

Rakoll[®] supermelt Plus

Type of Product Unfilled edgebanding hot melt adhesive.

Product Characteristics

- long open time
- good tack and high initial strength
- good working and adhesion properties
- can be used at extreme low coat weights

Typical Applications Developed for the bonding of edge materials. It has been thoroughly tested on most application systems on straight edges and soft forming applications.

Suitable substrates Plastic edges (PVC, ABS, PP ...), melamine, HPL, wooden edges, etc. to chipboard or MDF panels.

Typical Properties

Property	Value
Base	Ethylene Vinyl Acetate Copolymer (EVA)
Colour	yellowish, transparent
Viscosity (Brookfield HB, at 204°C)	approx. 54 000 mPa.s
Shelf life	12 months

Application Instructions

Set up the machine in accordance with the manufacturer's instructions.

Recommended working conditions:

- Room, material and adhesive temperature: 18°C – 20°C
- Moisture content of material: 8 – 10%
- Relative humidity: 40 – 60%
- Processing temperature at the applicator roll: 180°C – 200°C
- Feed speed: at least 12 m/min

Edges strips can have very different adhesion properties, even if the base material is the same. For this reason, it is advisable to make trials if the edges are of an unknown type in order to test the suitability of the adhesive. The recommendations given by the edge strip manufacturers should be followed.

The heat resistance of this product is adequate for all normal requirements for home, used in cold, moderate, dry warm and humid climates.

Heat resistance measured using the method in a test involving increasing temperatures and using 3 melamine edges, 1 PVC edge, 1 veneer edge and 2 extruded PVC-ABS edges: approx. 100°C.

During long stops the adhesive temperature should be lowered to 160°C to avoid premature degradation of the hot-melt adhesive characteristics.

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Cleaning Instructions	Please contact your local Sales Office for available cleaning solutions.
Typical Packaging	Please contact your local Sales Office for available packaging options.
Storage Conditions	In original sealed packaging in a clean and dry conditions at room temperature.
Disposal Advice	Please refer to the MSDS for disposal instructions.
Safety Advice	At the recommended working temperature, the hot melt will cause burns in contact with skin. Do not inhale fumes that are released at the working temperature. In any case, a suitable exhausting system shall be installed in the working area. For additional information, please refer to the MSDS for safety advices.

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