

## Rakoll® 5728

**Type of Product** PO based hot melt adhesive.

**Product Characteristics**

- good spreading properties
- high initial strength
- high heat resistance
- good thermal stability

**Typical Applications** Used on edge banders with edges of ABS, PVC, melamine and veneer.

**Suitable substrates** Chipboard and MDF panels and plastic edges (ABS, PVC, PP), melamine and veneer edges.

### Typical Properties

Property	Value
Softening point (R&B)	approx. 127°C
Viscosity (Brookfield HB; at 204°C)	approx. 50 000 mPa.s
Shelf life	12 months

**Application Instructions**      The machine should be adjusted according to the recommendations of the machine manufacturers.

Good results can be obtained with the following conditions:

- Room and material temperature: 18°C – 20°C
- Temperature at the applicator roll: 190°C – 210°C
- Glue spread: 150 – 220 g/m<sup>2</sup>
- Feed speed: at least 20 m/min
- Relative humidity: 40 – 60%

Considering the sort of materials and the differences stated on the adhesion properties, it is advisable to make preliminary trials, so that the good working conditions can be determined.

Materials should be free from dust and grease. The material and the operation conditions can influence significantly the bonding results.

**Cleaning Instructions**      This product presents very good thermal stability. However, when necessary, all residual encrustations of adhesive must be completely cleaned from the tank with a spatula, as they conduct heat poorly and cause a lowering of the adhesive temperature.

**Typical Packaging**      Please contact your local Sales Office for available packaging options.

**Storage Conditions**      In original sealed packaging, under clean and dry conditions at room temperature.

**Disposal Advice**      Please refer to the MSDS for disposal instructions.

**Safety Advice**      Please refer to the MSDS for safety advice.

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