~ 73	~ 75	DIN ISO 7619-1
Scratch resistance (Erichsen Test 318 No. 1) Resistencia a los rasguños y rayados / Résistance aux éraflures	4-6 N	4-6 N	MKT Standard / Norma MKT / Norme MKT
Chemical resistance³ Constancia química / Résistance chimique	1 B ³	1 B ³	DIN 68861, Pt. 1 (LGA tested)

3 Annotation / Anotación / Annotation

Chemical resistance deviates

Alpha-Tape® soft matt 3 / gloss 90 edge banding is coated with a special coating system. Hence the chemical resistance deviates under the 1 B standard for coffee, mustard and red wine. In general, however, the mechanical properties and especially the chemical resistance should be tested regarding its desired specific field of application. Our experts in application technique will be happy to advise regarding the requirements and parameters for the processing of Alpha-Tape® flexible edge banding.

La consistencia química difiere:

Debido a la utilización de un sistema de barniz especial, la consistencia química por debajo de 1 B en los sectores café, mostaza y vino tinto difiere para las cintas de borde Alpha-Tape® soft mate 3/ gloss 90. Por regla general sería conveniente comprobar la consistencia química para el área de aplicación explícita del cliente. Nuestro Departamento de Técnica de Aplicaciones les asesora con mucho gusto acerca de las condiciones para el procesamiento de cintas de borde Alpha-Tape® soft mate 3/ gloss 90.

Restrictions à la résistance chimique :

Avec l'utilisation de systèmes de laques spéciales, la résistance aux produits chimiques au point 1 B n'est pas applicable pour le café, moutarde et vin rouge pour les chants Alpha-Tape® soft mat 3 / gloss 90. Généralement, la résistance chimique pour les utilisations spécifiques des clients doit être testée et ciblée. Notre Service Application Technique peut volontiers vous conseiller sur les exigences pour l'usinage des chants Alpha-Tape® soft mat 3 / gloss 90.

Technical data sheet

Ficha técnica

Fiche technique

12 Protective foil / Lámina protectora / Film de protection

Our Alpha-Tape® soft matt 3 or Alpha-Tape® gloss 90 is generally unprotected by a PE-protection foil. If you are in need of a protection foil, please contact our technical department for application and processing questions. If possible, we will recommend a protective foil for your individual needs during processing.

Nuestras superficies Alpha-Tape® soft mate 3 y Alpha-Tape® gloss 90 se suministran por regla general sin film de protección PE. En caso que necesiten un film de protección para esta variante, rogamos contacten nuestro Departamento de Técnica de Aplicaciones. Nuestros técnicos les recomendarán, en lo posible, un tipo de film de protección óptimo para su procesamiento.

Nos chants Alpha-Tape® soft mat 3 et Alpha-Tape® gloss 90 sont généralement livrés sans film de protection polyéthylène. Si vous avez cependant besoin d'un film de protection pour ces versions, veuillez communiquer avec notre Service Application Technique. Il s'agit, dans la mesure du possible, de proposer une variante de film de protection optimale pour votre process d'usinage.

Alpha-Tape® soft matt 3
Alpha-Tape® gloss 90**Type of foil**
Tipo de lámina protectora
Type de film**SM-UL , SM-HR soft matt 3**
GL90-UL , GL90-HR gloss 90**without foil** / sin / sans
without foil / sin / sans**13** Cleaning / Limpieza / Nettoyage**14** Storage conditions / Almacenaje / Conditions de stockage

Please refer to the technical data sheets of Alpha-Tape® ABS, PP or Alpha-Tape zero® PP for detailed information.

Encontrarán información detallada al respecto en las hojas de datos relacionadas con las Alpha-Tape® ABS, PP y Alpha-Tape zero® PP.

Vous trouverez des informations détaillées dans les fiches techniques Alpha-Tape® ABS, PP et Alpha-Tape zéro® PP.

Information and advice for application, if orally, in writing or by tests, are to the best of our knowledge, however, are not binding, especially in view of possible third party trade mark rights. Consultation with us does not exempt you from executing your own testing for the planned methods and purposes. Application, use and processing of our products, as well as your manufacturing of final goods following our advice are beyond our control and thus lie solely in your responsibility. The sale of our products is carried out according to our general commercial terms and conditions. Indicated data serve for orientation only. They do not represent any specification nor give warranty for edge banding characteristics.

La presente información y nuestro asesoramiento en cuanto a la técnica de procesamiento por palabra, escrito y mediante pruebas y ensayos se llevan a cabo de buena fe, son considerados como indicaciones sin compromiso, también en relación a posibles derechos de protección de terceros. El asesoramiento no le libera a usted de su propio examen de aptitud en cuanto a sus objetivos e intenciones de procesos. Empleo, utilización y procesamiento de nuestros productos y de los productos fabricados por ustedes mediante nuestro asesoramiento se realizan fuera de nuestras posibilidades de control y por lo tanto quedan exclusivamente en su área de responsabilidad. La venta de nuestros productos se lleva a cabo bajo nuestras Condiciones Generales Comerciales. Los datos indicados se ofrecen como datos aproximados para la orientación. No constituyen especificación o garantía de propiedades.

Les présentes informations et nos conseils d'application sous forme orale, écrite et par démonstration sont donnés de bonne foi, mais ne sauraient revêtir un caractère contractuel, ce qui vaut également pour d'éventuels droits de protection des tiers. Les conseils prodigués ne vous délivrent pas de l'obligation d'effectuer votre propre test d'aptitude par rapport aux processus et applications envisagés. L'application, l'utilisation et la transformation de nos produits ainsi que des produits que vous avez fabriqués sur la base de notre activité-conseil échappent à nos opportunités de contrôle et se situent donc exclusivement dans votre espace de responsabilité. Nos produits sont distribués en conformité avec nos conditions générales de vente. Les données mentionnées le sont à titre indicatif et ont vocation d'orientation. En aucun cas, elles ne sauraient exprimer une spécification ou garantir des propriétés.

Safety Data Sheet

According to Regulation (EG) 1907/2006 (REACH)



Moderne Kunststoff-Technik

Gebr. Eschbach GmbH

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Date / Revision am: 28.11.2013

Version 3-TS

ALPHA-TAPE® ABS edge banding

Chapter 1: Identification of the substance/mixture and of the company

1.1. Product identifier

Product name: **ALPHA-TAPE® ABS edge banding**

1.2. Relevant identified uses of the substance or mixture and uses advised against: None known

Application: Thermo-plastic edge banding for the furniture industry

1.3. Details of the supplier of the safety data sheet

Company: MKT Moderne Kunststoff-Technik
Gebrüder Eschbach GmbH
Herrenhöfer Landstraße 2
D-99885 Ohrdruf
Phone: +49(0)3624 / 36923
Fax: +49(0)3624 / 313708
email: info@mkt-gmbh.com

Specialist contact: Mr. Heiko Ilg Phone: +49(0)3624/3692-708
h.ilg@mkt-gmbh.com

1.4. Emergency number

Emergency advice: Phone: +49(0)3624 / 36923 (Mon-Fri 8am to 4pm)

Chapter 2: Possible risks

2.1. Classification of the substance or mixture:

None

This product is pursuant to the criteria of the CLP regulation (EG) No. 1272/2008 and the directives 67/548/EEC and 1999/45/EEC respectively classified as non-hazardous.

2.2. Identification elements:

None

2.3. Other risks:

See section 7.1

Chapter 3: Composition/Information on components

3.1. Substances:

Not applicable. This product is defined in terms of the REACH regulation (EG) 1908/2006 as an article.

3.2. Mixtures:

Not applicable. This product is defined in terms of the REACH regulation (EG) 1908/2006 as an article.

Chemical characteristics: Extruded ABS profile CAS No. 9003-56-9

Hazardous ingredients: not subject to declaration

Safety Data Sheet

According to Regulation (EG) 1907/2006 (REACH)



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ALPHA-TAPE® ABS edge banding

Chapter 4: First-aid measures

4.1. Description of first-aid measures

After inhalation:	No particular measures required After inhaling decomposition products: Rest, fresh air, medical aid
After skin contact:	No particular measures required After contact with molten material cool rapidly under cold water
After swallowing:	See a doctor (possible mechanical blocking in gastrointestinal tract)
After eye contact:	No particular measures required After eye contact with chipping products (dust) flush eyes with plenty of water and consult a doctor

4.2. Most important symptoms and effects, both acute and delayed:

None identified.

4.3. Indication of any medical attention and special treatment:

None

Chapter 5: Fire-fighting measures

5.1. Extinguishing media

Suitable extinguishing media: water, dry chemical powder, carbon dioxide, foam

Unsuitable extinguishing media for safety reasons: None

5.2. Special hazards arising from the substance or mixture

May be released in case of fire: Carbon dioxide (CO₂) and water

Furthermore, in small quantities may occur: Carbon monoxide, soot, styrene, monomers and other flammable gases or vapors

5.3. Instructions for firefighting

Special protective equipment:	In case of fire wear self-contained breathing equipment
Particular risks caused by fire and explosion:	Mechanical crushing and pneumatic conveying of chipped products may form combustible dust. Accumulation of dust and electrostatic charging shall be avoided.
Additional information:	Dispose of fire residues and contaminated extinguishing water in accordance with local regulations

Safety Data Sheet

According to Regulation (EG) 1907/2006 (REACH)



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ALPHA-TAPE® ABS edge banding

Chapter 6: Accidental release measures

- 6.1. Personal precautions, protective equipment and emergency procedures
No measures necessary beyond the scope of general hygiene regulations at work.
- 6.2. Measures for environmental protection
No measures necessary beyond the scope of general regulations for environmental protection.
- 6.3. Methods and material for containment and cleaning up
Measures for cleaning up/taking up: Take up mechanically
- 6.4. Reference to other chapters
Observe general protective measures in chapter nos. 7, 8 and 13.

Chapter 7: Handling and storage

- 7.1. Precautions for safe handling
Handling: In crushing (chipping) observe regulations for dust explosion hazards. Accumulation of dust and electrostatic charge to be avoided.

In extreme overheating the material gaseous decomposition products may be released (cf. Chapter 5 Fire-fighting measures).
Protecting against cuts is recommended
- 7.2. Conditions for safe storage, including any incompatibilities
Storage: Store cool and dry; protect against direct sunlight
Avoid extreme heat and ignition sources (sparks, open flames)
- 7.3. Specific end uses
For more detailed information, please, refer to our technical data sheet.

Chapter 8: Limitation and monitoring of exposure/Personal protective equipment

- 8.1. Control parameters
None
- 8.2. Limitation and monitoring of exposure
Personal protective equipment:
Respiratory protection: In the case of respirable dust: use filter P1 (for solid particles)

Eye protection: In shredding processes wear protective goggles
General: Develop good personal hygiene. Do not eat or leave food in working areas.

Hand protection: Protective gloves according to national regulations

Safety Data Sheet

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ALPHA-TAPE® ABS edge banding

Chapter 9: Physical and chemical properties

9.1. Information on basic physical and chemical properties

Form:	Profile
Color:	Different according to coloration
Smell:	Type specific
Softening temperature:	> 90°C (ISO306)
Ignition temperature:	No data available
Density:	1,06 to 1.2 g/cm ³ (depending on coloration)
Water solubility:	In practice insoluble
Solubility in other solvents:	Soluble in polar solvents

Other physical and chemical data, e.g. pH-value, boiling point, flashpoint and vapor pressure have not been determined, as they are irrelevant for the product.

9.2. Other information

For more information, please, refer to our technical data sheet.

Chapter 10: Stability and reactivity

10.1. Reactivity:

The product is under usual conditions inert.

10.2. Chemical stability:

The product is chemically stable.

10.3. Possibility of hazardous reactions:

When used according to instructions, hazardous reactions are not to be expected.

10.4. Conditions to avoid:

To avoid thermal decomposition do not overheat.
Decomposition occurs at temperatures above 300°C.

10.5. Incompatible materials:

Strong oxidizing agents

10.6. Hazardous decomposition products:

See 5.2.

Chapter 11: Toxicological information

11.1. Information on toxicological effects:

No data available.

When appropriately used and handled according to instructions as per our experience and information the product does not cause any harmful effects on health.

Safety Data Sheet

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ALPHA-TAPE® ABS edge banding

Chapter 12: Environmental information

12.1. Toxicity:

No data available.

In view of its consistency and insolubility of the product in water bioavailability is unlikely.

12.2. Persistence and degradability:

No data available.

12.3. Bioaccumulation potential:

No data available.

In view of its consistency and insolubility of the product in water bioavailability is unlikely.

12.4. Mobility in soil:

No data available.

12.5. Results of PBT and vPvB assessment:

According to the available data criteria for PBT and vPvB assessment respectively are not fulfilled.

12.6. Other adverse effects:

No data available.

Chapter 13: Instructions on disposal

13.1 Waste treatment methods:

Must be disposed of according to local regulation e.g. on a suitable dump or incineration plant.

Non-contaminated material can be recycled.

Waste code: 07 02 13 Plastic waste

Chapter 14: Transport information

14.1. UN number

Not classified as dangerous goods according to transport regulations.

14.2. UN proper shipping name

Not classified as dangerous goods according to transport regulations.

14.3. Transport hazard class

Not classified as dangerous goods according to transport regulations.

14.4. Packing group

Not classified as dangerous goods according to transport regulations.

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14.5. Environmental hazards

Not classified as dangerous goods according to transport regulations.

14.6. Special precautions for user

See chapters 6 to 8.

14.7. Transport in bulk according to Annex II of MARPOL 73/78 and IBC Code:

Not applicable.

Chapter 15: Legislation

15.1. Safety, health and environmental regulations/legislation specific for the substance or mixture:

No applicable EU regulations.

National regulations:

Water hazard class:

Not hazardous to water

(Germany, self-classification)

15.2. Chemical safety assessment:

The product has not been examined in a safety assessment.

Chapter 16: Other information

Amendments to the last version:

Adaptation to regulation (EU) No. 453/2010 in all chapters

The aforementioned information in this safety data sheet is based upon information of our raw materials suppliers and our knowledge and experience to date. The safety data sheet describes the product with regards to safety requirements. The information is in no way to be considered as description of the quality of the merchandise (product specification). It does not represent any assurance of characteristics. Existing laws and regulations as well as possible property rights must be observed by the recipient and user of our products on its own responsibility.

End of the safety data sheet.

Safety Data Sheet

According to Regulation (EG) 1907/2006 (REACH)



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Version 3-TS

ALPHA-TAPE® PP edge banding

Chapter 1: Identification of the substance/mixture and of the company

1.1. Product identifier

Product name: **ALPHA-TAPE® PP edge banding**

1.2. Relevant identified uses of the substance or mixture and uses advised against: None known

Application: Thermo-plastic edge banding for the furniture industry

1.3. Details of the supplier of the safety data sheet

Company: MKT Moderne Kunststoff-Technik
Gebrüder Eschbach GmbH
Herrenhöfer Landstraße 2
D-99885 Ohrdruf
Phone: +49(0)3624 / 36923
Fax: +49(0)3624 / 313708
email: info@mkt-gmbh.com

Specialist contact: Mr. Heiko Ilg Phone: +49(0)3624/3692-708
h.ilg@mkt-gmbh.com

1.4. Emergency number

Emergency advice: Phone: +49(0)3624 / 36923 (Mon-Fri 8am to 4pm)

Chapter 2: Possible risks

2.1. Classification of the substance or mixture:

None

This product is pursuant to the criteria of the CLP regulation (EG) No. 1272/2008 and the directives 67/548/EEC and 1999/45/EEC respectively classified as non-hazardous.

2.2. Identification elements:

None

2.3. Other risks:

See section 7.1

Chapter 3: Composition/Information on components

3.1. Substances:

Not applicable. This product is defined in terms of the REACH regulation (EG) 1908/2006 as an article.

3.2. Mixtures:

Not applicable. This product is defined in terms of the REACH regulation (EG) 1908/2006 as an article.

Chemical characteristics: Extruded PP profile (PP=Polypropylene) CAS No. 9003-07-0

Hazardous ingredients: not subject to declaration

Safety Data Sheet

According to Regulation (EG) 1907/2006 (REACH)



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ALPHA-TAPE® PP edge banding

Chapter 4: First-aid measures

4.1. Description of first-aid measures

After inhalation:	No particular measures required After inhaling decomposition products: Rest, fresh air, medical aid
After skin contact:	No particular measures required After contact with molten material cool rapidly under cold water
After swallowing:	See a doctor (possible mechanical blocking in gastrointestinal tract)
After eye contact:	No particular measures required After eye contact with chipping products (dust) flush eyes with plenty of water and consult a doctor

4.2. Most important symptoms and effects, both acute and delayed:

None identified.

4.3. Indication of any medical attention and special treatment:

None

Chapter 5: Fire-fighting measures

5.1. Extinguishing media

Suitable extinguishing media: water, dry chemical powder, carbon dioxide, foam

Unsuitable extinguishing media for safety reasons: None

5.2. Special hazards arising from the substance or mixture

May be released in case of fire:	Carbon dioxide (CO ₂) and water
Furthermore, in small quantities may occur:	Carbon monoxide, monomers and other flammable gases or vapors

5.3. Instructions for firefighting

Special protective equipment:	In case of fire wear self-contained breathing equipment
Particular risks caused by fire and explosion:	Mechanical crushing and pneumatic conveying of chipped products may form combustible dust. Accumulation of dust and electrostatic charging shall be avoided.
Additional information:	Dispose of fire residues and contaminated extinguishing water in accordance with local regulations

Safety Data Sheet

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ALPHA-TAPE® PP edge banding

Chapter 6: Accidental release measures

6.1. Personal precautions, protective equipment and emergency procedures

No measures necessary beyond the scope of general hygiene regulations at work.

6.2. Measures for environmental protection

No measures necessary beyond the scope of general regulations for environmental protection.

6.3. Methods and material for containment and cleaning up

Measures for cleaning up/taking up: Take up mechanically

6.4. Reference to other chapters

Observe general protective measures in chapter nos. 7, 8 and 13.

Chapter 7: Handling and storage

7.1. Precautions for safe handling

Handling:

In crushing (chipping) observe regulations for dust explosion hazards. Accumulation of dust and electrostatic charge to be avoided.

In extreme overheating the material gaseous decomposition products may be released (cf. Chapter 5 Fire-fighting measures).

Protecting against cuts is recommended

7.2. Conditions for safe storage, including any incompatibilities

Storage:

Store cool and dry; protect against direct sunlight
Avoid extreme heat and ignition sources (sparks, open flames)

7.3. Specific end uses

For more detailed information, please, refer to our technical data sheet.

Chapter 8: Limitation and monitoring of exposure/Personal protective equipment

8.1. Control parameters

None

8.2. Limitation and monitoring of exposure

Personal protective equipment:

Respiratory protection:

In the case of respirable dust: use filter P1 (for solid particles)

Eye protection:

In shredding processes wear protective goggles

General:

Develop good personal hygiene. Do not eat or leave food in working areas.

Hand protection:

Protective gloves according to national regulations

Safety Data Sheet

According to Regulation (EG) 1907/2006 (REACH)



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ALPHA-TAPE® PP edge banding

Chapter 9: Physical and chemical properties

9.1. Information on basic physical and chemical properties

Form:	Profile
Color:	Different according to coloration
Smell:	Odorless
Softening temperature:	> 88°C (ISO306)
Ignition temperature:	No data available
Density:	0.9 to 1.2 g/cm ³ (depending on coloration)
Water solubility:	In practice insoluble
Solubility in other solvents:	Soluble in polar solvents

Other physical and chemical data, e.g. pH-value, boiling point, flashpoint and vapor pressure have not been determined, as they are irrelevant for the product.

9.2. Other information

For more information, please, refer to our technical data sheet.

Chapter 10: Stability and reactivity

10.1. Reactivity:

The product is under usual conditions inert.

10.2. Chemical stability:

The product is chemically stable.

10.3. Possibility of hazardous reactions:

When used according to instructions, hazardous reactions are not to be expected.

10.4. Conditions to avoid:

To avoid thermal decomposition do not overheat.
Decomposition occurs at temperatures above 300°C.

10.5. Incompatible materials:

Strong oxidizing agents

10.6. Hazardous decomposition products:

See 5.2.

Chapter 11: Toxicological information

11.1. Information on toxicological effects:

No data available.

When appropriately used and handled according to instructions as per our experience and information the product does not cause any harmful effects on health.

Safety Data Sheet

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Chapter 12: Environmental information

12.1. Toxicity:

No data available.

In view of its consistency and insolubility of the product in water bioavailability is unlikely.

12.2. Persistence and degradability:

No data available.

12.3. Bioaccumulation potential:

No data available.

In view of its consistency and insolubility of the product in water bioavailability is unlikely.

12.4. Mobility in soil:

No data available.

12.5. Results of PBT and vPvB assessment:

According to the available data criteria for PBT and vPvB assessment respectively are not fulfilled.

12.6. Other adverse effects:

No data available.

Chapter 13: Instructions on disposal

13.1 Waste treatment methods:

Must be disposed of according to local regulation e.g. on a suitable dump or incineration plant.
Non-contaminated material can be recycled.

Waste code: 07 02 13 Plastic waste

Chapter 14: Transport information

14.1. UN number

Not classified as dangerous goods according to transport regulations.

14.2. UN proper shipping name

Not classified as dangerous goods according to transport regulations.

14.3. Transport hazard class

Not classified as dangerous goods according to transport regulations.

14.4. Packing group

Not classified as dangerous goods according to transport regulations.

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14.5. Environmental hazards

Not classified as dangerous goods according to transport regulations.

14.6. Special precautions for user

See chapters 6 to 8.

14.7. Transport in bulk according to Annex II of MARPOL 73/78 and IBC Code:

Not applicable.

Chapter 15: Legislation

15.1. Safety, health and environmental regulations/legislation specific for the substance or mixture:

No applicable EU regulations.

National regulations:

Water hazard class:

Not hazardous to water

(Germany, self-classification)

15.2. Chemical safety assessment:

The product has not been examined in a safety assessment.

Chapter 16: Other information

Amendments to the last version:

Adaptation to regulation (EU) No. 453/2010 in all chapters

The aforementioned information in this safety data sheet is based upon information of our raw materials suppliers and our knowledge and experience to date. The safety data sheet describes the product with regards to safety requirements. The information is in no way to be considered as description of the quality of the merchandise (product specification). It does not represent any assurance of characteristics. Existing laws and regulations as well as possible property rights must be observed by the recipient and user of our products on its own responsibility.

End of the safety data sheet.

Safety Data Sheet

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ALPHA-TAPE® ZERO PP edge banding

Chapter 1: Identification of the substance/mixture and of the company

1.1. Product identifier

Product name: **ALPHA-TAPE® ZERO PP edge banding**

1.2. Relevant identified uses of the substance or mixture and uses advised against: None known

Application: Thermo-plastic edge banding for the furniture industry

1.3. Details of the supplier of the safety data sheet

Company: MKT Moderne Kunststoff-Technik
Gebrüder Eschbach GmbH
Herrenhöfer Landstraße 2
D-99885 Ohrdruf
Phone: +49(0)3624 / 36923
Fax: +49(0)3624 / 313708
email: info@mkt-gmbh.com

Specialist contact: Mr. Heiko Ilg Phone: +49(0)3624/3692-708
h.ilg@mkt-gmbh.com

1.4. Emergency number

Emergency advice: Phone: +49(0)3624 / 36923 (Mon-Fri 8am to 4pm)

Chapter 2: Possible risks

2.1. Classification of the substance or mixture:

None

This product is pursuant to the criteria of the CLP regulation (EG) No. 1272/2008 and the directives 67/548/EEC and 1999/45/EEC respectively classified as non-hazardous.

2.2. Identification elements:

None

2.3. Other risks:

See section 7.1

Chapter 3: Composition/Information on components

3.1. Substances:

Not applicable. This product is defined in terms of the REACH regulation (EG) 1908/2006 as an article.

3.2. Mixtures:

Not applicable. This product is defined in terms of the REACH regulation (EG) 1908/2006 as an article.

Chemical characteristics: Extruded PP profile (PP=Polypropylene) CAS No. 9003-07-0

Hazardous ingredients: not subject to declaration

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Chapter 4: First-aid measures

4.1. Description of first-aid measures

After inhalation:	No particular measures required After inhaling decomposition products: Rest, fresh air, medical aid
After skin contact:	No particular measures required After contact with molten material cool rapidly under cold water
After swallowing:	See a doctor (possible mechanical blocking in gastrointestinal tract)
After eye contact:	No particular measures required After eye contact with chipping products (dust) flush eyes with plenty of water and consult a doctor

4.2. Most important symptoms and effects, both acute and delayed:

None identified.

4.3. Indication of any medical attention and special treatment:

None

Chapter 5: Fire-fighting measures

5.1. Extinguishing media

Suitable extinguishing media: water, dry chemical powder, carbon dioxide, foam

Unsuitable extinguishing media for safety reasons: None

5.2. Special hazards arising from the substance or mixture

May be released in case of fire: Carbon dioxide (CO₂) and water

Furthermore, in small quantities may occur: Carbon monoxide, monomers and other flammable gases or vapors

5.3. Instructions for firefighting

Special protective equipment: In case of fire wear self-contained breathing equipment

Particular risks caused by fire and explosion: Mechanical crushing and pneumatic conveying of chipped products may form combustible dust. Accumulation of dust and electrostatic charging shall be avoided.

Additional information: Dispose of fire residues and contaminated extinguishing water in accordance with local regulations

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Chapter 6: Accidental release measures

- 6.1. Personal precautions, protective equipment and emergency procedures
No measures necessary beyond the scope of general hygiene regulations at work.
- 6.2. Measures for environmental protection
No measures necessary beyond the scope of general regulations for environmental protection.
- 6.3. Methods and material for containment and cleaning up
Measures for cleaning up/taking up: Take up mechanically
- 6.4. Reference to other chapters
Observe general protective measures in chapter nos. 7, 8 and 13.

Chapter 7: Handling and storage

- 7.1. Precautions for safe handling
Handling: In crushing (chipping) observe regulations for dust explosion hazards. Accumulation of dust and electrostatic charge to be avoided.

In extreme overheating the material gaseous decomposition products may be released (cf. Chapter 5 Fire-fighting measures).
Protecting against cuts is recommended
- 7.2. Conditions for safe storage, including any incompatibilities
Storage: Store cool and dry; protect against direct sunlight
Avoid extreme heat and ignition sources (sparks, open flames)
- 7.3. Specific end uses
For more detailed information, please, refer to our technical data sheet.

Chapter 8: Limitation and monitoring of exposure/Personal protective equipment

- 8.1. Control parameters
None
- 8.2. Limitation and monitoring of exposure
Personal protective equipment:
Respiratory protection: In the case of respirable dust: use filter P1 (for solid particles)

Eye protection: In shredding processes wear protective goggles
General: Develop good personal hygiene. Do not eat or leave food in working areas.

Hand protection: Protective gloves according to national regulations

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Chapter 9: Physical and chemical properties

9.1. Information on basic physical and chemical properties

Form:	Profile
Color:	Different according to coloration
Smell:	Odorless
Softening temperature:	> 88°C (ISO306)
Ignition temperature:	No data available
Density:	0.9 to 1.2 g/cm ³ (depending on coloration)
Water solubility:	In practice insoluble
Solubility in other solvents:	Soluble in polar solvents

Other physical and chemical data, e.g. pH-value, boiling point, flashpoint and vapor pressure have not been determined, as they are irrelevant for the product.

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